

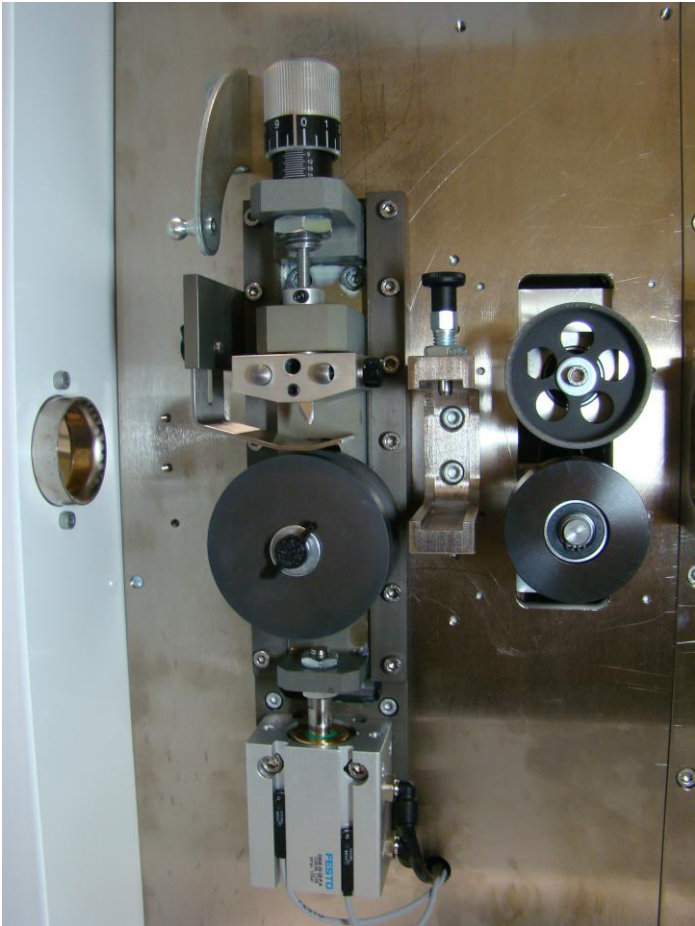
CS327 CS370 Slitter tooling

REV 27 07/09/2021

Contents

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.

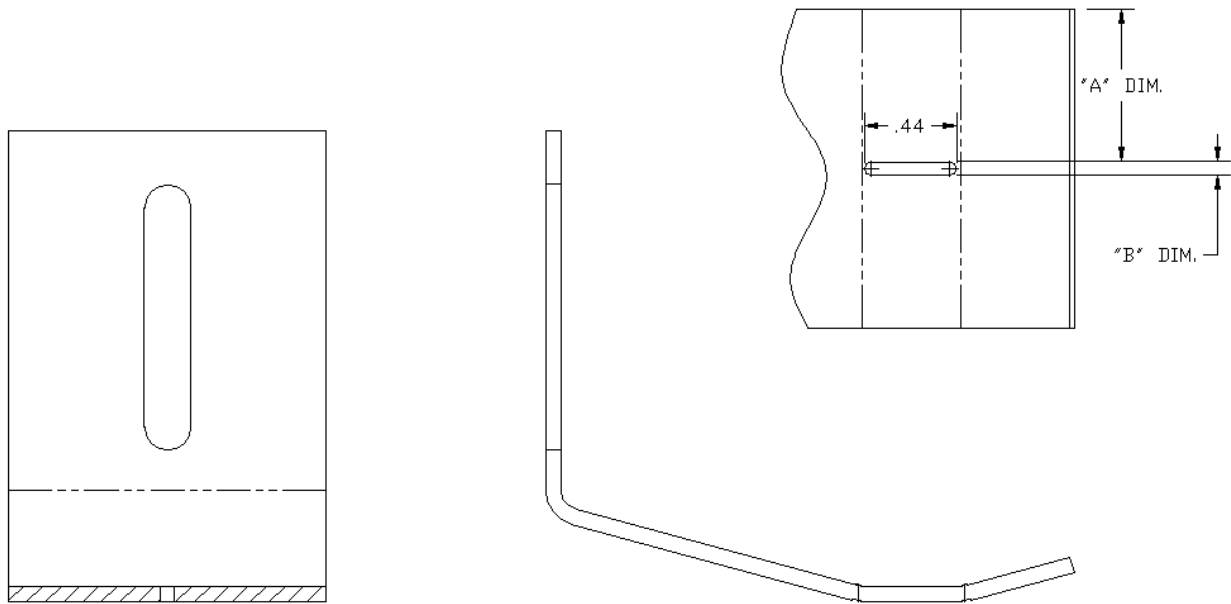
$$"A" = 19.1 - C -.762$$

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

If using English units of measure.

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

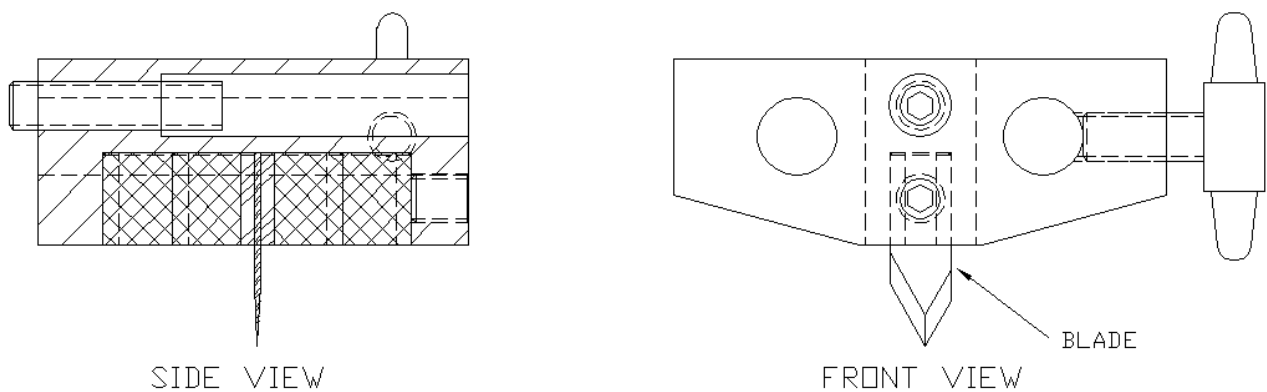
$$"B" = .062 + 2(C)$$



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
-3	0.39	9.91	0.72	18.29

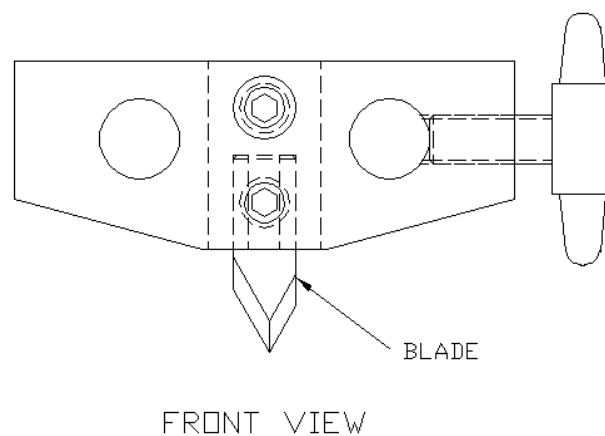
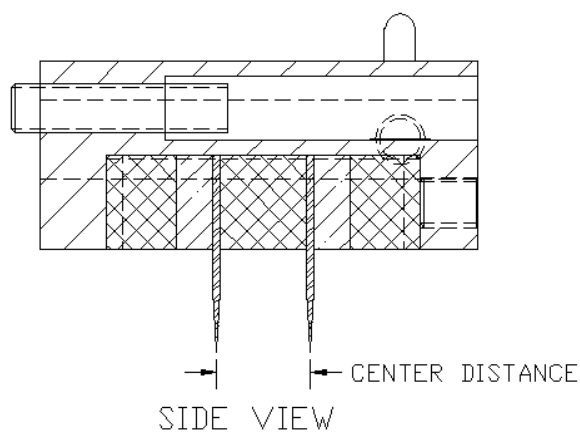
Blade assembly



5-142971 Blade assembly for single slitting blade

H-22896 Replacement blade

H-22896TC Replacement blade, Titanium Nitride coated.

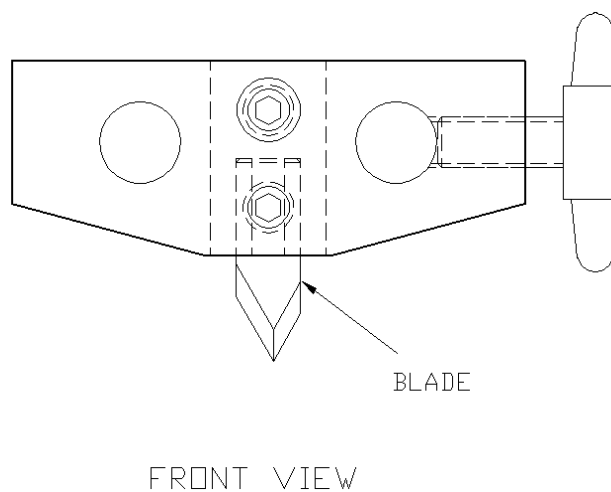
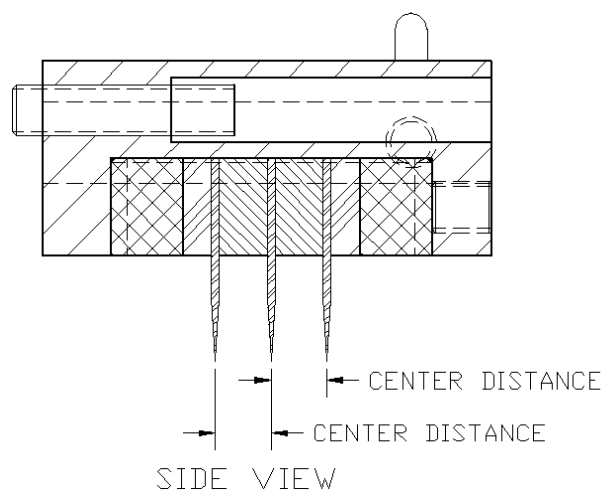


5-142972-XX Blade assembly for double slitting blade

H-22896 Replacement blade

H-22896TC Replacement blade, Titanium Nitrite coated.

Dash number	Center Distance inch	Center distance mm
-1	0.156	3.96
-2	0.620	15.75



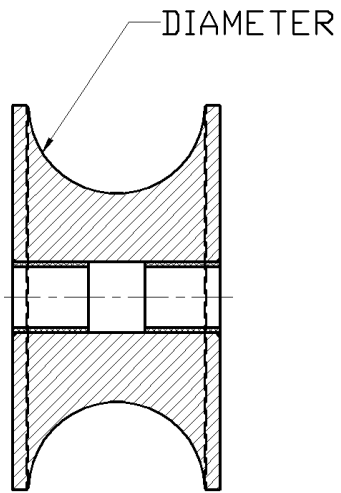
5-142973-XX Blade assembly for triple slitting blade

H-22896 Replacement blade

H-22896TC Replacement blade, Titanium Nitrite coated.

Dash Number	Center Distance inch	Center distance mm

Wire guide wheel assembly

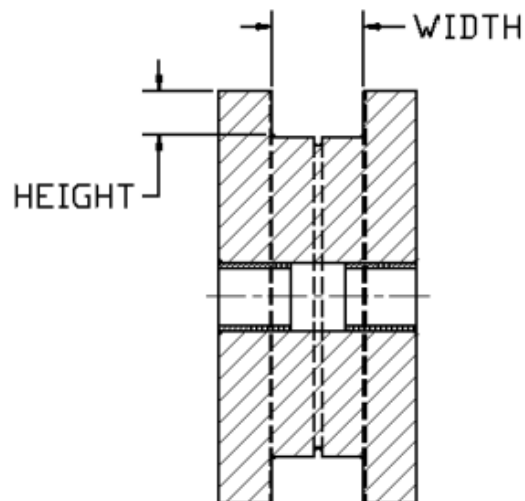


5-142964-XX Wheel assembly for single conductor wire.

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
-49	0.254	6.45
-21	0.262	6.65
-39	0.272	6.91
-53	0.300	7.62
-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
-51	0.414	10.52
-41	0.420	10.67
-37	0.429	10.90
-31	0.434	11.02
-52	0.440	11.20
-24	0.448	11.38
-57	0.452	11.48
-8	0.468	11.88

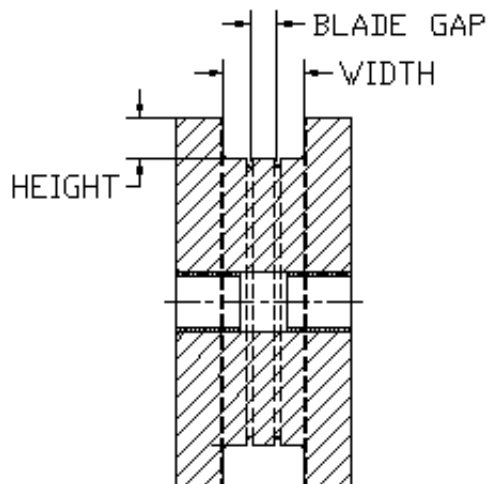
-26	0.478	12.14
-38	0.490	12.45
-25	0.508	12.90
-48	0.526	13.36
-7	0.534	13.56
-12	0.568	14.43
-58	0.574	14.58
-34	0.582	14.78
-6	0.612	15.54
-59	0.622	15.80
-19	0.634	16.10
-27	0.644	16.36
-32	0.656	16.66
-5	0.668	16.97
-14	0.718	18.24
-4	0.736	18.69
-15	0.758	19.25
-10	0.788	20.02
-35	0.814	20.68
-16	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
-54	1.220	31.00
-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 0.010 less than the wire size.

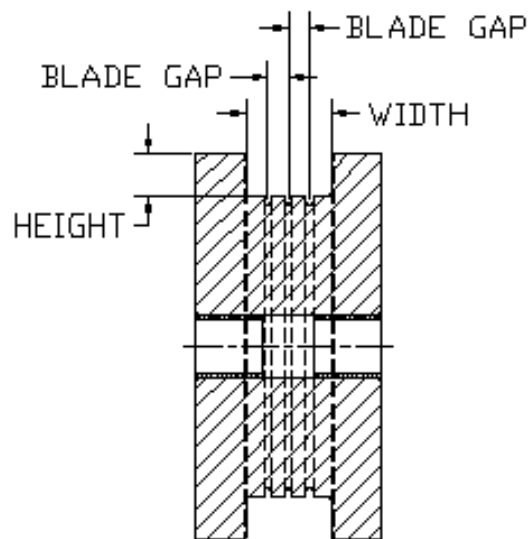
Item Number	Width inches	Width mm	Height inches	Height mm
-21	0.227	5.77	0.090	2.29
-20	0.246	6.25	0.110	2.79
-19	0.299	7.59	0.126	3.20
-18	0.329	8.36	0.139	3.53
-10	0.403	10.24	0.170	4.32
-9	0.528	13.41	0.220	5.59
-8	0.648	16.46	0.305	7.75
-2	0.698	17.73	0.320	8.13
-4	0.724	18.39	0.320	8.13
-12	0.728	18.49	0.310	7.87
-13	0.783	19.89	0.330	8.38
-1	0.788	20.02	0.365	9.27
-17	0.808	20.52	0.410	10.41
-16	0.838	21.29	0.410	10.41
-7	0.848	21.54	0.390	9.91
-5	0.908	23.06	0.405	10.29
-14	0.918	23.32	0.390	9.91
-6	0.948	24.08	0.415	10.54
-3	1.000	25.40	0.470	11.94
-15	1.113	28.27	0.480	12.19
-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 0.010 less than the wire size.

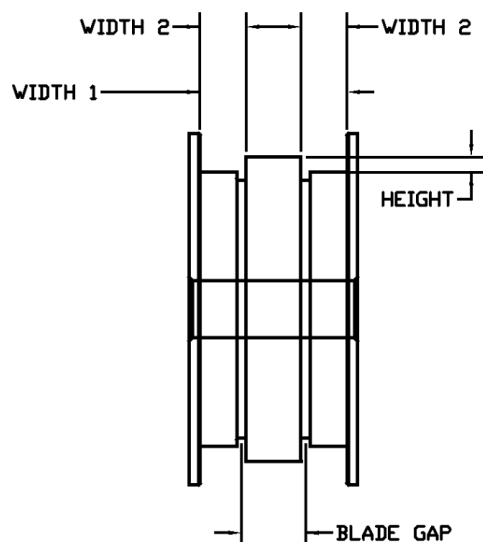
Item Number	Width inches	Width mm	Blade Gap inch	Blade Gap mm	Height inches	Height mm
-2	0.604	15.34	0.156	3.96	0.294	7.47
-1	0.642	16.31	0.156	3.96	0.292	7.16



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 0.010 less than the wire size.

Item Number	Width inches	Width mm	Blade Gap inch	Blade Gap mm	Height inches	Height mm



5-148671-XX Wheel assembly for dog bone 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 0.010 less than the wire size.

Item Number	Width 1 inches	Width 1 mm	Blade Gap inch	Blade Gap mm	Height inches	Height mm	Width 2 inches	Width 2 mm
-	1.42	35.81	.620	15.75	0.148	3.76	0.445	11.30