



SETTING REFERENCE SHEET FOR TANGLESS COILING

CTL-01 THEORETICAL VALUES

SIZE NUMBER	INSERT SIZE	MAX LENGTH	FEED HEIGHT (mm)	WIRE GUIDES POSITION (mm)
01	M2.5 x 0.45	3D	11.28	4.5
02	M3 x 0.5	3D	11.51	4.5
03	M4 x 0.7	3D	11.98	5.5
04	M5 x 0.8	2.5D	12.47	6.0
05	M6 x 1	2D	12.94	6.5
09	2-56	3D	11.10	3.5
10	4-40	3D	11.42	4.5
11	6-32	3D	11.78	5.5
12	8-32	3D	12.09	5.5
13	10-32	2.5D	12.39	5.5
14	10-24	2.5D	12.41	6.5

CTL-02 THEORETICAL VALUES

SIZE NUMBER	INSERT SIZE	MAX LENGTH	FEED HEIGHT (mm)	WIRE GUIDES POSITION (mm)
05	M6 x 1	3D	8.94	7.0
06	M8 x 1.25	3D	9.86	8.0
07	M10 x 1.5	3D	10.72	11.0
08	M12 x 1.75	3D	11.63	12.0
14	10-24	3D	8.41	7.0
15	1/4-28	3D	9.08	9.0
16	1/4-20	3D	9.14	10.0
17	5/16-24	3D	9.79	10.0
18	5/16-18	3D	N/A	10.0
19	3/8-24	3D	10.43	11.0
20	3/8-16	3D	N/A	12.0
61	M14 x 1.5	2.5D	12.38	14.0

NOTE:

1. Feed height taken between feed assembly plate and adjuster block.
2. Wire guide position taken from centre of arbor pin to exit face of wire guides.