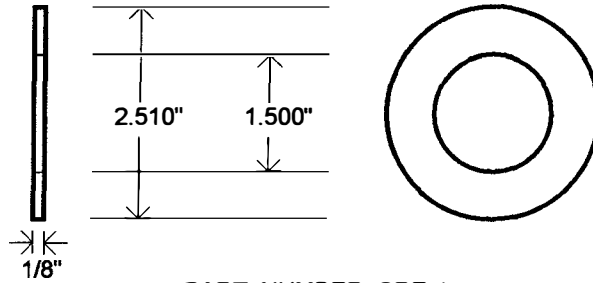


# STANDARD STEEL FLAT RINGS

## BACK UP RINGS

The function of this BACK UP RING is to guide the wire and to keep the coil from backing up on the SPINDLE when using STANDARD STEEL FLAT WORK RINGS to coil. The outside corners are honed to prevent the wire from being shaved and to form a feed groove for the first turn of wire. All Steel Flat Work Ring sizes are set from this Ring diameter.



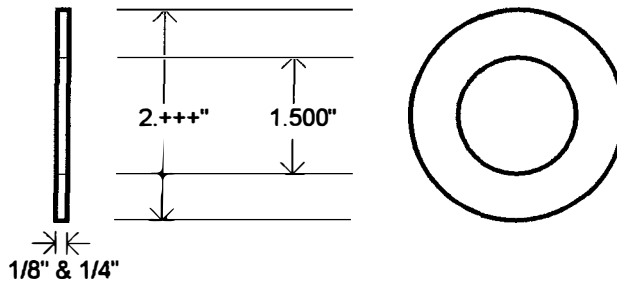
PART NUMBER CRE-1

## STEEL FLAT WORK RINGS

This is the most common Ring used in coiling.

This Ring is used for close coiling and must be used with the CRE-1 BACK UP RING.

For wire gages 13 through 20 the width of the Ring is .250".



PART NUMBER CRE-2

### CRE-2 1/4" FACE

- 2.422" O.D. 13-14 GA.
- 2.430" O.D. 15-16 GA.
- 2.446" O.D. 17-18 GA.
- 2.460" O.D. 19-20 GA.

### CRE-2 1/8" FACE

- 2.470" O.D. 21-22 GA.
- 2.478" O.D. 23-24 GA.
- 2.484" O.D. 25-26 GA.
- 2.490" O.D. 27-28 GA.
- 2.496" O.D. 29-30 GA.

## WIRE GAGE and RECOMMENDED COILING RINGS TO USE

<u>WIRE GAGE</u>	<u>DECIMAL</u>	<u>MILLIMETER</u>	<u>USE RINGS</u>		
13	.072	1.8278	2.422 OD	THESE ARE ALL 1/4" FACE " " " "	
14	.064	1.6277	2.422 "		
15	.057	1.449	2.430 "		
16	.051	1.2908	2.430 "		
17	.045	1.1495	2.446 "		
18	.040	1.1023	2.446 "		
19	.035	.9116	2.460 "		
20	.032	.8118	2.460 "		
21	.028	.7229	2.470 OD		THESE ARE ALL 1/8" FACE " " " " " "
22	.025	.6438	2.470 "		
23	.023	.5733	2.478 "		
24	.022	.5105	2.478 "		
25	.0179	.4546	2.484 "		
26	.0159	.4049	2.484 "		
27	.0141	.3605	2.490 "		
28	.0126	.3210	2.490 "		
29	.0112	.2859	2.496 "		
30	.0100	.2546	2.496 "		