

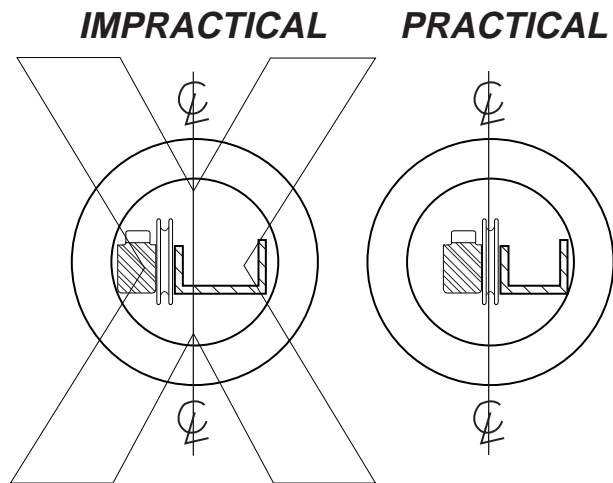
# Universal's 18 Inch Diameter Gear Head Standard Series

UNIVERSAL		MAGAZINE WIRE CAPACITY					18U STANDARD SERIES			
WIRE RANGE	STANDARD SERIES - MAGAZINE WIDTH (inches and mm)									
AWG mm	FEET METERS	3/8" 9.52mm	1/2" 12.70mm	5/8" 15.88mm	3/4" 19.05mm	7/8" 22.22mm	1" 25.40mm	1-1/4" 31.75mm	1-1/2" 38.10mm	2" 50.80mm
#5 4.732	FEET METERS	43 13.1	55 16.8	73 22.3	86 26.2	103 31.4	116 35.4	146 44.5	176 53.6	343 104.5
#6 4.221	FEET METERS	51 15.5	73 22.3	90 27.4	111 33.8	129 39.3	150 45.7	189 57.6	227 69.2	439 133.8
#7 3.665	FEET METERS	68 20.7	90 27.4	116 35.4	141 43.0	163 49.7	189 57.6	236 71.9	283 86.3	546 166.4
#8 3.624	FEET METERS	86 26.2	116 35.4	146 44.5	176 53.6	206 62.8	236 71.9	296 90.2	356 108.5	687 209.3
#9 2.906	FEET METERS	107 32.6	146 44.5	184 56.1	223 68.0	262 79.9	296 90.2	374 114.0	451 137.5	862 262.7
#10 2.588	FEET METERS	137 41.8	184 56.1	232 70.7	283 86.3	331 100.9	378 115.2	473 144.2	567 172.8	1086 331.0
#11 2.309	FEET METERS	172 52.4	236 71.9	292 89.0	352 107.3	412 125.6	473 144.2	589 179.5	709 216.1	1376 419.4
#12 2.058	FEET METERS	219 66.8	296 90.2	369 112.5	447 136.2	520 158.5	597 182.0	743 226.5	894 272.5	1733 528.2
#13 1.829	FEET METERS	279 85.0	369 112.5	464 141.4	563 171.6	649 197.8	748 228.0	933 284.4	1126 343.2	2169 611.1
#14 1.628	FEET METERS	344 104.8	464 141.4	580 176.8	696 212.1	812 247.5	997 303.9	1165 355.1	1397 425.8	2725 830.5
#15 1.490	FEET METERS	434 132.3	584 178.0	731 222.8	881 268.5	1019 310.6	1169 356.3	1466 446.8	1763 537.4	3642 1110.0
#16 1.290	FEET METERS	554 168.9	743 226.3	928 282.9	1118 340.8	1311 399.6	1492 454.8	1866 568.8	2248 685.2	4289 1307.2
#17 1.150	FEET METERS	683 208.2	915 278.9	1143 348.4	1371 417.9	1603 488.6	1831 558.1	2291 698.3	2747 837.3	5165 1574.2
#18 1.028	FEET METERS	851 259.4	1135 345.9	1419 432.2	1702 518.8	1986 605.3	2270 691.9	2842 866.2	3409 1039.1	6414 1954.9
#19 0.911	FEET METERS	1083 330.1	1449 441.7	1818 554.1	2184 665.7	2549 776.9	2915 888.5	3637 1108.6	4368 1331.4	8361 2548.4
#20 0.812	FEET METERS	1363 415.4	1823 555.7	2270 691.9	2730 832.1	3190 972.3	3650 1112.5	4558 1389.3	5478 1669.7	10415 3174.4

The following minimum finished inside diameter/wire capacity charts have been calculated to **GUARANTEE PERFORMANCE**. For years these types of charts have been formatted by drawing a circle around the combined width and depth of the ring gear and magazine. The measurement of this circle's diameter became the minimum finished inside coil diameter that this magazine will fit through. Of course we know that although on paper this looks great, *this is not practical in actual coil production.*

With these new technical charts, **UNIVERSAL** has included two major factors in the calculations.

1. Keeping the wire guide wheel on the center line with the core.
2. Finished coil heights.



**UNIVERSAL** is the only manufacturer of toroidal winding machinery supplying these types of practical charts. Please keep this in mind when comparing minimum finished inside diameters of **UNIVERSAL** magazines to our competitors.