LAKES PRECISION INC.

Your Global Source for Wire Processing Perishable Tooling

ARTOS MACHINE SERIES

THIS SECTION CONTAINS BLADES FOR THE FOLLOWING MACHINE SERIES:

- □ *STANDARD*
- □ *X-STYLE*
- □ *BD-4*
- □ *CS-326*
- □ *CS-326 / 600 AUTO ADJUST*
- □ *CS-327*
- □ *MTX*
- □ *CR-11 / CR-22*
- □ *CS-7*
- □ *AM-1, AM-2, AM-3, AM-015 & AM ALL-ROUND*
- □ *CS-36 & CS-37*
- □ *CS-330*
- □ *CS-336 & CS-337*

Your Global Source for Wire Processing Perishable Tooling

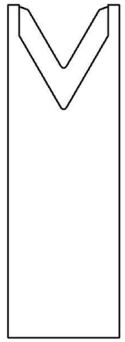
TANGENT RADIUS "V" STRIP BLADES

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.

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

- TC Coating Available -



86777- XX

WIRE GUAGE	ITEM NUMBER	DESCRIPTION
28/30/32	86777-21	V-012S TA-V
28/30/32	86777-22	V-012L TA-V
24/26/28	86777-19	V-022S TA-V
24/26/28	86777-20	V-022L TA-V
22	86777-1	V-034S TA-V
22	86777-2	V-034L TA-V
20	86777-3	V-042S TA-V
20	86777-4	V-042L TA-V
18	86777-5	V-052S TA-V
18	86777-6	V-052L TA-V
16	86777-7	V-062S TA-V

WIRE GUAGE	ITEM NUMBER	DESCRIPTION
16	86777-8	V-062L TA-V
14	86777-9	V-076S TA-V
14	86777-10	V-076L TA-V
12	86777-11	V-096S TA-V
12	86777-12	V-096L TA-V
10	86777-13	V-112S TA-V
10	86777-14	V-112L TA-V
6/8	86777-15	V-172S TA-V
6/8	86777-16	V-172L TA-V
4	86777-17	V-222S TA-V
4	86777-18	V-222L TA-V

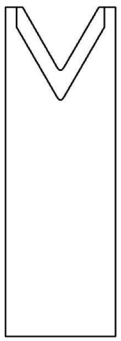
TANGENT RADIUS "V" STRIP BLADES

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.

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

- TC Coating Available -



122107-XX

WIRE GUAGE	ITEM NUMBER	DESCRIPTION
28/30/32	122107-21	V-012S TA-V
28/30/32	122107-22	V-012L TA-V
24/26/28	122107-19	V-022S TA-V
24/26/28	122107-20	V-022L TA-V
22	122107-1	V-034S TA-V
22	122107-2	V-034L TA-V
20	122107-3	V-042S TA-V
20	122107-4	V-042L TA-V
18	122107-5	V-052S TA-V
18	122107-6	V-052L TA-V
16	122107-7	V-062S TA-V

WIRE GUAGE	ITEM NUMBER	DESCRIPTION
16	122107-8	V-62L TA-V
14	122107-9	V-076S TA-V
14	122107-10	V-076L TA-V
12	122107-11	V-096S TA-V
12	122107-12	V-096L TA-V
10	122107-13	V-112S TA-V
10	122107-14	V-112L TA-V
6/8	122107-15	V-172S TA-V
6/8	122107-16	V-172L TA-V
4	122107-17	V222A TA-V
4	122107-18	V-222L TA-V

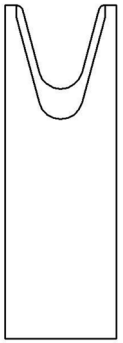
TANGENT RADIUS "V" STRIP BLADES

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.

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

- TC Coating Available -



122117- XX

ITEM NUMBER	DESCRIPTION
122117-5	V-134S TA-V
122117-6	V-134L TA-V
122117-7	V-134A TA-V
122117-8	V-156S TA-V
122117-9	V-156L TA-V
122117-10	V-250S TA-V

ITEM NUMBER	DESCRIPTION
122117-1	V-250A TA-V
122117-2	V-250L TA-V
122117-3	V-312A TA-V
122117-4	V-312L TA-V
122117-13	V350A TA-V
122117-14	V350L TA-V

LAKES PRECISION INC.

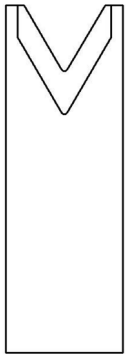
THIN TYPE TANGENT RADIUS "V" STRIP BLADES

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.

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

- TC Coating Available -



122038- XX

WIRE GUAGE	ITEM NUMBER	THICKNESS	DESCRIPTION
28/30/32	122038-21	.031	V-012FS TA-V
28/30/32	122038-22	.031	V-012FL TA-V
24/26/28	122038-19	.031	V-022FS TA-V
24/26/28	122038-20	.031	V-022FL TA-V
22	122038-1	.031	V-034FS TA-V
22	122038-2	.031	V-034FL TA-V
20	122038-3	.031	V-042FS TA-V
20	122038-4	.031	V-042FL TA-V
18	122038-5	.031	V-052FS TA-V
18	122038-6	.031	V-052FL TA-V
16	122038-7	.031	V-062FS TA-V

WIRE GUAGE	ITEM NUMBER	THICKNESS	DESCRIPTION
16	122038-8	.031	V-062FL TA-V
14	122038-9	.031	V-076FS TA-V
14	122038-10	.031	V-076FL TA-V
12	122038-11	.031	V-096FS TA-V
12	122038-12	.031	V-096FL TA-V
10	122038-13	.031	V-112FS TA-V
10	122038-14	.031	V-112FL TA-V
6/8	122038-15	.031	V-172FS TA-V
6/8	122038-16	.031	V-172FL TA-V
4	122038-17	.031	V-222FS TA-V
4	122038-18	.031	V-222FL TA-V

TANGENT RADIUS “V” STRIP BLADES

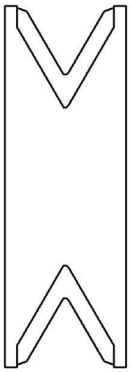
The sharp edge is ground to an arc whose radius approximates awg wire size. The entry angle lines meet the arc at a tangent point. This type of blade, when closed, presents a diamond shaped edge profile.

Advantages: By adjusting cutter head shut height, (if insulation material and wall thickness allow), you can process adjacent wire extrusions.

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

S = SHORT / THICK & L = LONG / THIN

- TC Coating Available -



120457-XX

WIRE GUAGE	ITEM NUMBER	DESCRIPTION
28/30/32	120457-21	V-012S TA-V
28/30/32	120457-22	V-012L TA-V
24/26/28	120457-19	V-022S TA-V
24/26/28	120457-20	V-022L TA-V
22	120457-1	V-034S TA-V
22	120457-2	V-034L TA-V
20	120457-3	V-042S TA-V
20	120457-4	V-042L TA-V
18	120457-5	V-052S TA-V
18	120457-6	V-052L TA-V
16	120457-7	V-062S TA-V

WIRE GUAGE	ITEM NUMBER	DESCRIPTION
16	120457-8	V-062L TA-V
14	120457-6	V-076S TA-V
14	120457-10	V-076L TA-V
12	120457-11	V-096S TA-V
12	120457-12	V-096L TA-V
10	120457-13	V-112S TA-V
10	120457-14	V-112L TA-V
6/8	120457-*15	V-175A TA-V
6/8	120457-16	V-175L TA-V
4	120457-17	V-222A TA-V
4	120457-18	V-222L TA-V

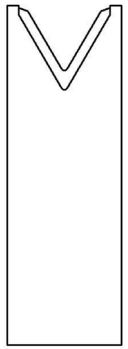
TANGENT RADIUS "V" STRIP BLADES

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.

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

- TC Coating Available -



122350-XX

WIRE GUAGE	ITEM NUMBER	DESCRIPTION
16/18	122350-1	V-062S TA-V
16/18	122350-2	V-062L TA-V
14	122350-3	V-076S TA-V
14	122350-4	V-076L TA-V
10	122350-5	V-112S TA-V
10	122350-6	V-112L TA-V
6/8	122350-7	V-172S TA-V

WIRE GUAGE	TEM NUMBER	DESCRIPTION
6/8	122350-8	V-172A TA-V
6/8	122350-9	V-172L TA-V
4	122350-10	V-222S TA-V
4	122350-11	V-222A TA-V
4	122350-12	V222L TA-V
2	122350-13	V-250A TA-V
2	122350-14	V-250L TA-V

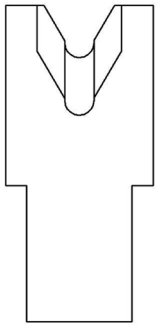
TRU-RADIUS STRIP BLADE

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.

- TC Coating Available -



123339-X

DIA SIZE	ITEM NUMBER	DESCRIPTION
.039	123339-1	V-039S TR-V
.039	123339-2	V-039L TR-V
.043	123339-3	V-043S TR-V
.043	123339-4	V-043L TR-V
.047	123339-5	V-047S TR-V
.047	123339-6	V-047L TR-V
.055	123339-7	V-055S TR-V
.055	123339-8	V-055L TR-V
.067	123339-9	V-067S TR-V
.067	123339-10	V-067L TR-V
.072	123339-11	V-072S TR-V
.072	123339-12	V-072L TR-V
.078	123339-13	V-078S TR-V
.078	123339-14	V-078L TR-V
.088	123339-15	V-088S TR-V
.088	123339-16	V-088L TR-V
.090	123339-17	V-090S TR-V

DIA SIZE	ITEM NUMBER	DESCRIPTION
.090	123339-18	V-090L TR-V
.095	123339-47	V-095S TR-V
.095	123339-48	V-095L TR-V
.102	123339-19	V-102S TR-V
.102	123339-20	V-102L TR-V
.112	123339-21	V-112S TR-V
.112	123339-22	V-112L TR-V
.120	123339-23	V-0120S TR-V
.120	123339-24	V-120L TR-V
.125	123339-25	V-125S TR-V
.125	123339-26	V-125L TR-V
.140	123339-27	V-140S TR-V
.140	123339-28	V-140L TR-V
.155	123339-49	V-155S TR-V
.155	123339-50	V-155L TR-V
.160	123339-29	V-160S TR-V
.160	123339-30	V-160L TR-V

DIA SIZE	ITEM NUMBER	DESCRIPTION
.170	123339-31	V-170S TR-V
.170	123339-32	V-170L TR-V
.175	123339-33	V-175S TR-V
.175	123339-34	V-175L TR-V
.185	123339-35	V-185S TR-V
.185	123339-36	V-185L TR-V
.190	123339-37	V-190S TR-V
.190	123339-38	V-190L TR-V
.200	123339-39	V-200S TR-V
.200	123339-40	V-200L TR-V
.205	123339-41	V-205S TR-V
.205	123339-42	V-205L TR-V
.220	123339-43	V-220S TR-V
.220	123339-44	V-220L TR-V
.270	123339-45	V-270S TR-V
.270	123339-46	V-270L TR-V

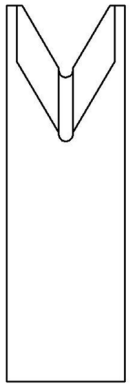
TRU-RADIUS STRIP BLADE

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.

- TC Coating Available -



122122-XX

DIA SIZE	ITEM NUMBER	DESCRIPTION
.022	122122-58	V-022S TR-V
.022	122122-59	V-022L TR-V
.033	122122-56	V-033S TR-V
.033	122122-57	V-033L TR-V
.039	122122-1	V-039S TR-V
.039	122122-13	V-039FS TR-V
.039	122122-2	V-039L TR-V
.047	122122-3	V-047S TR-V
.047	122122-14	V-047FS TR-V
.047	122122-4	V-047L TR-V
.055	122122-5	V-055S TR-V
.055	122122-15	V-055FS TR-V
.055	122122-6	V-055L TR-V
.060	122122-43	V-060S TR-V
.060	122122-44	V-060L TR-V
.067	122122-7	V-067S TR-V
.067	122122-16	V-067FS TR-V
.067	122122-8	V-067L TR-V
.078	122122-9	V-078S TR-V
.078	122122-17	V-078FS TR-V
.078	122122-10	V078L TR-V

DIA SIZE	ITEM NUMBER	DESCRIPTION
.086	122122-54	V-086S TR-V
.086	122122-55	V-086L TR-V
.090	122122-47	V-090S TR-V
.090	122122-48	V-090L TR-V
.096	122122-49	V-096S TR-V
.096	122122-50	V-096L TR-V
.096	122122-53	V-096L TR-V
.102	122122-11	V-102S TR-V
.102	122122-18	V-102FS TR-V
.102	122122-12	V-102L TR-V
.112	122122-19	V-112S TR-V
.112	122122-20	V-112L TR-V
.125	122122-21	V-125S TR-V
.125	122122-22	V-125L TR-V
.132	122122-60	V-132S TR-V
.132	122122-61	V-132L TR-V
.140	122122-23	V-140A TR-V
.140	122122-24	V-140L TR-V
.152	122122-25	V-152A TR-V
.152	122122-26	V-152L TR-V

DIA SIZE	ITEM NUMBER	DESCRIPTION
.160	122122-27	V-160A TR-V
.160	122122-28	V-160L TR-V
.172	122122-51	V-172A TR-V
.172	122122-52	V-172L TR-V
.175	122122-29	V-175A TR-V
.175	122122-30	V-175L TR-V
.180	122122-45	V-180A TR-V
.180	122122-46	V-180L TR-V
.190	122122-31	V-190A TR-V
.190	122122-32	V-190L TR-V
.200	122122-33	V-200S TR-V
.200	122122-34	V-200L TR-V
.210	122122-35	V-210A TR-V
.210	122122-36	V-210L TR-V
.220	122122-37	V-220A TR-V
.220	122122-38	V-220L TR-V
.230	122122-39	V-230A TR-V
.230	122122-40	V-2130L TR-V
.240	122122-41	V-240A TR-V
.240	122122-42	V-240L TR-V

LAKES PRECISION INC.

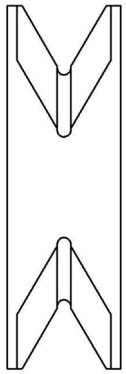
TRU-RADIUS STRIP BLADE

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.

- TC Coating Available -



122410-XX

DIA SIZE	ITEM NUMBER	DESCRIPTION
.039	122410-1	039S TR-V
.039	122410-13	039FS TR-V
.039	122410-2	039L TR-V
.047	122410-3	047S TR-V
.047	122410-14	047FS TR-V
.047	122410-4	047L TR-V
.055	122410-5	055S TR-V
.055	122410-15	055FS TR-V
.055	122410-6	055L TR-V
.067	122410-7	067S TR-V
.067	122410-16	067FS TR-V

DIA SIZE	ITEM NUMBER	DESCRIPTION
.067	122410-8	067L TR-V
.078	122410-9	078S TR-V
.078	122410-17	078FS TR-V
.078	122410-10	078L TR-V
.102	122410-11	102S TR-V
.102	122410-18	102FS TR-V
.102	122410-12	102L TR-V
.125	122410-19	125S TR-V
.125	122410-20	125L TR-V
.152	122410-21	152S TR-V
.152	122410-22	152L TR-V

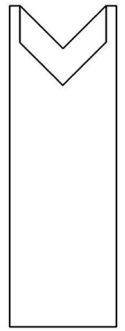
TANGENT ANGLE CUT-OFF BLADES

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

Characteristics: Sharp edges cut by slicing, creating a gradual cut. This produces less deformation of the material being cut. Cutting edges must be able to by-pass each other. This type cut-off is best used with circular shaped wire.

- TC Coating Available -

ITEM NUMBER	DESCRIPTION
C-2681-2	CL CUT-OFF BLADE
C-2681-1	CLA CUT-OFF BLADE
C-2681-10	CLT CUT-OFF BLADE
C-2681-10-D2	CLT-D2 CUT-OFF BLADE
C-2681-8	CLS CUT-OFF BLADE
C-2681-9	DCL CUT-OFF BLADE



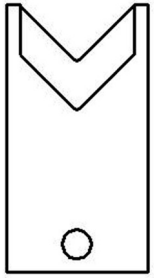
CUT-OFF BLADE

TANGENT ANGLE CUT-OFF BLADES

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

Characteristics: sharp edges cut by slicing, creating a gradual cut. This produces less deformation of the material being cut. Cutting edges must be able to by-pass each other. This type cut-off is best used with circular shaped wire.

- TC Coating Available -



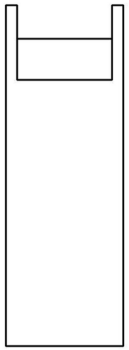
40532
FOR CS-9AT ONLY

COLLINEAR ANGLE CUT-OFF BLADE

Sharp edge is ground to a flat collinear angle.

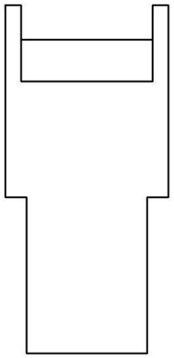
Characteristics: Sharp edges cut by shearing action. This class of blade was designed to allow multiple conductor wire to be processed without deforming the wire. The main advantage of this class is the ability to process many different wire gauges with the same blades.

- TC Coating Available -



C-2670-3

STANDARD
CUT-OFF



C-2670-7

WIDE
CUT-OFF

ITEM NUMBER	DESCRIPTION
C-2670-6	SC CUT-OFF
C-2670-3	SCA CUT-OFF
C-2670-4	SCT CUT-OFF
C-2670-4-D2	SCT CUT-OFF D2
C-2670-5	DSC CUT-OFF
C-2670-7	WSCA CUT-OFF
C-2670-12	WSC CUT-OFF

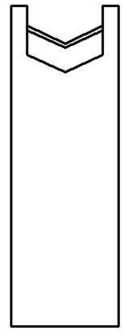
HEAVY DUTY CUT-OFF BLADE

The sharp edge is ground at an angle that results in a "V" opening above 90 degrees. This type of blade, when closed, presents a diamond shaped edge profile.

Characteristics: Sharp edge cut by slicing, creating a gradual cut. The wide angle allows for a wider range of wire sizes to be cut with the same blades. This type of cut-off is best used with circular shaped wire.

- TC Coating Available -

ITEM NUMBER	DESCRIPTION
SK-393	HEAVY DUTY CUT-OFF BLADE



SK-393

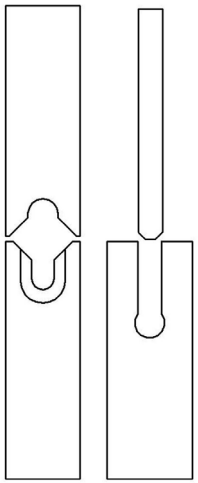
STEEL CABLE CUT- OFF

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

Characteristics: Sharp edges cut by slicing, creating a gradual cut. This produces less deformation of the material being cut. Cutting edges must be able to by-pass each other. This type cut-off is best used with circular shaped wire.

- TC Coating Available -

DIAMETER	ITEM NUMBER	MATERIAL	DESCRIPTION
.104	SK-394-1A&2A	A2 STEEL	STEEL WIRE CABLE
.187	SK-394-1B&2B	A2 STEEL	STEEL WIRE CABLE
.250	SK-394-1C&2C	A2 STEEL	STEEL WIRE CABLE
.062	SK-394-1D&2D	A2 STEEL	STEEL WIRE CABLE
.187	SK-394-1E&2E	A2 STEEL	STEEL WIRE CABLE
.104	SK-394-1F&2F	D2 STEEL	STEEL WIRE CABLE
.130	SK-394-1G&2G	A2 STEEL	STEEL WIRE CABLE
.312	SK-394-1H&2H	A2 STEEL	STEEL WIRE CABLE
.187	SK-394-1I&2I	D2 STEEL	STEEL WIRE CABLE



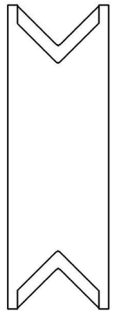
SK-394-1&2 "XX"

UNIVERSAL CUT-OFF BLADES

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

Characteristics: Sharp edges cut by slicing, creating a gradual cut. This produces less deformation of the material being cut. Cutting edges must be able to by-pass each other. This type cut-off is best used with circular shaped wire. *- TC Coating Available -*

ITEM NUMBER	DESCRIPTION
120462	CL DUAL FORM CUT-OFF



120462

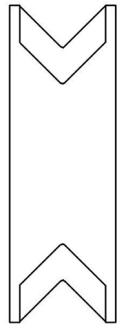
UNIVERSAL CUT-OFF BLADES

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

Characteristics: Sharp edges cut by slicing, creating a gradual cut. This produces less deformation of the material being cut. Cutting edges must be able to by-pass each other. This type cut-off is best used with circular shaped wire.

- TC Coating Available -

ITEM NUMBER	DESCRIPTION
122051-1	CLA DUAL FORM CUT-OFF
122051-2	CLT DUAL FORM CUT-OFF



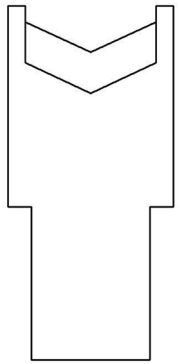
122051

WIDE ENTRY ANGLE CUT-OFF

The sharp edge is ground at an angle that results in a "V" opening above 90 degrees. This type of blade, when closed, presents a diamond shaped edge profile.

Characteristics: Sharp edge cut by slicing, creating a gradual cut. The wide angle allows for a wider range of wire sizes to be cut with the same blades. This type of cut-off is best used with circular shaped wire.

- TC Coating Available -



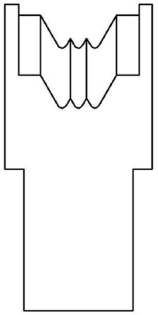
36931

ITEM NUMBER	DESCRIPTION
36931	WCLA WE-A CUT-OFF

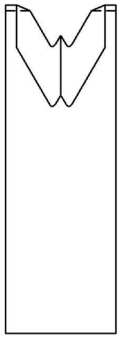
- FOR MORE INFORMATION ON THESE BLADES, PLEASE CONTACT LAKES PRECISION, INC.

- SEND WIRE SAMPLES TO LAKES PRECISION, INC.

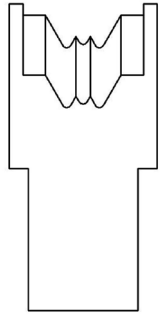
- TC Coating Available -



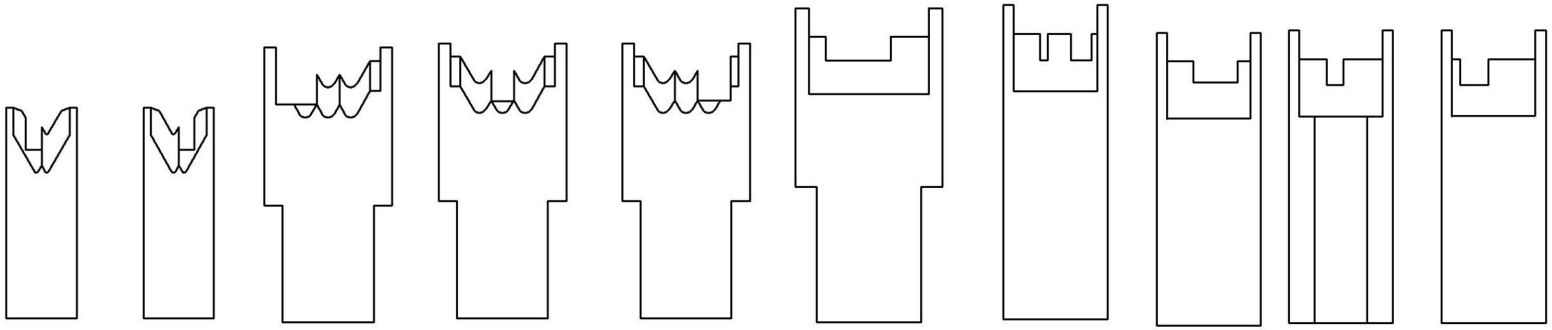
F-946-XX
3V MULTI CONDUCTOR TA-V
LONG & SHORT BLADE = PAIR



37615-XX
MULTI CONDUCTOR TA-V
LONG & SHORT BLADE = PAIR



F-948-XX
3V MULTI CONDUCTOR TA-V
LONG & SHORT BLADE = PAIR



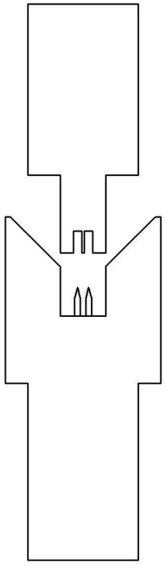
CUT / STRIP & NOTCH BLADES

WIRE SLITTER

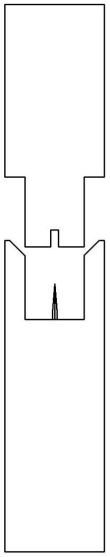
The wire slitter is used to slit multiple conductor wire, separating the individual conductors from each other. Wire slitters are fitted to the wire. For help in choosing the correct slitters for your application, please contact Lakes Precision, Inc.

- SEND WIRE SAMPLES TO LAKES PRECISION, INC. -

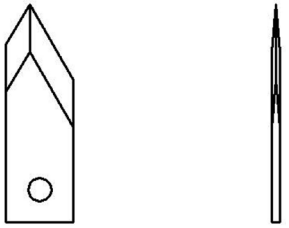
-X STYLE ALSO AVAILABLE - Please contact Lakes Precision Inc for more information



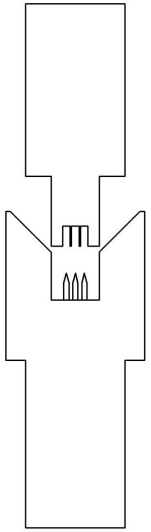
5-115062-XX
3 CONDUCTOR



5-115061-XX
2 CONDUCTOR



H-22896
SLITTER KNIFE



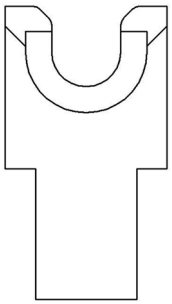
5-115063-XX
4 CONDUCTOR

BI-PASS DIE TYPE BLADES

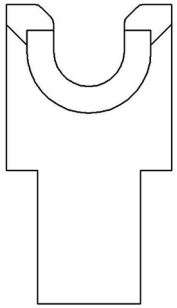
Die type blades are made for a specific wire sizes. The cutting edge is drilled to a specific size to closely match the conductor of the wire being processed. When the proper shut height is achieved, the blades will form a complete circle around the conductor, giving a very clean strip.

Normally this is the blade of choice for SJT, SVT, SJO, and most round multi-conductor wires.

- TC Coating Available -



87367-XX
LONG .125 THICK



87369-XX
SHORT .125 THICK

DIA SIZE	ITEM NUMBER	DESCRIPTION
.125	87367-19	LONG BL
.125	87369-19	SHORT BL
.156	87367-1	LONG BL
.156	87369-1	SHORT BL
.187	87367-2	LONG BL
.187	87369-2	SHORT BL
.205	87367-3	LONG BL
.205	87369-3	SHORT BL
.228	87367-4	LONG BL
.228	87369-4	SHORT BL
.234	87367-5	LONG BL
.234	87369-5	SHORT BL
.250	87367-6	LONG BL
.250	87369-6	SHORT BL
.266	87367-7	LONG BL
.266	87369-7	SHORT BL
.281	87367-8	LONG BL
.281	87369-8	SHORT BL
.312	87367-9	LONG BL

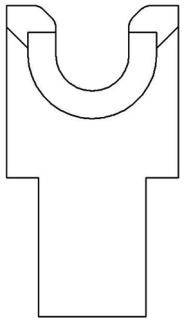
DIA SIZE	ITEM NUMBER	DESCRIPTION
.312	87369-9	SHORT BL
.343	87367-10	LONG BL
.343	87369-10	SHORT BL
.358	87367-11	LONG BL
.358	87369-11	SHORT BL
.366	87367-12	LONG BL
.366	87369-12	SHORT BL
.375	87367-13	LONG BL
.375	87369-13	SHORT BL
.386	87367-14	LONG BL
.386	87369-14	SHORT BL
.397	87367-15	LONG BL
.397	87369-15	SHORT BL
.406	87367-16	LONG BL
.406	87369-16	SHORT BL
.421	87367-17	LONG BL
.421	87369-17	SHORT BL
.437	87367-18	LONG BL
.437	87369-18	SHORT BL

BI-PASS DIE TYPE BLADES

Die type blades are made for a specific wire sizes. The cutting edge is drilled to a specific size to closely match the conductor of the wire being processed. When the proper shut height is achieved, the blades will form a complete circle around the conductor, giving a very clean strip.

Normally this is the blade of choice for SJT, SVT, SJO, and most round multi-conductor wires.

- TC Coating Available -

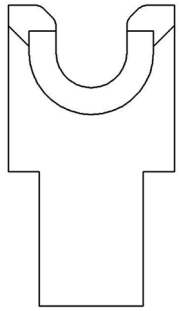


87370-XX
LONG .187 THICK

ARTOS STANDARD MACHINE SERIES

BI-PASS DIE BLADES

- ADDITIONAL PART NUMBER'S ON SUCCEEDING PAGE -



87371-XX
SHORT .187 THICK

ARTOS STANDARD MACHINE SERIES

BI-PASS DIE TYPE BLADES ADDITIONAL PART NUMBER'S

LAKES PRECISION INC.

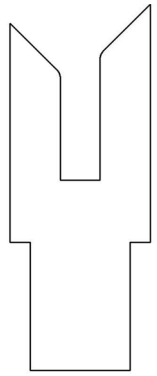
DIA SIZE	ITEM NUMBER	DESCRIPTION
.156	87370-1	LONG BLADE
.156	87371-1	SHORT BLADE
.177	87370-32	LONG BLADE
.177	87371-32	SHORT BLADE
.187	87370-2	LONG BLADE
.187	87371-2	SHORT BLADE
.196	87370-35	LONG BLADE
.196	87371-35	SHORT BLADE
.205	87370-3	LONG BLADE
.205	87371-3	SHORT BLADE
.210	87370-22	LONG BLADE
.210	87371-22	SHORT BLADE
.228	87370-4	LONG BLADE
.228	87371-4	SHORT BLADE
.234	87370-5	LONG BLADE
.234	87371-5	SHORT BLADE
.250	87370-6	LONG BLADE
.250	87371-6	SHORT BLADE
.257	87370-36	LONG BLADE
.257	87371-36	SHORT BLADE
.266	87370-7	LONG BLADE
.266	87371-7	SHORT BLADE
.272	87370-34	LONG BLADE
.272	87371-34	SHORT BLADE

DIA SIZE	ITEM NUMBER	DESCRIPTION
.281	87370-8	LONG BLADE
.281	87371-8	SHORT BLADE
.302	87370-31	LONG BLADE
.302	87371-31	SHORT BLADE
.312	87370-9	LONG BLADE
.312	87371-9	SHORT BLADE
.316	87370-33	LONG BLADE
.316	87371-33	SHORT BLADE
.323	87370-19	LONG BLADE
.323	87371-19	SHORT BLADE
.330	87370-27	LONG BLADE
.330	87371-27	SHORT BLADE
.343	87370-10	LONG BLADE
.343	87371-10	SHORT BLADE
.358	87370-11	LONG BLADE
.358	87371-11	SHORT BLADE
.366	87370-12	LONG BLADE
.366	87371-12	SHORT BLADE
.375	87370-13	LONG BLADE
.375	87371-13	SHORT BLADE
.386	87370-14	LONG BLADE
.386	87371-14	SHORT BLADE
.397	87370-15	LONG BLADE
.397	87371-15	SHORT BLADE

DIA SIZE	ITEM NUMBER	DESCRIPTION
.406	87370-16	LONG BLADE
.406	87371-16	SHORT BLADE
.421	87370-17	LONG BLADE
.421	87371-17	SHORT BLADE
.437	87370-18	LONG BLADE
.437	87371-18	SHORT BLADE
.453	87370-28	LONG BLADE
.453	87371-28	SHORT BLADE
.468	87370-29	LONG BLADE
.468	87371-29	SHORT BLADE
.484	87370-30	LONG BLADE
.484	87371-30	SHORT BLADE
.500	87370-20	LONG BLADE
.500	87371-20	SHORT BLADE
.515	87370-25	LONG BLADE
.515	87371-25	SHORT BLADE
.531	87370-21	LONG BLADE
.531	87371-21	SHORT BLADE
.562	87370-26	LONG BLADE
.562	87370-26	SHORT BLADE
.577	87370-23	LONG BLADE
.577	87371-23	SHORT BLADE
.657	87370-24	LONG BLADE
.657	87371-24	SHORT BLADE

WIRE GUIDES

Wire guides are used in conjunction with cut and strip blades to precisely guide the conductor into the strip area of the blade. This will help prevent the conductor from coming in contact with the cutting edges of the strip blades, preventing premature strip blade wear.



87366-XX

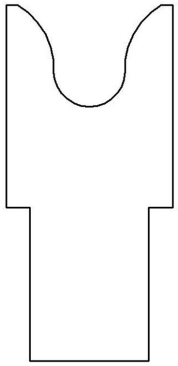
WIRE GUIDE SIZE	ITEM NUMBER
.062	87366-36
.086	87366-13
.093	87366-14
.104	87366-15
.110	87366-16
.116	87366-17
.125	87366-1
.136	87366-18
.145	87366-19
.156	87366-2
.172	87366-30
.187	87366-3
.196	87366-20
.205	87366-31
.218	87366-4
.234	87366-21
.242	87366-43
.250	87366-5
.266	87366-22

WIRE GUIDE SIZE	ITEM NUMBER
.274	87366-50
.281	87366-6
.290	87366-48
.300	87366-37
.305	87366-51
.312	87366-7
.328	87366-29
.335	87366-42
.344	87366-8
.350	87366-57
.359	87366-23
.367	87366-41
.375	87366-9
.386	87366-26
.392	87366-46
.398	87366-40
.406	87366-12
.415	87366-47
.421	87366-28

WIRE GUIDE SIZE	ITEM NUMBER
.425	87366-53
.437	87366-10
.445	87366-45
.453	87366-27
.468	87366-24
.475	87366-55
.484	87366-25
.500	87366-11
.520	87366-32
.531	87366-38
.540	87366-39
.550	87366-39
.562	87366-34
.578	87366-35
.595	87366-44
.605	87366-52
.630	87366-33
.640	87366-54
.680	87366-49

WIRE GUIDES

Wire guides are used in conjunction with cut and strip blades to precisely guide the conductor into the strip area of the blade. This will help prevent the conductor from coming in contact with the cutting edges of the strip blades, preventing premature strip blade wear.



123276-XX

DIA MM SIZE	ITEM NUMBER	MARK	DESCRIPTION
9.5	123276-1	------	WWG - 375S
9.5	123276-2	------	WWG - 375LT
11.4	123276-3	------	WWG-450S
11.4	123276-4	------	WWG450LT

DIE TYPE BLADES

The die-type blade has a fixed shut height. The cutting edge is precisely drilled to an exact radius dimension for the conductor diameter. The insulation wall is contained in a counter-bore drilled around cutting edge.

This type of blade is the most exactly matched blade to the wire specification, giving a very precise insulation removal. This is excellent for removal of extremely thin insulation walls or where the outer jacket is oval shaped, and is also very useful for processing solid conductor insulated wire. Normally this is the blade of choice for SJT, SVT, SJO, coaxial cable outer jacket removal, and many round multi-conductor wires.

Die blades are manufactured to the exact wire specifications. Blades can be produced for most any wire.

- For a specific blade size or application, contact Lakes Precision, Inc.

- TC Coating Available -

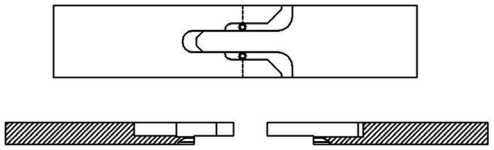
CUTTING EDGE MODIFIERS

MODIFIER	MEANING
NONE	STANDARD
"H"	SHARP
"R"	REVERSE
"C"	DIRECT CENTER
"Z"	REVERSE (CS-326)

DIE BLADE MODIFIERS

MODIFIER	MEANING
NONE	0.0035 / 0.0055
"H"	0.0020 / 0.0035

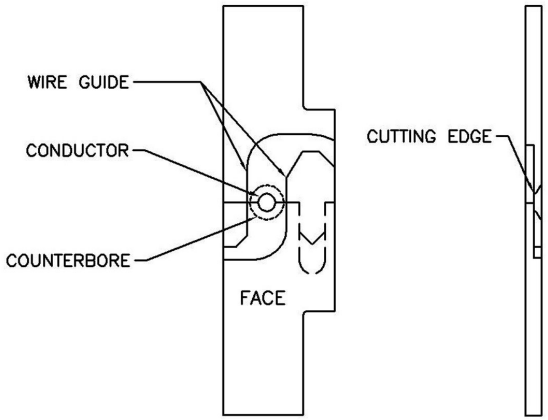
MAXIMUM DIFFERENCE OF 0.001 BETWEEN HALVES



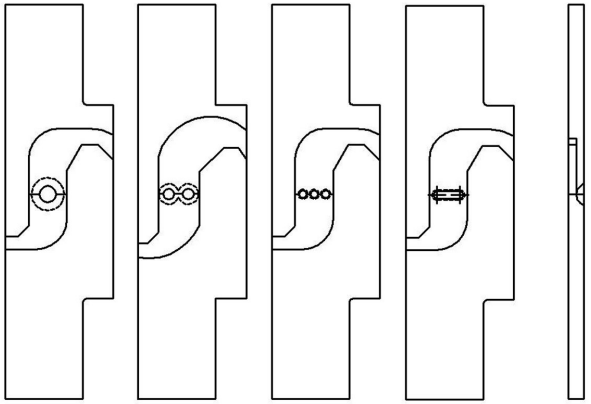
TWIN DIE BLADE

DIE BLADE MODIFIERS

MODIFIER	MEANING
NONE	STANDARD
"A"	ASBESTOS MILL
"R"	REVERSE
"H"	SHARP
"P"	SPECIAL MILLING
"C"	DIRECT CENTER
"W"	HEAVY DUTY BLANK
"X"	EQUAL LENGTH (CS-26)
"Z"	REVERSE (CS-326)
"T"	TWIN DIE BLADE
"O"	OVAL DRILLED
"K"	SK-359 BLANK
"U"	UNEQUAL LENGTH
"A1"	AM-1 STYLE
"A2"	AM-2 STYLE



STANDARD DIE BLADE SHOWN



SINGLE COND. | TWO COND. | THREE COND. | OVAL COND.

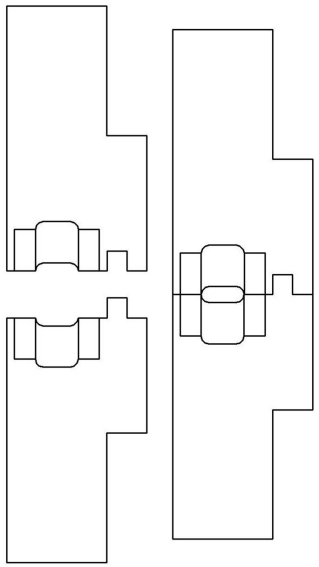
COLLINEAR OVAL TYPE

This type of blade, when closed to shut height, forms an oval profile.

Advantages: This type of blade is most often used for outer jacket removal on multi conductor parallel wires. The oval shape will not damage the inner insulations of the individual conductors.

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

- TC Coating Available -



123202-XX

ITEM NUMBER	MATERIAL	DESCRIPTION
123202-1	A2 TOOL STEEL	OVAL DIE WITH GROUND RADIUS
123202-2	A2 TOOL STEEL	OVAL DIE WITH GROUND RADIUS
123202-3	A2 TOOL STEEL	OVAL DIE WITH GROUND RADIUS
123202-4	A2 TOOL STEEL	OVAL DIE WITH GROUND RADIUS
123202-5	A2 TOOL STEEL	OVAL DIE WITH GROUND RADIUS

VARIABLE SPACERS

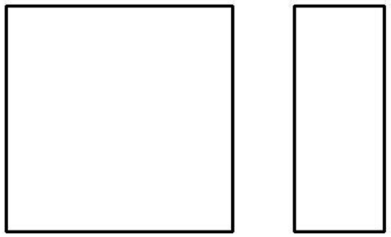
The wire end strip dimension is obtained by physically inserting spacers of different thickness in-between the blade bodies. The assembly is then held in place by set screws or other fastening devices.

This system involves measurement calculations in order to figure the correct spacer-blade combinations. Because of its inherent cumbersome nature, it is highly recommended that this setup be performed in anticipation to a scheduled production run.

To optimize equipment productivity, it is a good idea to have several sets of pre-assembled blade mounts ready for production schedules. For more information plesae see chart on page 69.

SPACER SETS

ITEM NUMBER	MACHINE	TYPE
5-120213	2” STD	SPACER SET
5-120214	4” STD	SPACER SET
5-120215	4” QC	SPACER SET
5-120217	6” STD	SPACER SET
5-120218	8” STD	SPACER SET
5-120224	CS-7	SPACER SET



84980-XX

SIZE	ITEM NUMBER
.005	84980-9
.010	84980-8
.015	84980-7
.022	84980-6
.031	84980-1
.062	84980-2
.078	84980-17
.093	84980-18
.125	84980-3
.156	84980-10
.187	84980-11
.203	84980-12
.219	84980-13
.250	84980-4

SIZE	ITEM NUMBER
.281	84980-14
.312	84980-15
.344	84980-16
.375	84980-19
.417	84980-30
.500	84980-5
.620	84980-29
.625	84980-34
.675	84980-28
.688	84980-31
.750	84980-35
.876	84980-27
1.000	84980-42
1.150	84980-36

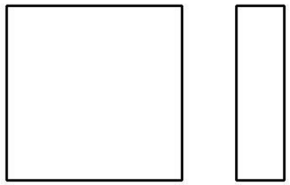
SIZE	ITEM NUMBER
1.200	84980-37
1.300	84980-39
1.350	84980-40
1.400	84980-41
1.688	84980-33
1.875	84980-32
2.000	84980-20
3.000	84980-22
4.000	84980-23
5.000	84980-24
5.375	84980-44
6.000	84980-25
7.000	84980-26
8.000	84980-21
9.735	84980-43

VARIABLE SPACERS

The wire end strip dimension is obtained by physically inserting spacers of different thickness in-between the blade bodies. The assembly is then held in place by set screws or other fastening devices.

This system involves measurement calculations in order to figure the correct spacer-blade combinations. Because of its inherent cumbersome nature, it is highly recommended that this setup be performed in anticipation to a scheduled production run.

To optimize equipment productivity, it is a good idea to have several sets of pre-assembled blade mounts ready for production schedules. For more information please see chart on page 69.



119683-XX

MM SIZE	ITEM NUMBER
0.1	119683-24
0.2	119683-25
0.3	119683-26
0.4	119683-27
0.5	119683-9
0.75	119683-28
1.0	119683-1
1.5	119683-12
2.0	119683-2
2.5	119683-13
2.85	119683-45
3.0	119683-5
3.5	119683-14
4.0	119683-10
4.44	119683-46
4.5	119683-15
4.85	119683-32

MM SIZE	ITEM NUMBER
5.0	119683-3
5.5	119683-16
6.0	119683-6
6.5	119683-17
6.85	119683-50
7.0	119683-18
7.5	119683-19
7.85	119683-52
8.0	119683-20
8.5	119683-21
8.85	119683-33
9.0	119683-22
9.5	119683-23
9.85	119683-34
10.0	119683-4
11.85	119683-35
12.0	119683-7

MM SIZE	ITEM NUMBER
13.0	119683-31
14.85	119683-44
15.0	119683-29
17.8	119683-47
20.0	119683-8
20.8	119683-41
22.8	119683-39
23.8	119683-37
24.0	119683-40
25.9	119683-38
27.0	119683-36
27.8	119683-42
29.0	119683-51
29.8	119683-48
30.0	119683-30
31.0	119683-43
32.9	119683-49
40.0	119683-11

VARIABLE SPACERS

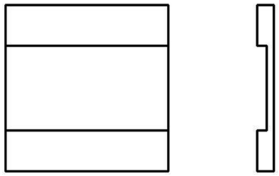
The wire end strip dimension is obtained by physically inserting spacers of

different thickness in-between the blade bodies. The assembly is then held in place by set screws or other fastening devices.

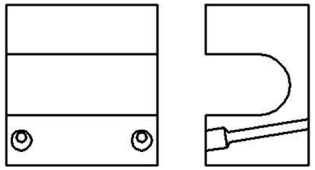
This system involves measurement calculations in order to figure the correct spacer-blade combinations. Because of its inherent cumbersome nature, it is highly recommended that this setup be performed in anticipation to a scheduled production run.

To optimize equipment productivity, it is a good idea to have several sets of pre-assembled blade mounts ready for production schedules.

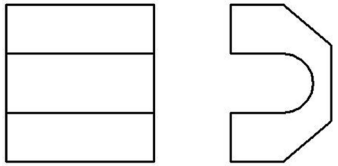
- FOR MORE INFORMATION, CONTACT LAKES PRECISION, INC.



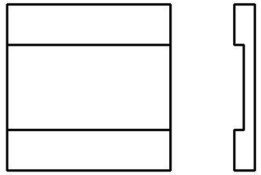
H-2529
STD SPACER



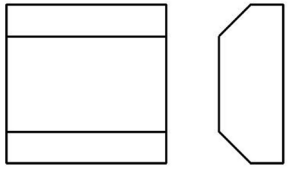
138828-XX
MTX SPACER



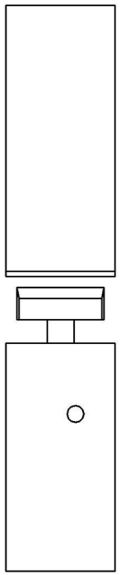
138829-XX
MTX SPACER



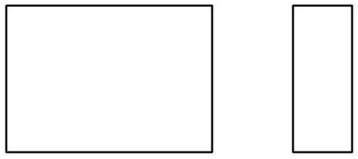
119689
SLOTTED METRIC SPACER



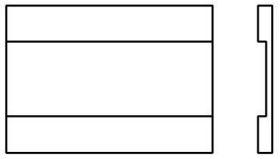
116114
END SPACER



37488-500
PLUNGER BLOCK ASSY
CS-6



H-4376-XX
CS-10 & 11 SPACERS

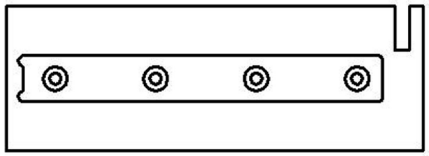


TOOLHOLDERS

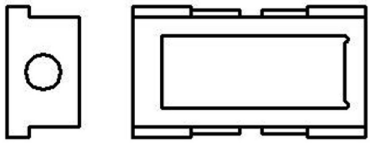
Purchase choices range from a complete assembly, with spacers, to a single toolholder, individual screw or nut. Please contact sales for further information on your specific application.

- FOR MORE INFORMATION, CONTACT LAKES PRECISON, INC.

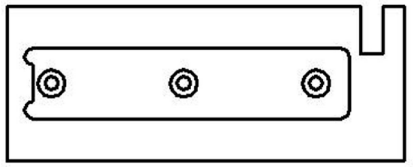
- SEE CHART (PAGE 69)



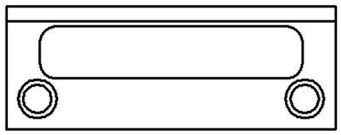
5-122250 & 5-122251
AM-2 LEFT & RIGHT



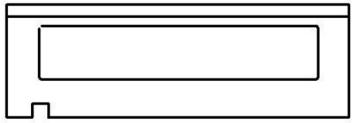
AH-1615
CS-15 / CS-29 / CS-21
CS-30 / CS-33 / CS-35 / CS-15



5-122267 & 5-122268
AM-1 LEFT & RIGHT



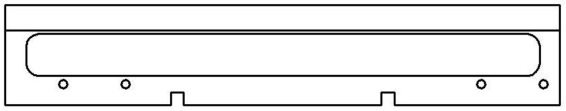
H-1010 & H-1018
CS-6 WITH HORIZONTAL SCREWS



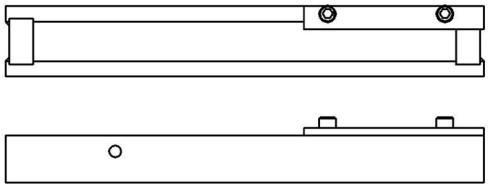
H-2527
CS-6 WITH VERTICLE SCREWS
CS-6 / CS-9 / CS-14 / CS-20 / CS-26
CS-10 / CS-11

TOOLHOLDERS

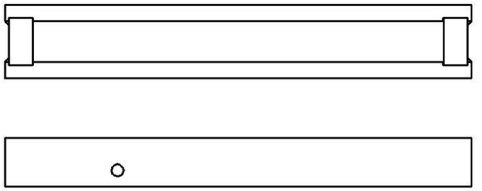
Purchase choices range from a complete assembly, with spacers, to a single toolholder, individual screw or nut. Please contact sales for further information on your specific application.



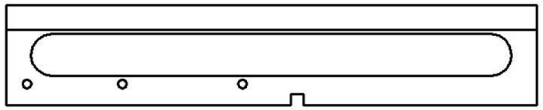
81299 -1 & -2 & -3
QUICK CHANGE CS-27



AH-234 & AH-235
CS-10B



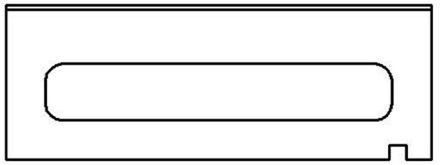
AH-236 & AH-237
AH-387 & AH-388
CS-10A / CS-10



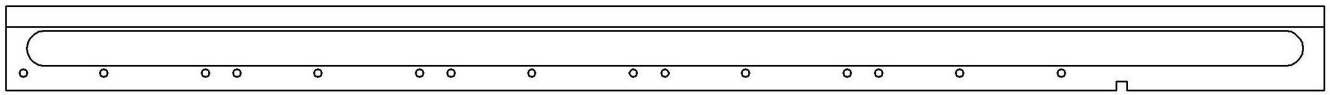
G-2914 & 15 -1 & -2
CS-6 / CS-9 / CS-11 / CS-14 / CS-20

FOR MORE INFORMATION, CONTACT LAKES PRECISON, INC.

SEE CHART (PAGE 69)



G-43681
CS-23



LPI 203-XX & LPI 204-XX
SPECIAL CS-9

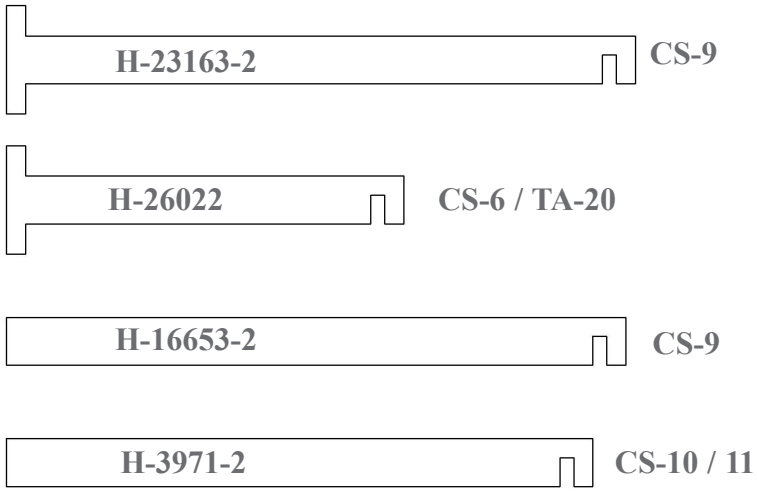
ARTOS STANDARD MACHINE SERIES

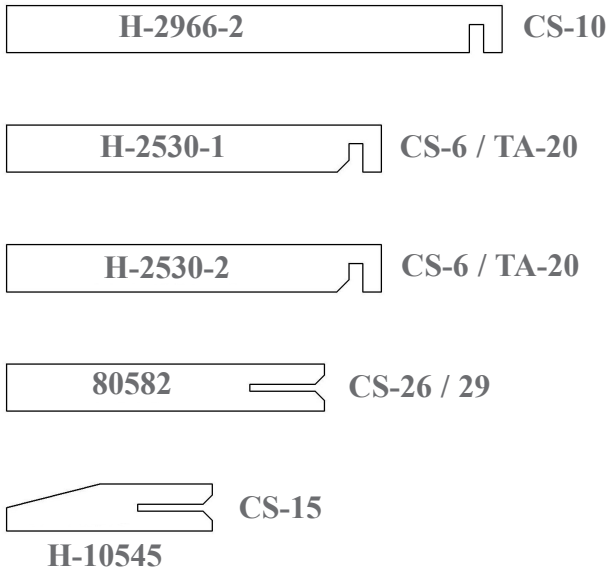
TOOLHOLDER CHART

LAKES PRECISION INC.

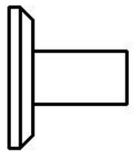
MACHINE TYPE	TOOLHOLDER P/N F=FRONT, R=REAR	DESCRIPTION	FRONT T/H P/N REAR T/H P/N WITH SPACERS
OLD STYLE CS-6	H-1018 (F) H-1010 (R) BT-3004-6 (F) BT-3004-5 (R) BT-3004-21 (F) BT-3004-20 (R)	4" OLD STYLE T/H 4" OLD STYLE T/H 6" OLD STYLE T/H 6" OLD STYLE T/H 8" OLD STYLE T/H 8" OLD STYLE T/H	5-115016 5-119511 5-115018 5-119512 5-115020 5-119514
CS-26	H-2527 (2 REQUIRED)	4" QUICK CHANGE T/H	5-122555
CS-6 9 14 20	H-2527 (2 REQUIRED) AH-2761-500 (INCLUDES F&R T/H, BACKING STRIPS & SCREW) G-2914-1 (F) G-2915-1 (R)	4" QUICK CHANGE T/H 6" QUICK CHANGE T/H 6" QUICK CHANGE T/H 6" QUICK CHANGE T/H	5-115017 5-122047 5-115019 5-119513
CS-10 11A B C D	AH-236-500 (F) AH-237-500 (R) AH-234-500 (F) AH-235-500 (R) AH-205-500 (F) AH-206-500 (R) AH-387-500 (F) AH-388-500 (R)	7 1/4" T/H 7 1/4" T/H 9 3/4" T/H 9 3/4" T/H 15 3/4" T/H 15 3/4" T/H 19 3/4" T/H 19 3/4" T/H	5-115023 5-119516 5-115024 5-119517 5-115025 5-119518 5-115026 5-119519
CS-15 29	AH-1615-500 (2 REQUIRED) (ALSO USED FOR CS-21AT, CS-30AT, CS-33AT/ CS-35 SINGLE WIRE, CS-15, S-1 STRIPPER & T-1 TRIMMER)	2" STANDARD T/H	5-115015
CS-7	B-5366-1 (F) B-5366-2 (R)	6" STANDARD T/H 6" STANDARD T/H	5-115022 5-119520
CS-23	43681 (2 REQUIRED)	23" T/H	5-115028
CS-27	81299-1 81299-2 TWO 6" T/H WITH SPACERS TWO 8" T/H WITH SPACERS	27S T/H (6") 27L T/H (8")	5-115030 5-115029 5-122049

- FOR MORE INFORMATION, CONTACT LAKES PRECISION, INC.

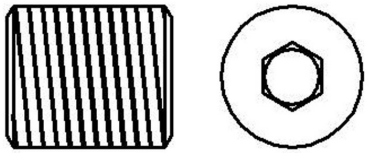




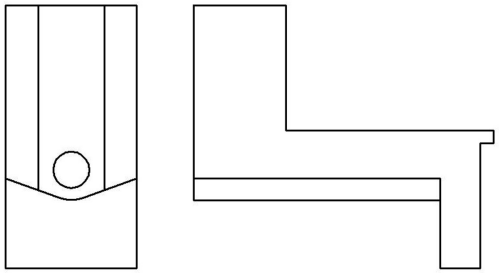
- CONTACT LAKES PRECISION, INC. FOR MORE INFORMATION



H-33783
END WASHER



37646
SCREW



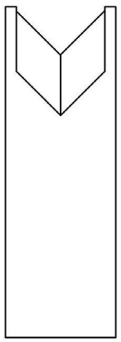
40531
CS-9AT HOLDER

UNIVERSAL STRIP BLADES

The sharp edge is ground at an angle that results in a "V" opening of exactly 90 degrees.

Characteristics: 90 degree angle is widely accepted as the best entry angle to use for processing a wide range of wire sizes using the same blade setup. Most of the time, this class of blade incorporates a sharp edge ground to a very small or non-existing radius. It works sufficiently for most of standard wall insulation but is marginal for thin wall, cross-linked PVC, very rubbery insulations, woven fiber or thin-walled multi-conductors.

- TC Coating Available -



123147

INCH DIA SIZE	ITEM NUMBER	DESCRIPTION
.020	123147-1	UN-V STRIP SHORT
.020	123147-2	UN-V STRIP LONG
.032	123147-3	UN-V STRIP SHORT
.032	123147-4	UN-V STRIP LONG

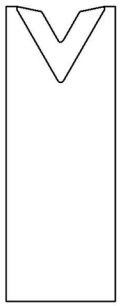
TANGENT RADIUS "V" STRIP BLADES

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.

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

- TC Coating Available -



87330-XX

DIA SIZE	ITEM NUMBER	DESCRIPTION
X-012S	87330-17	SHORT BLADE
X-012L	87330-18	LONG BLADE
X-022S	87330-15	SHORT BLADE
X-022L	87330-16	LONG BLADE
X-034S	87330-1	SHORT BLADE
X-034L	87330-2	LONG BLADE
X-042S	87330-3	SHORT BLADE
X-042L	87330-4	LONG BLADE
X-052S	87330-5	SHORT BLADE
X-052L	87330-6	LONG BLADE
X-062S	87330-7	SHORT BLADE
X-062L	87330-8	LONG BLADE

DIA SIZE	ITEM NUMBER	DESCRIPTION
X-076S	87330-9	SHORT BLADE
X-076L	87330-10	LONG BLADE
X-096S	87330-11	SHORT BLADE
X-096L	87330-12	LONG BLADE
X-112S	87330-13	SHORT BLADE
X-112L	87330-14	LONG BLADE
X-156A	87330-23	SHORT BLADE
X-156L	87330-24	LONG BLADE
X-172A	87330-19	SHORT BLADE
X-172L	87330-20	LONG BLADE
X-222A	87330-21	SHORT BLADE
X-222L	87330-22	LONG BLADE

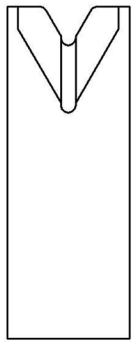
TRU-RADIUS STRIP BLADE

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.

- TC Coating Available -



122111-XX

ITEM NUMBER	DESCRIPTION
122111-1	XTRV-039S STRIP
122111-2	XTRV-039L STRIP
122111-3	XTRV-047S STRIP
122111-4	XTRV-047L STRIP
122111-5	XTRV-055S STRIP
122111-6	XTRV-055L STRIP
122111-7	XTRV-067S STRIP
122111-8	XTRV-067L STRIP
122111-9	XTRV-078S STRIP
122111-10	XTRV-078L STRIP
122111-13	XTRV-090S STRIP
122111-14	XTRV-090L STRIP
122111-11	XTRV-102S STRIP
122111-12	XTRV-102L STRIP
122111-15	XTRV-112S STRIP
122111-16	XTRV-112L STRIP
122111-17	XTRV-125S STRIP

ITEM NUMBER	DESCRIPTION
122111-18	XTRV-125L STRIP
122111-23	XTRV-140S STRIP
122111-24	XTRV-140L STRIP
122111-29	XTRV-152S STRIP
122111-30	XTRV-152L STRIP
122111-21	XTRV-165S STRIP
122111-22	XTRV-165L STRIP
122111-19	XTRV-175S STRIP
122111-20	XTRV-175L STRIP
122111-25	XTRV-210A STRIP
122111-26	XTRV-210L STRIP
122111-33	XTRV-230A STRIP
122111-34	XTRV-230L STRIP
122111-35	XTRV-240A STRIP
122111-36	XTRV-240L STRIP
122111-27	XTRV-250A STRIP
122111-28	XTRV-250L STRIP

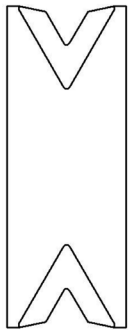
TANGENT RADIUS "V" STRIP BLADES

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.

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

- TC Coating Available -



122002-XX

ITEM NUMBER	DESCRIPTION
122002-17	X-012S
122002-18	X-012L
122002-15	X-022S
122002-16	X-022L
122002-1	X-034S
122002-2	X-034L
122002-3	X-042S
122002-4	X-042L
122002-5	X-052S
122002-6	X-052L
122002-7	X-062S

ITEM NUMBER	DESCRIPTION
122002-8	X-062L
122002-9	X-076S
122002-10	X-076L
122002-11	X-096S
122002-12	X-096L
122002-13	X-112S
122002-14	X-112L
122002-19	X-172A
122002-20	X-172L
122002-21	X-222A
122002-22	X-222L

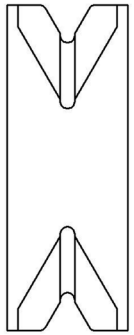
TRU-RADIUS STRIP BLADE (DUAL FORM)

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.

- TC Coating Available -



122411-XX

ITEM NUMBER	DESCRIPTION
122411-1	XTRV-039S
122411-2	XTRV-039L
122411-3	XTRV-047S
122411-4	XTRV-047L
122411-5	XTRV-055S
122411-6	XTRV-055L
122411-7	XTRV-067S

ITEM NUMBER	DESCRIPTION
122411-8	XTRV-067L
122411-9	XTRV-078S
122411-10	XTRV-078L
122411-11	XTRV-102S
122411-12	XTRV-102L
122411-13	XTRV-160A
122411-14	XTRV-160L

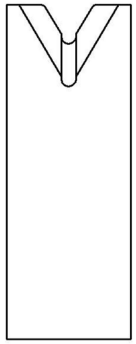
TRU-RADIUS STRIP BLADE

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.

- TC Coating Available -



123800-XX

ITEM NUMBER	DESCRIPTION
123800-1	XTRV-039S STRIP
123800-2	XTRV-039L STRIP
123800-3	XTRV-047S STRIP
123800-4	XTRV-047L STRIP
123800-5	XTRV-055S STRIP
123800-6	XTRV-055L STRIP
123800-7	XTRV-067S STRIP
123800-8	XTRV-067L STRIP
123800-9	XTRV-078S STRIP
123800-10	XTRV-078L STRIP
123800-13	XTRV-090S STRIP
123800-14	XTRV-090L STRIP

ITEM NUMBER	DESCRIPTION
123800-11	XTRV-102S STRIP
123800-12	XTRV-102L STRIP
123800-15	XTRV-112S STRIP
123800-16	XTRV-112L STRIP
123800-17	XTRV-125S STRIP
123800-18	XTRV-125L STRIP
123800-23	XTRV-140S STRIP
123800-24	XTRV-140L STRIP
123800-29	XTRV-152S STRIP
123800-30	XTRV-152L STRIP
123800-21	XTRV-165S STRIP
123800-22	XTRV-165L STRIP

ITEM NUMBER	DESCRIPTION
123800-19	XTRV-175S STRIP
123800-20	XTRV-175L STRIP
123800-31	XTRV-190S STRIP
123800-32	XTRV-190L STRIP
123800-25	XTRV-210A STRIP
123800-26	XTRV-210L STRIP
123800-33	XTRV-230A STRIP
123800-34	XTRV-230L STRIP
123800-35	XTRV-240A STRIP
123800-36	XTRV-240L STRIP
123800-27	XTRV-250A STRIP
123800-28	XTRV-250L STRIP

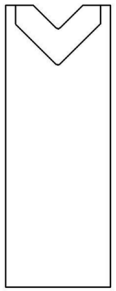
UNIVERSAL CUT-OFF BLADES

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

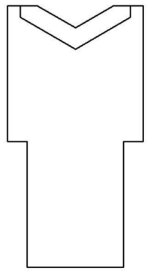
Characteristics: Sharp edges cut by slicing, creating a gradual cut. This produces less deformation of the material being cut. Cutting edges must be able to by-pass each other. This type cut-off is best used with circular shaped wire.

- TC Coating Available -

ITEM NUMBER	DESCRIPTION
54492-2	XCL CUT-OFF
54492-1	XCLA CUT-OFF
54492-3	XDCL CUT-OFF
54492-5	XCLT CUT-OFF
54492-6	XWCLA CUT-OFF
54492-7	XWCLT CUT-OFF
54492-4	X8LPC CUT-OFF
54492-8	SPECIAL
54492-9	SPECIAL



54492-XX



54492-6 & 7
WIDE CUT-OFF

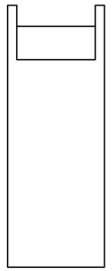
COLLINEAR ANGLE CUT-OFF BLADES

Sharp edge is ground to a flat collinear angle

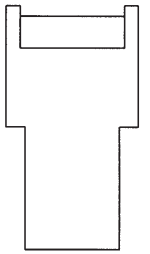
Characteristics: Sharp edges cut by shearing action. This class of blade was designed to allow multiple conductor wire to be processed without deforming the wire. The main advantage of this class is the ability to process many different wire gauges with the same blades.

- TC Coating Available -

ITEM NUMBER	DESCRIPTION
67945-1	XSCA CUT-OFF
58966-1	XWSCA CUT-OFF
67945-2	XSC CUT-OFF
58966-2	XWSC CUT-OFF



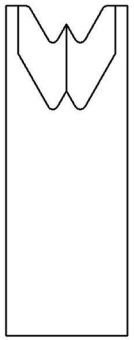
67945-XX



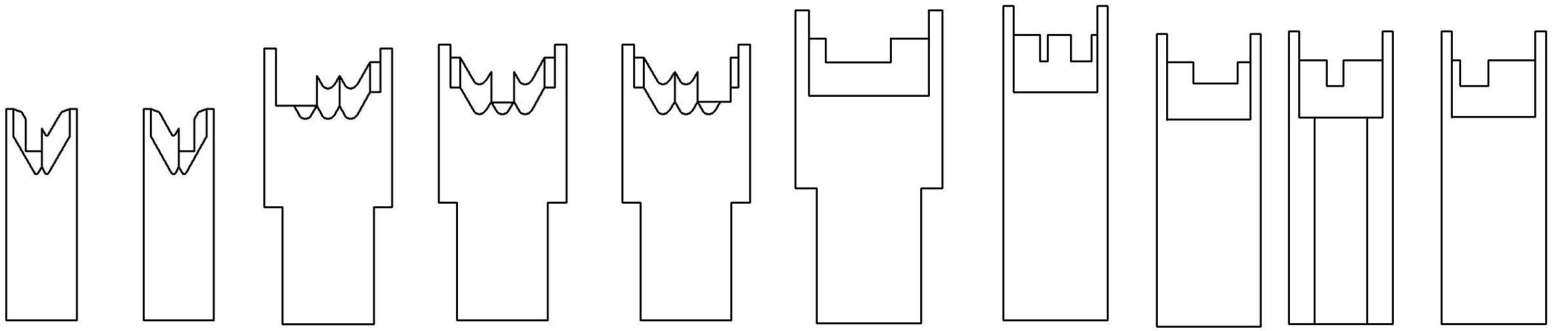
58966-XX
WIDE CUT-OFF

- FOR MORE INFORMATION ON THESE BLADES, PLEASE CONTACT LAKES PRECISION, INC.
- SEND WIRE SAMPLES TO LAKES PRECISION, INC.

- TC Coating Available -



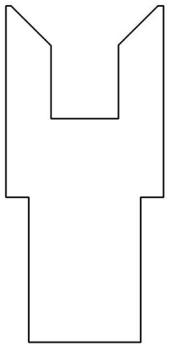
80735-XX
2V MULTI CONDUCTOR TA-V
LONG & SHORT BLADE = PAIR



CUT / STRIP & NOTCH BLADES

WIRE GUIDES

Wire guides are used in conjunction with cut and strip blades to precisely guide the conductor into the strip area of the blade. This will help prevent the conductor from coming in contact with the cutting edges of the strip blades, preventing premature strip blade wear.



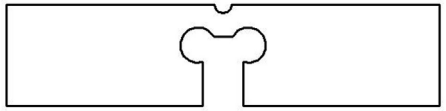
64476

WIRE GUIDE SIZE	ITEM NUMBER
.062	64476-35
.100	64476-31
.115	64476-42
.120	64476-50
.130	64476-40
.135	64476-49
.145	64476-45
.150	64476-43
.164	64476-1
.187	64476-33
.197	64476-51
.205	64476-38
.206	64476-5
.218	64476-36
.235	64476-39
.250	64476-8

WIRE GUIDE SIZE	ITEM NUMBER
.255	64476-32
.262	64476-2
.276	64476-28
.281	64476-25
.285	64476-24
.286	64476-27
.296	64476-4
.304	64476-46
.312	64476-15
.320	64476-48
.328	64476-13
.335	64476-44
.344	64476-19
.354	64476-7
.358	64476-23
.361	64476-3

WIRE GUIDE SIZE	ITEM NUMBER
.367	64476-47
.376	64476-10
.386	64476-18
.394	64476-34
.410	64476-37
.421	64476-20
.437	64476-16
.446	64476-9
.453	64476-12
.456	64476-14
.460	64476-17
.476	64476-30
.496	64476-11
.530	64476-22
.550	64476-29
.630	64476-41
.665	64476-26

FOR MORE INFORMATION ON THESE BLADES, CONTACT LAKES PRECISION, INC.



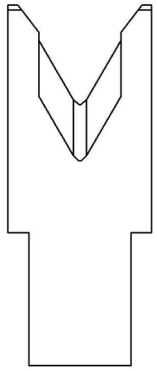
R93855-XX

DIA SIZE	ITEM NUMBER
.017	R93855-14
.021	R93855-13
.026	R93855-12
.032	R93855-11
.043	R93855-10
.046	R93855-7
.054	R93855-4
.059	R93855-3
.067	R93855-2
.075	R93855-15
.080	R93855-16
.086	R93855-5
.093	R93855-9
.096	R93855-17
.101	R93855-8
.106	R93855-6

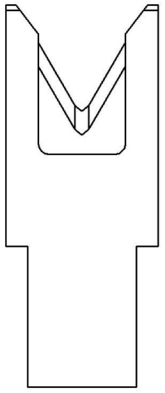
UNI-V UNIVERSAL STRIP BLADE

The sharp edge is ground to an arc that has a small radius. The entry angle lines meet the arc at a tangent point. Unique to this from is an auxiliary angle that intersects the entry angle. This results in greater insulation penetration and a better strip. This patented blade type allows wire sizes from 26 awg to 10 awg to be processed using a single set of blades.

- TC Coating Available -



137470-XX
UNI-V WITHOUT RELIEF



140045
UNI-V WITH RELIEF

ITEM NUMBER	DESCRIPTION
137470-1	30 DEGREE UNI-V
137470-2	20 DEGREE UNI-V
140045	30 DEGREE UNI-V WITH RELIEF

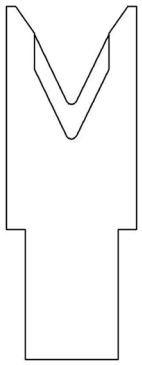
TANGENT RADIUS "V" STRIP BLADES

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.

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

-TC Coating Available -



123241-XX

DIA MM SIZE	ITEM NUMBER	MARK	DESCRIPTION
0.6	123241-1	V-022	60 DEGREE TA-V STRIP
0.9	123241-2	V-034	60 DEGREE TA-V STRIP
1.1	123241-3	V-042	60 DEGREE TA-V STRIP
1.3	123241-4	V-052	60 DEGREE TA-V STRIP
1.6	123241-5	V-062	60 DEGREE TA-V STRIP
1.9	123241-6	V-076	55 DEGREE TA-V STRIP
2.4	123241-7	V-096	60 DEGREE TA-V STRIP
2.8	123241-8	V-112	48 DEGREE TA-V STRIP
4.4	123241-9	V-112	40 DEGREE TA-V STRIP
5.6	123241-10	V-222	30 DEGREE TA-V STRIP
6.6	123241-12	V-260	30 DEGREE TA-V STRIP
7.9	123241-11	V-312	30 DEGREE TA-V STRIP

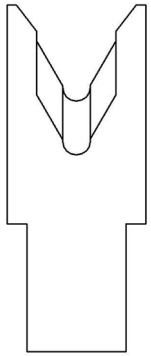
TRU-RADIUS STRIP BLADE

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.

- TC Coating Available -



137684-XX

DIA MM SIZE	ITEM NUMBER
0.7	137684-028
0.8	137684-034
1.0	137684-039
1.1	137684-043
1.2	137684-047
1.3	137684-051
1.4	137684-055
1.6	137684-063
1.7	137684-067
1.8	137684-072
2.0	137684-078
2.2	137684-088
2.3	137684-090
2.5	137684-098
2.6	137684-102
2.7	137684-110
2.8	137684-112

DIA MM SIZE	ITEM NUMBER
3.0	137684-120
3.2	137684-125
3.6	137684-140
3.9	137684-152
4.1	137684-160
4.3	137684-170
4.4	137684-175
4.6	137684-180
4.7	137684-185
4.8	137684-190
4.9	137684-194
5.1	137684-200
5.2	137684-205
5.4	137684-212
5.6	137684-220
5.7	137684-225
5.8	137684-230

DIA MM SIZE	ITEM NUMBER
5.9	137684-235
6.1	137684-240
6.4	137684-250
6.6	137684-260
6.9	137684-270
7.1	137684-280
7.4	137684-290
7.6	137684-300
8.1	137684-320
8.4	137684-330
8.6	137684-340
8.9	137684-350
9.1	137684-360
9.4	137684-370
9.7	137684-380
10.2	137684-400
10.7	137684-420

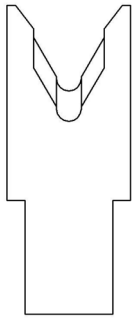
TRU-RADIUS STRIP BLADE

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.

- TC Coating Available -



137685-XX

DIA MM SIZE	ITEM NUMBER
0.51	137685-020
0.61	137685-024
0.71	137685-028
0.81	137685-032
0.86	137685-034
0.99	137685-039
1.09	137685-043
1.19	137685-047
1.30	137685-051
1.40	137685-055
1.60	137685-063
1.70	137685-067
1.75	137685-069
1.83	137685-072
1.91	137685-075
1.98	137685-078
2.24	137685-088

DIA MM SIZE	ITEM NUMBER
2.29	137685-090
2.44	137685-096
2.49	137685-098
2.54	137685-100
2.59	137685-102
2.77	137685-109
2.79	137685-110
2.84	137685-112
3.05	137685-120
3.18	137685-125
3.30	137685-130
3.40	137685-134
3.43	137685-135
3.51	137685-138
3.56	137685-140
3.68	137685-145
3.81	137685-150

DIA MM SIZE	ITEM NUMBER
3.86	137685-152
4.06	137685-160
4.19	137685-165
4.32	137685-170
4.45	137685-175
4.50	137685-177
4.57	137685-180
4.70	137685-185
4.83	137685-190
5.08	137685-200
5.21	137685-205
5.33	137685-210
5.59	137685-220
5.72	137685-225
5.84	137685-230
6.10	137685-240
6.35	137685-250
6.60	137685-260

DIA MM SIZE	ITEM NUMBER
6.86	137685-270
7.11	137685-280
7.37	137685-290
7.49	137685-295
7.62	137685-300
7.70	137685-303
7.80	137685-307
7.92	137685-312
8.13	137685-320
8.38	137685-330
8.64	137685-340
8.89	137685-350
9.14	137685-360
9.40	137685-370
9.65	137685-380
10.16	137685-400
10.67	137685-420
10.92	137685-430
11.43	137685-450

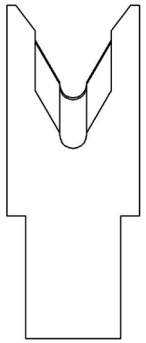
TRU-RADIUS CUT / STRIP BLADE WITH 20 DEGREE RELIEF

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.

- TC Coating Available -



123193-XX

DIA MM SIZE	ITEM NUMBER
0.7	123193-028
1.0	123193-039
1.1	123193-043
1.2	123193-047
1.4	123193-055
1.7	123193-067
1.8	123193-072
2.0	123193-078
2.2	123193-088
2.3	123193-090
2.6	123193-102
2.8	123193-112
3.2	123193-125
3.6	123193-140
3.9	123193-152
4.1	123193-160
4.4	123193-175
4.5	123193-178
4.7	123193-185

DIA MM SIZE	ITEM NUMBER
4.8	123193-190
5.1	123193-200
5.6	123193-220
5.7	123193-225
5.8	123193-230
6.1	123193-240
6.4	123193-250
6.6	123193-260
6.9	123193-270
7.1	123193-280
7.4	123193-290
7.6	123193-300
8.1	123193-320
8.6	123193-340
8.9	123193-350
9.1	123193-360
9.7	123193-380
10.2	123193-400
10.7	123193-420

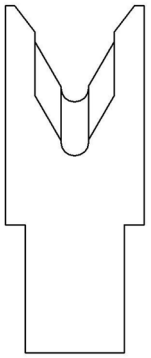
TRU-RADIUS STRIP BLADE

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.

- TC Coating Available -



141097-XX
TR-V STRIP FOR LARGE OD WIRE

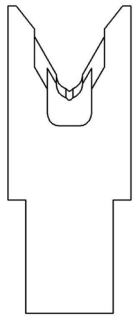
DIA MM SIZE	ITEM NUMBER
4.4	141097-175
5.1	141097-200
5.6	141097-220
6.1	141097-240
6.6	141097-260
7.1	141097-280
7.6	141097-300
8.1	141097-320
8.6	141097-340
9.7	141097-380
10.7	141097-420

UNI-V-TR-V / STRIP BLADES

The UNI-V-TR-V cut and strip blade is specially made for coaxial cable to be run in the single blade cutter-head. The blade is designed to cut off, to remove the outer jacket and also to strip the conductor with the same blade. The blade has a true radius vee form for clean outer jacket removal, and a universal vee form for conductor strip. The dual function is accomplished with the programming software in the CS-326.

- TC Coating Available -

ITEM NUMBER	DESCRIPTION
123201	185 UNI-V-TR-V CUT / STRIP FOR COAXIAL CABLE



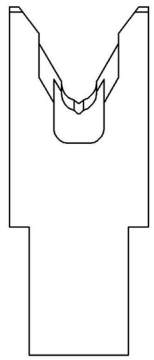
123201

UNI-V-TR-V CUT / STRIP BLADES

The UNI-V-TR-V cut and strip blade is specially made for coaxial cable to be run in the single blade cutter-head. The blade is designed to cut off, to remove the outer jacket and also to strip the conductor with the same blade. The blade has a true radius vee form for clean outer jacket removal, and a universal vee form for conductor strip. The dual function is accomplished with the programming software in the CS-326.

- TC Coating Available -

ITEM NUMBER	DESCRIPTION
123198	220 UNI-V-TR-V CUT / STRIP FOR COAXIAL CABLE



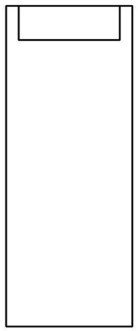
123198

COLLINEAR ANGLE CUT-OFF BLADES

Sharp edge is ground to a collinear angle.

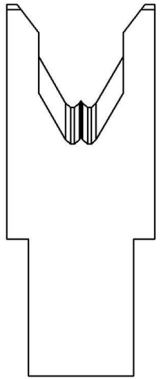
Characteristics: Sharp edges cut by compression. This class of blade was designed to allow positive control of cutter head closure. It also allows precision processing of specific wire sizes with an inherant blade longevity. This type of blade is used with collinear radius strip blades.

- TC Coating Available -



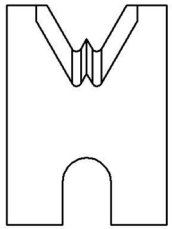
123200

ITEM NUMBER	MATERIAL	DESCRIPTION
123200	A2 TOOL STEEL	BUTT STYLE CL-A CUT-OFF



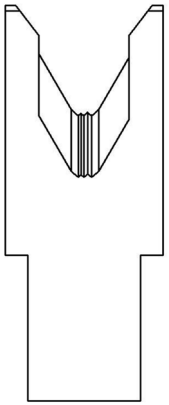
138911-XX

PATENTED UNI-V STRIP
30 DEGREE



138634-XX

MULTI CONDUCTOR TA-V
20 DEGREE



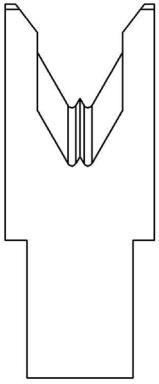
139048-XX

PATENTED UNI-V STRIP
20 DEGREE

- FOR MORE INFORMATION ON THESE BLADES, PLEASE CONTACT LAKES PRECISION, INC.

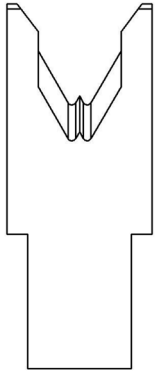
- SEND WIRE SAMPLES TO LAKES PRECISION, INC.

- TC Coating Available -



137944-XX

MULTI CONDUCTOR TA-V
20 DEGREE



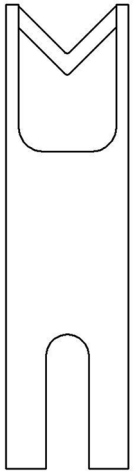
138477-XX

MULTI CONDUCTOR TA-V
30 DEGREE

UNIVERSAL CUT-OFF BLADES

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

Characteristics: Sharp edges cut by slicing, creating a gradual cut. This produces less deformation of the material being cut. Cutting edges must be able to by-pass each other. This type cut-off is best used with circular shaped wire. *- TC Coating Available -*

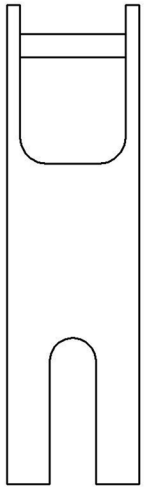


136064

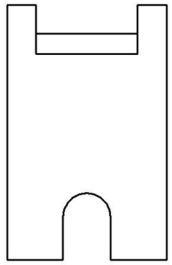
ITEM NUMBER	DESCRIPTION
138633	3 BLADE MACHINE SC STYLE STRAIGHT CUT-OFF
138643	TWO BLADE HEAD SC STYLE CUT-OFF
136064	TWO BLADE HEAD UN-V CUT-OFF

FOR MORE INFORMATION, CONTACT LAKES PRECISION, INC

- TC Coating Available -



138643



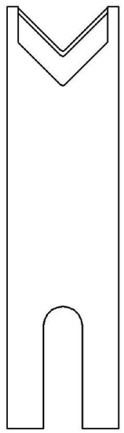
138633

TANGENT ANGLE CUT-OFF BLADES

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

Characteristics: Sharp edges cut by slicing, creating a gradual cut. This produces less deformation of the material being cut. Cutting edges must be able to by-pass each other. This type cut-off is best used with circular shaped wire.

- TC Coating Available -



123237

ITEM NUMBER	DESCRIPTION
123237	TA-V CUT BLADE FOR 2 BLADE CUTTER HEAD

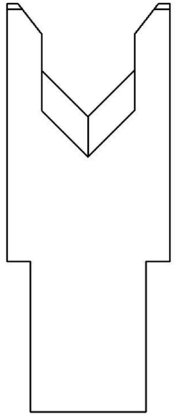
CUT-OFF BLADES

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

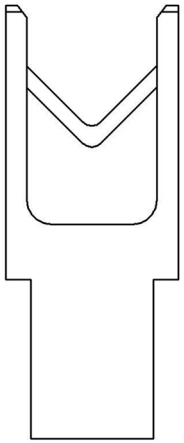
Characteristics: Sharp edges cut by slicing, creating a gradual cut. This produces less deformation of the material being cut. Cutting edges must be able to by-pass each other. This type cut-off is best used with circular shaped wire.

- TC Coating Available -

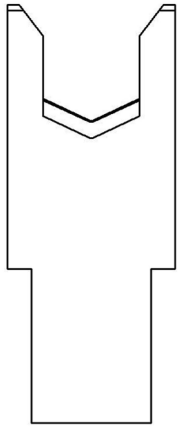
ITEM NUMBER	DESCRIPTION
122863	UN-V CUT-OFF
123163	TA-V CUT-OFF WITH RELIEF
138511	WE-A CUT-OFF WITH COMPOUND CUTTING EDGE
123537	30 SC CUT BLADE



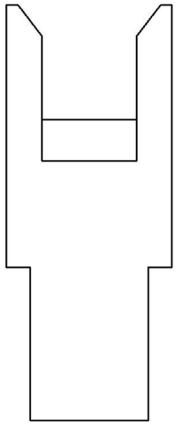
122863
UN-V



123163
TA-V



138511
WE-A



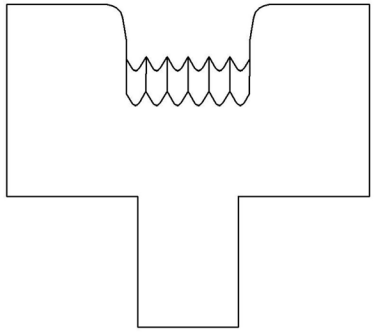
123537
CL-A

SPECIAL APPLICATION BLADES

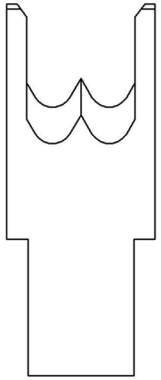
Lakes Precision, Inc. also provides blades for special applications. A few examples are shown here. For blades to meet your specific application please contact Lakes Precision, Inc.

- TC Coating Available -

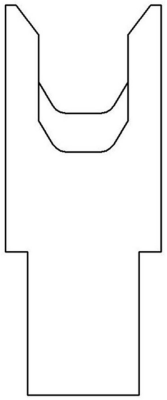
ITEM NUMBER	DESCRIPTION
123120-XX	MULTI-V STRIP
123157-XX	WIDE MULTI-V STRIP (30 DEGREE)
123160-XX	MULTI-CONDUCTOR OVAL STRIP
136061	WIRE GUIDE
138915-XX	MULTI-CONDUCTOR OVAL STRIP
139404-XX	MULTI-V STRIP FOR RIBBON OR PHONE CABLE



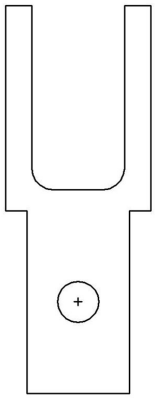
123120-XX
MULTI-CONDUCTOR



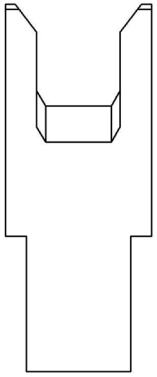
123157-XX
MULTI-CONDUCTOR



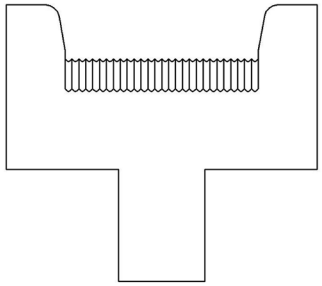
123160-XX
MULTI-CONDUCTOR OVAL



136061
WIRE GUIDE



138915-XX
MUTLI-CONDUCTOR OVAL



139404-XX
MULTI-CONDUCTOR

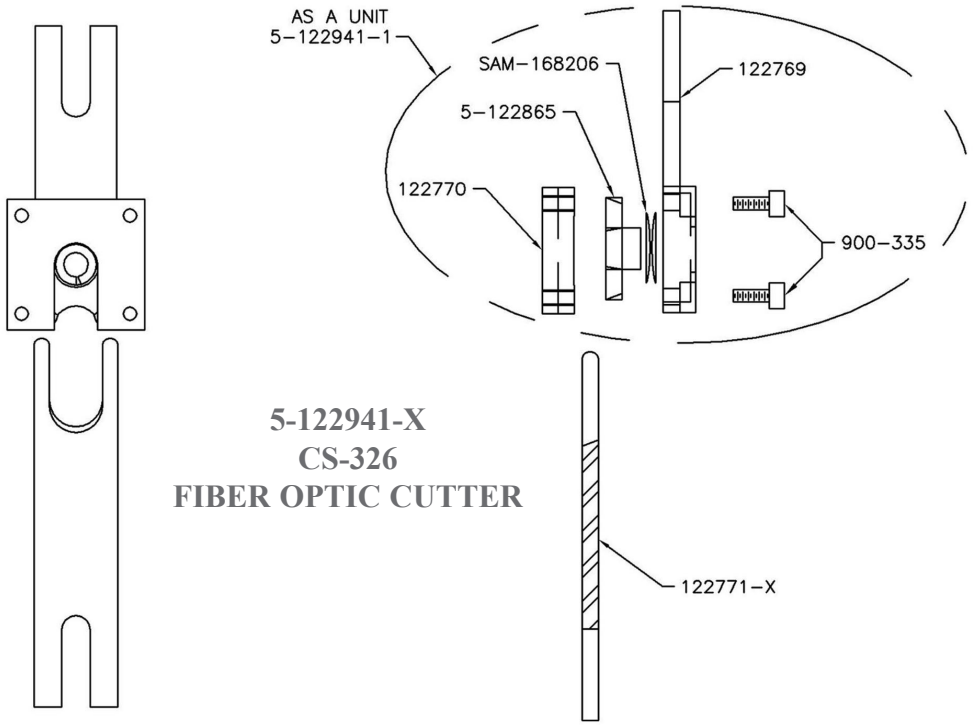
FIBER OPTIC CUTTER

The fiber optic cutter is an assembly that will cut fiber optic cable to length. The assembly is capable of cutting fiber optic cable with or without a strength member, usually made of kevlar. The assembly is used for all fiber optic cables with a maximum outside diameter of .250" (6.3 mm) or less.

- FOR MORE INFORMATION, CONTACT LAKES PRECISON, INC.

- SEND WIRE SAMPLES TO LAKES PRECISION, INC.

- TC Coating Available -



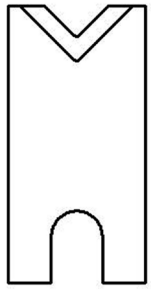
5-122941-X
CS-326
FIBER OPTIC CUTTER

UNIVERSAL CUT-OFF BLADES

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

Characteristics: Sharp edges cut by slicing, creating a gradual cut. This produces less deformation of the material being cut. Cutting edges must be able to by-pass each other. This type cut-off is best used with circular shaped wire. *- TC Coating Available -*

ITEM NUMBER	NOTE
121635-1	FOR AUTO ADJUST STRIP LENGTH ALL WIRE SIZES
121635-2	FOR FIXED STRIP LENGTH TOOLING 1.00 mm AND LARGER
121635-3	FOR FIXED STRIP LENGTH TOOLING 1.00 mm AND SMALLER



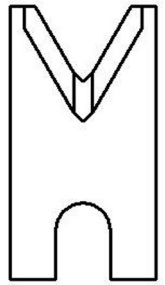
121635-XX

PATENTED DESIGN UNI-V UNIVERSAL STRIP BLADES

The sharp edge is ground to an arc that has a small radius. The entry angle lines meet the arc at a tangent point. Unique to this from is an auxiliary angle that intersects the entry angle. This results in greater insulation penetration and a better strip. This patented blade type allows wire sizes from 26 awg to 10 awg to be processed using a single set of blades.

- With TC Coating -

ITEM NUMBER	DESCRIPTION
132921-1	30 DEGREE UNI-V
132921-2	20 DEGREE UNI-V



132921-XX

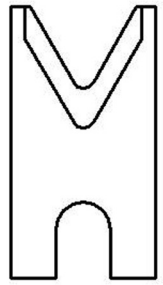
TANGENT RADIUS "V" STRIP BLADES

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.

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

- With TC Coating -



132737-XX

DIA MM SIZE	ITEM NUMBER	MARK	DESCRIPTION
0.3	132737-1	012	65 DEGREE AUTO ADJUST
0.6	132737-2	022	65 DEGREE AUTO ADJUST
0.9	132737-3	034	60 DEGREE AUTO ADJUST
1.1	132737-4	042	60 DEGREE AUTO ADJUST
1.3	132737-5	056	60 DEGREE AUTO ADJUST
1.6	132737-6	062	60 DEGREE AUTO ADJUST
1.9	132737-7	076	55 DEGREE AUTO ADJUST
2.4	132737-8	096	55 DEGREE AUTO ADJUST
2.8	132737-9	112	48 DEGREE AUTO ADJUST
4.4	132737-10	172	40 DEGREE AUTO ADJUST
5.6	132737-11	222	30 DEGREE AUTO ADJUST

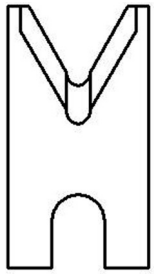
TRU-RADIUS STRIP BLADE

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.

- With TC Coating -



122551-XX

DIA MM SIZE	ITEM NUMBER	DESCRIPTION
0.7	122551-028	TR-V BLADE
1.0	122551-039	TR-V BLADE
1.2	122551-047	TR-V BLADE
1.4	122551-055	TR-V BLADE
1.7	122551-067	TR-V BLADE
2.0	122551-078	TR-V BLADE
2.3	122551-090	TR-V BLADE
2.6	122551-102	TR-V BLADE
2.8	122551-112	TR-V BLADE

DIA MM SIZE	ITEM NUMBER	DESCRIPTION
3.2	122551-125	TR-V BLADE
3.6	122551-140	TR-V BLADE
4.1	122551-160	TR-V BLADE
4.3	122551-170	TR-V BLADE
4.4	122551-175	TR-V BLADE
4.6	122551-180	TR-V BLADE
5.1	122551-200	TR-V BLADE
5.6	122551-220	TR-V BLADE
5.8	122551-230	TR-V BLADE

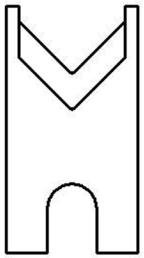
UNIVERSAL STRIP BLADES

The sharp edge is ground at an angle that results in a "V" opening of exactly 90 degrees.

Characteristics: 90 degree angle is widely accepted as the best entry angle to use for processing a wide range of wire sizes using the same blade setup. Most of the time, this class of blade incorporates a sharp edge ground to a very small or non-existing radius. It works sufficiently for most standard wall insulation but is marginal for thin wall, cross-linked PVC, very rubbery insulations, woven fiber or thin-walled multi-conductors.

- With TC Coating -

ITEM NUMBER	DESCRIPTION
121636	UN-V STRIP



121636

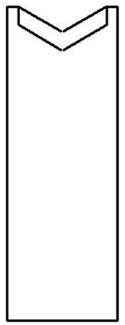
WIDE ENTRY ANGLE

The sharp edge is ground at an angle that results in a "V" opening above 90 degrees.

Characteristics: Wide angle is not as effective for gathering wire towards the operating radius. This type works well for gathering thick, soft insulations, (such as ignition wire).

- With TC Coating -

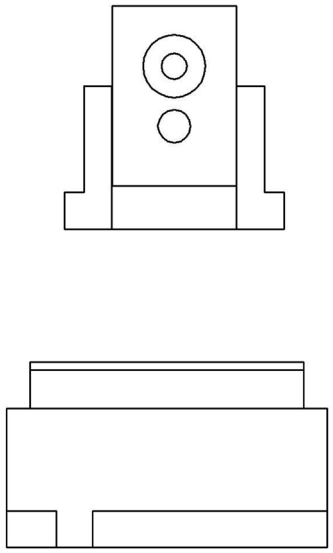
ITEM NUMBER	NOTE
135895-1	FOR FIXED STRIP LENGTH TOOLING 1.00 mm AND LARGER
135895-2	FOR FIXED STRIP LENGTH TOOLING 1.00 mm AND SMALLER



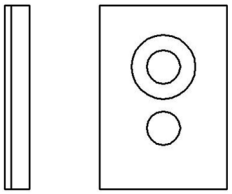
135895-XX

TOOLHOLDERS

Purchase choices range from a complete assembly, with spacers, to a single toolholder, individual screw or nut. For an assembly with pre-installed blades for your specific application, please contact sales for further information.



121778-XX



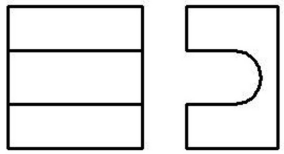
STOP

ITEM NUMBER	DESCRIPTION
121778-1	CS-600 TOOLHOLDER WITH IMAJE
121778-2	CS-600 TOOLHOLDER WITHOUT IMAJE
950-284	SCREW HSC M4 X 10 mm (not shown)
950-839	SCREW FHHSC M4 X 10 mm (not shown)
132741	STOP

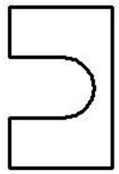
VARIABLE SPACERS

The wire end strip dimension is obtained by physically inserting spacers of different thickness in-between the blade bodies. The assembly is then held in place by set screws or other fastening devices. This system involves measurement calculations in order to figure the correct spacer-blade combinations. Because of its inherent cumbersome nature, it is highly recommended that this setup be performed in anticipation to a scheduled production run. To optimize equipment productivity, it is a good idea to have several sets of pre-assembled blade mounts ready for production schedules.

- FOR MORE INFORMATION, CONTACT LAKES PRECISION, INC. -



121607-XX



121608
END SPACER

DIA MM SIZE	ITEM NUMBER
0.50	121607-29
0.99	121607-28
1.49	121607-1
1.99	121607-2
2.49	121607-3
2.99	121607-4
3.17	121607-39
3.50	121607-5
4.00	121607-6
4.50	121607-7
4.99	121607-8
5.49	121607-9
5.99	121607-10
6.49	121607-11

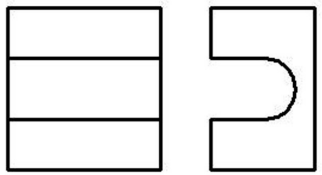
DIA MM SIZE	ITEM NUMBER
7.00	121607-12
7.50	121607-13
8.00	121607-14
8.49	121607-15
8.99	121607-16
9.49	121607-17
9.57	121607-40
9.99	121607-18
10.50	121607-19
11.81	121607-38
10.50	121607-19
11.00	121607-20
11.50	121607-21
11.99	121607-22

DIA MM SIZE	ITEM NUMBER
12.49`	121607-23
12.99	121607-24
13.42	121607-27
13.50	121607-25
14.99	121607-26
16.25	121607-35
17.83	121607-32
18.00	121607-36
18.57	121607-30
19.42	121607-31
19.52	121607-33
19.57	121607-37
22.68	121607-34

VARIABLE SPACERS

The wire end strip dimension is obtained by physically inserting spacers of different thickness in-between the blade bodies. The assembly is then held in place by set screws or other fastening devices. This system involves measurement calculations in order to figure the correct spacer-blade combinations. Because of its inherent cumbersome nature, it is highly recommended that this setup be performed in anticipation to a scheduled production run. To optimize equipment productivity, it is a good idea to have several sets of pre-assembled blade mounts ready for production schedules.

- FOR MORE INFORMATION, CONTACT LAKES PRECISION, INC. -



123166-XX

DIA MM SIZE	ITEM NUMBER
1.52	123166-3
1.57	123166-9
3.16	123166-10
3.20	123166-1
3.25	123166-13
3.32	123166-27
3.61	123166-32
3.76	123166-14
3.87	123166-16
4.06	123166-2
4.64	123166-23
4.78	123166-3

DIA MM SIZE	ITEM NUMBER
5.08	123166-33
5.44	123166-25
5.50	123166-22
6.35	123166-4
7.06	123166-19
7.98	123166-26
8.64	123166-17
8.83	123166-28
9.32	123166-31
9.55	123166-5
9.66	123166-15
9.86	123166-35

DIA MM SIZE	ITEM NUMBER
9.89	123166-20
10.03	123166-6
10.17	123166-12
10.21	123166-18
10.33	123166-29
10.41	123166-7
11.20	123166-30
11.82	123166-11
12.70	123166-8
15.15	123166-21
16.64	123166-24

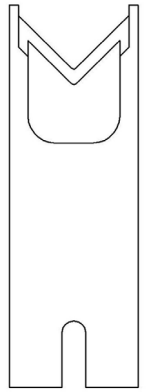
TANGENT ANGLE CUT-OFF BLADES

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

Characteristics: Sharp edges cut by slicing, creating a gradual cut. This produces less deformation of the material being cut. Cutting edges must be able to by-pass each other. This type cut-off is best used with circular shaped wire.

- TC Coating Available -

ITEM NUMBER	OEM #	DESCRIPTION
142336-060	----------	CUT-OFF BLADE WITH .060 RELIEF
142336-125	----------	CUT-OFF BLADE WITH .125 RELIEF



142336-XX

ARTOS CS-327 MACHINE SERIES

TANGENT RADIUS "V" CUT-OFF BLADES CLASS: TA-V

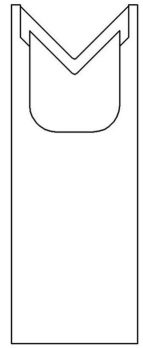
TANGENT ANGLE CUT-OFF BLADES

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

Characteristics: Sharp edges cut by slicing, creating a gradual cut. This produces less deformation of the material being cut. Cutting edges must be able to by-pass each other. This type cut-off is best used with circular shaped wire.

- TC Coating Available -

ITEM NUMBER	OEM #	DESCRIPTION
142900-060	----------	3 BLADE CUTTERHEAD .060 RELIEF
142900-125	----------	3 BLADE CUTTERHEAD .125 RELIEF



142900-XX

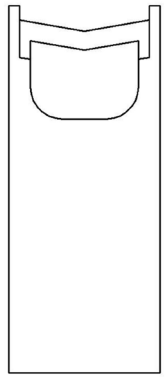
WIDE ENTRY ANGLE CUT-OFF

The sharp edge is ground at an angle that results in a "V" opening above 90 degrees. This type of blade, when closed, presents a diamond shaped edge profile.

Characteristics: Sharp edge cut by slicing, creating a gradual cut. The wide angle allows for a wider range of wire sizes to be cut with the same blades. This type of cut-off is best used with circular shaped wire.

- TC Coating Available -

ITEM NUMBER	OEM #	DESCRIPTION
143058	-------	WE-A CUT FOR 3 BLADE SETUP



143058

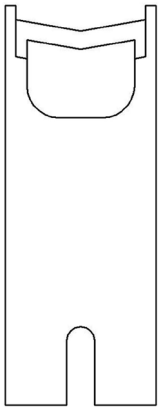
WIDE ENTRY ANGLE CUT-OFF

The sharp edge is ground at an angle that results in a "V" opening above 90 degrees. This type of blade, when closed, presents a diamond shaped edge profile.

Characteristics: Sharp edge cut by slicing, creating a gradual cut. The wide angle allows for a wider range of wire sizes to be cut with the same blades. This type of cut-off is best used with circular shaped wire.

- TC Coating Available -

ITEM NUMBER	OEM #	DESCRIPTION
143059	-------	WE-A CUT FOR 2 BLADE SETUP



143059

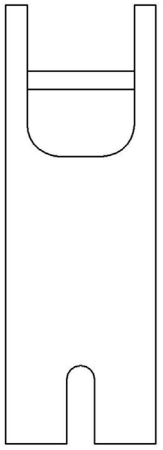
COLLINEAR ANGLE CUT-OFF BLADES

Sharp edge is ground to a flat collinear angle.

Characteristics: Sharp edges cut by shearing action. This class of blade was designed to allow multiple conductor wire to be processed without deforming the wire. The main advantage of this class is the ability to process many different wire gauges with the same blades.

- TC Coating Available -

ITEM NUMBER	OEM #	DESCRIPTION
123722	----------	CL-A 2 BLADE CUTTER-HEAD



123722

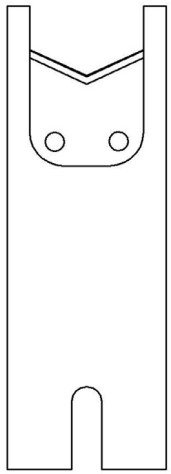
WIDE ENTRY ANGLE CUT-OFF

The sharp edge is ground at an angle that results in a "V" opening above 90 degrees. This type of blade, when closed, presents a diamond shaped edge profile.

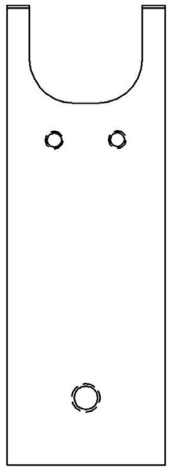
Characteristics: Sharp edge cut by slicing, creating a gradual cut. The wide angle allows for a wider range of wire sizes to be cut with the same blades. This type of cut-off is best used with circular shaped wire.

- TC Coating Available -

ITEM NUMBER	OEM #	DESCRIPTION
123634	----------	STEEL CABLE WE-A CUT
142728	----------	GUIDE FOR STEEL CABLE



123634



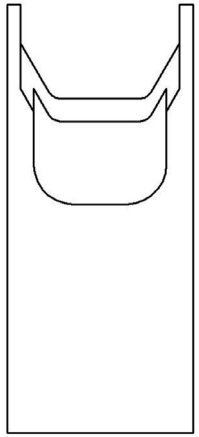
142728

SPECIAL APPLICATION BLADES

Lakes Precision, Inc. also provides blades for special applications. A few examples are shown here. For blades to meet your specific application please contact Lakes Precision, Inc.

- SEND CUSTOMER WIRE SAMPLE TO LAKES PRECISION, INC.

- TC Coating Available -



123758-XX

ITEM NUMBER	DESCRIPTION
123758-1	.130 - .367 CC OVAL STRIP
123758-2	.208 - .601 CC OVAL STRIP
123758-3	.260 - .742 CC OVAL STRIP
123758-4	.130 - .117 CC OVAL STRIP
123758-5	.290 - .572 CC OVAL STRIP
123758-6	.330 - .630 CC OVAL STRIP
123758-7	.200 - .385 CC OVAL STRIP
123758-8	.180 - .330 CC OVAL STRIP
123758-9	.150 - .290 CC OVAL STRIP
123758-10	.150 - .150 CC OVAL STRIP
123758-11	.080 - 1.130 CC OVAL STRIP
123758-12	.080 - .735 CC OVAL STRIP
123758-13	.140 - .265 CC OVAL STRIP

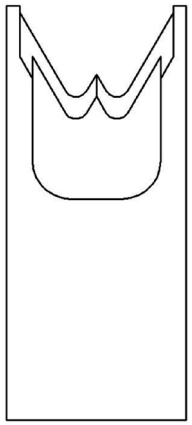
TANGENT RADIUS "2V" STRIP BLADES

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.

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

- TC Coating Available -



123723-XX

DIA MM SIZE	ITEM NUMBER	MARK	DESCRIPTION
1.07	123723-22	2V-042-125	30 DEGREE 2V STRIP
1.32	123723-6	2V-052-135	30 DEGREE 2V STRIP
1.57	123723-2	2V-062-108	30 DEGREE 2V STRIP
1.93	123723-3	2V-076-120	30 DEGREE 2V STRIP
1.93	123723-8	2V-076-170	30 DEGREE 2V STRIP
2.44	123723-7	2V-096-195	30 DEGREE 2V STRIP
2.44	123723-18	2V-096-225	30 DEGREE 2V STRIP
3.05	123723-9	2V-120-205	30 DEGREE 2V STRIP
3.05	123723-19	2V-120-240	30 DEGREE 2V STRIP
3.96	123723-10	2V-156-325	30 DEGREE 2V STRIP
3.96	123723-15	2V-156-360	30 DEGREE 2V STRIP
4.06	123723-25	2V-160-410	30 DEGREE 2V STRIP
4.37	123723-4	2V-172-325	30 DEGREE 2V STRIP
4.37	1213723-11	2V-172-365	30 DEGREE 2V STRIP
5.33	123723-12	2V-210-385	30 DEGREE 2V STRIP

DIA MM SIZE	ITEM NUMBER	MARK	DESCRIPTION
5.72	123723-30	2V-225-220	30 DEGREE 2V STRIP
5.72	123723-20	2V-225-350	30 DEGREE 2V STRIP
5.72	123723-29	2V-225-455	30 DEGREE 2V STRIP
5.33	123723-26	2V-210-415	30 DEGREE 2V STRIP
5.84	123723-29	2V-230-455	30 DEGREE 2V STRIP
6.35	123723-1	2V-250-400	30 DEGREE 2V STRIP
6.35	123723-13	2V-250-420	30 DEGREE 2V STRIP
6.86	123723-21	2V-270-410	30 DEGREE 2V STRIP
7.11	123723-17	2V-280-460	30 DEGREE 2V STRIP
7.11	123723-16	2V-280-485	30 DEGREE 2V STRIP
7.52	123723-27	2V-295-480	30 DEGREE 2V STRIP
7.92	123723-23	2V-312-610	30 DEGREE 2V STRIP
8.25	123723-31	2V-325-500	30 DEGREE 2V STRIP
8.89	123723-5	2V-350-530	30 DEGREE 2VSTRIP
9.65	123723-28	2V-380-625	30 DEGREE 2V STRIP

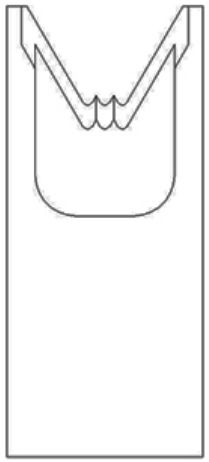
TANGENT RADIUS "3V" STRIP BLADES

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.

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

- TC Coating Available -

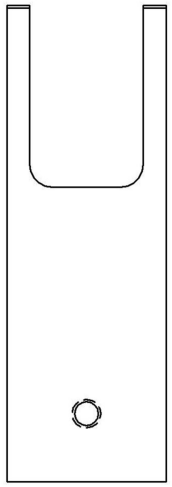


123723-XX

DIA MM SIZE	ITEM NUMBER	MARK	DESCRIPTION
1.57	123723-14	3V-062-105	30 DEGREE 3V STRIP
2.44	123723-24	3V-096-156	30 DEGREE 3V STRIP

RADIUS WIRE GUIDE

Wire guides are used in conjunction with collinear radius strip blades to precisely guide the conductor into the strip area of the blade. This will help prevent the conductor from coming in contact with the cutting edges of the strip blades, preventing premature strip blade wear.



142312

ITEM NUMBER	DESCRIPTION
142312	WIRE GUIDE / 30 mm

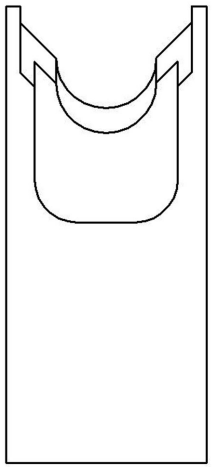
TRU-RADIUS "V" STRIP BLADE

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.

- TC Coating Available -



149311-XX

DIA MM SIZE	ITEM NUMBER	DIA MM SIZE	ITEM NUMBER	DIA MM SIZE	ITEM NUMBER	DIA MM SIZE	ITEM NUMBER
.61	149311-024	3.56	149311-140	8.89	149311-350	17.27	149311-680
.78	143911-031	3.68	149311-145	9.14	149311-360	17.78	149311-700
.99	149311-039	3.81	149311-150	9.40	149311-370	18.29	149311-720
1.19	149311-047	4.06	149311-160	9.65	149311-380	18.80	149311-740
1.40	149311-055	4.32	149311-170	10.16	149311-400	19.30	149311-760
1.57	149311-062	4.45	149311-175	10.41	149311-410	19.81	149311-780
1.70	149311-067	4.57	149311-180	10.67	149311-420	20.32	149311-800
1.78	149311-070	5.08	149311-200	11.18	149311-440	20.83	149311-820
1.88	149311-074	5.33	149311-210	11.68	149311-460	21.34	149311-840
1.98	149311-078	5.59	149311-220	12.19	149311-480	21.84	149311-860
2.29	149311-090	5.84	149311-230	12.70	149311-500	22.35	149311-880
2.59	149311-102	6.10	149311-240	13.21	149311-520	22.86	149311-900
2.65	149311-104	6.35	149311-250	13.72	149311-540	23.37	149311-920
2.70	149311-106	6.60	149311-260	14.22	149311-560	23.88	149311-940
2.84	149311-112	6.86	149311-270	14.73	149311-580	24.38	149311-960
3.05	149311-120	7.11	149311-280	15.24	149311-600	24.89	149311-980
3.10	149311-122	7.62	149311-300	15.75	149311-620	25.40	149311-1000
3.17	149311-125	8.13	149311-320	16.26	149311-640	25.65	149311-1010
3.43	149311-135	8.64	149311-340	16.76	149311-660	29.72	149311-1170

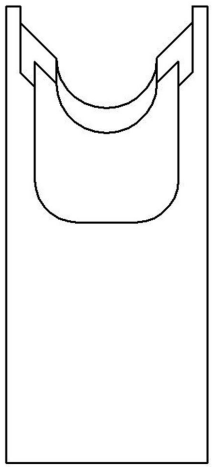
TRU-RADIUS "V" STRIP BLADE

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.

- TC Coating Available -



142337

DIA MM SIZE	ITEM NUMBER
0.61	142337-024
0.78	142337-031
0.99	142337-039
1.19	142337-047
1.40	142337-055
1.57	142337-062
1.70	142337-067
1.78	142337-070
1.88	142337-074
1.98	142337-078
2.29	142337-090
2.59	142337-102
2.65	142337-104
2.70	142337-106
2.84	142337-112
3.05	142337-120
3.10	142337-122
3.17	142337-125
3.43	142337-135
3.56	142337-140

DIA MM SIZE	ITEM NUMBER
3.68	142337-145
3.81	142337-150
4.06	142337-160
4.32	142337-170
4.45	142337-175
4.57	142337-180
5.08	142337-200
5.33	142337-210
5.59	142337-220
5.84	142337-230
6.10	142337-240
6.35	142337-250
6.60	142337-260
6.86	142337-270
7.11	142337-280
7.24	142337-285
7.62	142337-300
8.13	142337-320
8.64	142337-340
8.89	142337-350

DIA MM SIZE	ITEM NUMBER
9.14	142337-360
9.40	142337-370
9.65	142337-380
9.91	142337-390
10.16	142337-400
10.41	142337-410
10.67	142337-420
11.18	142337-440
11.43	142337-450
11.68	142337-460
12.19	142337-480
12.70	142337-500
13.21	142337-520
13.72	142337-540
13.97	142337-550
14.22	142337-560
14.73	142337-580
15.24	142337-600
15.75	142337-620
16.26	142337-640

DIA MM SIZE	ITEM NUMBER
16.76	142337-660
17.27	142337-680
17.78	142337-700
18.29	142337-720
18.80	142337-740
19.30	142337-760
19.81	142337-780
20.32	142337-800
20.83	142337-820
21.34	142337-840
21.84	142337-860
22.35	142337-880
22.86	142337-900
23.37	142337-920
23.88	142337-940
24.38	142337-960
24.89	142337-980
25.40	142337-1000
25.65	142337-1010
29.72	142337-1170

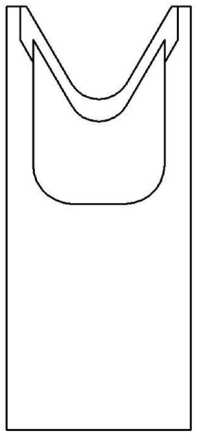
TANGENT ANGLE "V" STRIP BLADES

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.

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

- TC Coating Available -



143066-XX

DIA MM SIZE	ITEM NUMBER
0.61	143066-024
0.78	143066-031
0.99	143066-039
1.19	143066-047
1.40	143066-055
1.70	143066-067
1.98	143066-078
2.29	143066-090
2.59	143066-102
2.84	143066-112
3.17	143066-125
3.56	143066-140
3.81	143066-150
4.06	143066-160
4.45	143066-175
5.08	143066-200
5.59	143066-220
6.10	143066-240

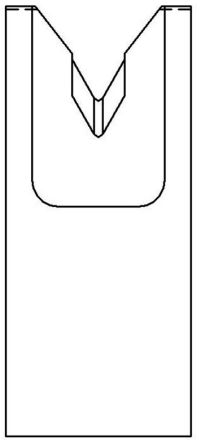
DIA MM SIZE	ITEM NUMBER
6.60	143066-260
7.11	143066-280
7.62	143066-300
8.13	143066-320
8.64	143066-340
9.14	143066-360
9.65	143066-380
10.16	143066-400
10.67	143066-420
11.18	143066-440
11.68	143066-460
12.19	143066-480
12.70	143066-500
13.21	143066-520
13.72	143066-540
14.22	143066-560
14.73	143066-580
15.24	143066-600

DIA MM SIZE	ITEM NUMBER
15.75	143066-620
16.26	143066-640
16.76	143066-660
17.27	143066-680
17.78	143066-700
18.29	143066-720
18.80	143066-740
19.30	143066-760
19.81	143066-780
20.32	143066-800
20.83	143066-820
21.34	143066-840
21.84	143066-860
22.35	143066-880
22.86	143066-900
23.37	143066-920
23.88	143066-940
24.38	143066-960
24.89	143066-980

UNI-V UNIVERSAL STRIP BLADE

The sharp edge is ground to an arc that has a small radius. The entry angle lines meet the arc at a tangent point. Unique to this from is an auxiliary angle that intersects the entry angle. This results in greater insulation penetration and a better strip. This patented blade type allows wire sizes from 26 awg to 10 awg to be processed using a single set of blades.

- TC Coating Available -



142945-XX

ITEM NUMBER	DESCRIPTION
142945-1	30 DEGREE UNI-V WITH RELIEF
142945-2	20 DEGREE UNI-V WITH RELIEF

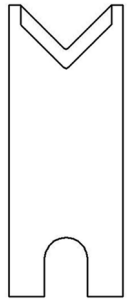
CUT-OFF BLADES

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

Characteristics: Sharp edges cut by slicing, creating a gradual cut. This produces less deformation of the material being cut. Cutting edges must be able to by-pass each other. This type cut-off is best used with circular shaped wire.

- With TC Coating -

ITEM NUMBER	DESCRIPTION
138773	CUT-OFF



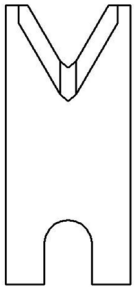
138773

UNI-V UNIVERSAL STRIP BLADE

The sharp edge is ground to an arc that has a small radius. The entry angle lines meet the arc at a tangent point. Unique to this from is an auxiliary angle that intersects the entry angle. This results in greater insulation penetration and a better strip. This patented blade type allows wire sizes from 26 awg to 10 awg to be processed using a single set of blades.

- TC Coating Available -

ITEM NUMBER	DESCRIPTION
138774-1	30 DEGREE UNI-V STRIP
138774-2	20 DEGREE UNI-V STRIP



138774-XX

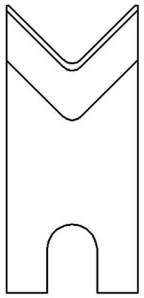
TANGENT ANGLE "V" STRIP BLADES

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.

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

- TC Coating Available -



123238

DIA MM SIZE	ITEM NUMBER	DESCRIPTION
0.2	123238-1	UNIVERSAL ENTRY / TA-V STRIP
0.5	123238-7	UNIVERSAL ENTRY / TA-V STRIP
0.7	123238-9	UNIVERSAL ENTRY / TA-V STRIP
1.0	123238-2	UNIVERSAL ENTRY / TA-V STRIP
1.5	123238-3	UNIVERSAL ENTRY / TA-V STRIP
2.0	123238-4	UNIVERSAL ENTRY / TA-V STRIP
2.8	123238-8	UNIVERSAL ENTRY / TA-V STRIP
3.0	123238-5	UNIVERSAL ENTRY / TA-V STRIP
3.5	123238-10	UNIVERSAL ENTRY / TA-V STRIP
4.0	123238-6	UNIVERSAL ENTRY / TA-V STRIP

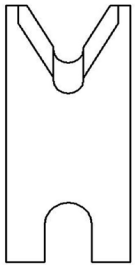
TRU-RADIUS STRIP BLADE

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.

- TC Coating Available -



140029-XX
AUTO ADJUST

DIA MM SIZE	ITEM NUMBER
0.50	140029-020
0.61	140029-024
0.76	140029-028
0.80	140029-032
0.85	140029-034
1.00	140029-039
1.57	140029-062
1.09	140029-043
1.20	140029-047
1.32	140029-052
1.40	140029-055
1.70	140029-067

DIA MM SIZE	ITEM NUMBER
1.78	140029-070
2.00	140029-078
2.24	140029-088
2.29	140029-090
2.60	140029-102
2.84	140029-112
3.00	140029-118
3.18	140029-125
3.30	140029-130
3.56	140029-140
3.86	140029-152
4.06	140029-160

DIA MM SIZE	ITEM NUMBER
4.45	140029-175
5.08	140029-220
6.10	140029-240
6.60	140029-280
7.11	140029-280
7.62	140029-300
8.13	140029-320
8.64	140029-340
9.14	140029-360
9.65	140029-380
10.16	140029-400
10.67	140029-420

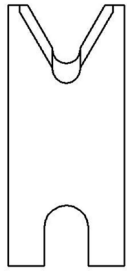
TRU-RADIUS STRIP BLADE

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.

- TC Coating Available -



140030-XX
AUTO ADJUST

DIA MM SIZE	ITEM NUMBER
0.50	140030-020
0.61	140030-024
0.80	140030-032
1.00	140030-039
1.09	140030-043
1.20	140030-047
1.40	140030-055
1.70	140030-067
1.78	140030-070
2.00	140030-078
2.24	140030-088
2.29	140030-090
2.60	140030-102
2.84`	140030-112
3.00	140030-118
3.18	140030-125
3.30	140030-130

DIA MM SIZE	ITEM NUMBER
6.56	140030-140
3.86	140030-152
4.06	140030-160
4.45	140030-175
5.08	140030-200
5.59	140030-220
6.10	140030-240
6.60	140030-260
7.11	140030-280
7.62	140030-300
8.13	140030-320
8.64	140030-340
9.14	140030-360
9.65	140030-380
10.16	140030-400
10.67	140030-420

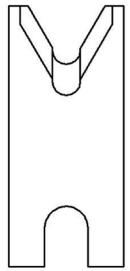
TRU-RADIUS STRIP BLADE

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.

- TC Coating Available -



140229-XX
FIXED MODE

DIA MM SIZE	ITEM NUMBER
0.5	140229-020
0.8	140229-032
1.0	140229-039
1.2	140229-047
1.4	140229-055
1.7	140229-067
1.8	140229-070
2.0	140229-078
2.2	140229-088
2.3	140229-090
2.6	140229-102
2.8	140229-112
3.0	140229-118
3.2	140229-125
3.3	140229-130
3.6	140229-140

DIA MM SIZE	ITEM NUMBER
3.9	140229-152
4.1	140229-160
4.4	140229-175
5.1	140229-200
5.6	140229-200
6.1	140229-240
6.6	140229-260
7.1	140229-280
7.6	140229-300
8.1	140229-320
8.6	140229-340
9.1	140229-360
9.7	140229-380
10.2	140229-400
10.7	140229-420

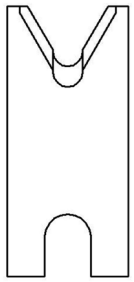
TRU-RADIUS STRIP BLADE

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.

- TC Coating Available -



140230-XX
FIXED MODE

DIA MM SIZE	ITEM NUMBER
0.5	140230-020
0.8	140230-032
1.0	140230-039
1.2	140230-047
1.4	140230-055
1.7	140230-067
1.8	140230-070
2.0	140230-078
2.2	140230-088
2.3	140230-090
2.6	140230-102
2.8	140230-112
3.0	140230-118
3.2	140230-125
3.3	140230-130
3.6	140230-140

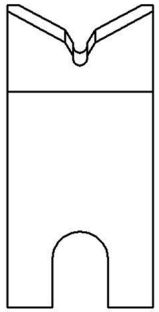
DIA MM SIZE	ITEM NUMBER
3.9	140230-152
4.1	140230-160
4.4	140230-175
5.1	140230-200
5.6	140230-220
6.1	140230-240
6.6	140230-260
7.1	140230-280
7.6	140230-300
8.1	140230-320
8.6	140230-340
9.1	140230-360
9.7	140230-380
10.2	140230-400
10.7	140230-420

IGNITION CABLE APPLICATION WIDE ENRTY ANGLE

The sharp edge is ground at an angle that results in a "V" opening above 90 degrees.

Characteristics: Wide angle is not as effective for gathering wire towards the operating radius. This type works well for gathering thick, soft insulations, (such as ignition wire).

- TC Coating Available -



141025-XX

Contact Lakes Precision for the correct ignition cable blade application.

COLLINEAR RADIUS TYPE

The sharp edge is ground to a half circle whose radius approximates awg wire size. Shearing edge is ground to a straight edge. This type of blade, when closed to shut height, forms a perfect circle profile.

Advantages: This type of blade is excellent for precise and clean jacket removal because it exactly matches conductor gauge. Excellent for thin-wall cross-link PVC and most applications where precise jacket removal around the conductor is required, especially with layered coverings such as fiber over plastic, plastic over shields, etc.

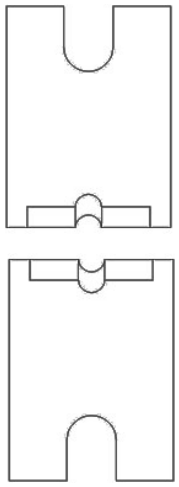
Disadvantages: Shut height cannot be modified to process adjacent wire sizes. Off-center wire condition has to be considered when choosing blade size.

Choosing the correct part number

When choosing the correct size, the blade diameter chosen should be 0.1 mm to 0.15 mm larger than the measured conductor size. If Titanium Nitrade coating is desired, add "TC" to the end of the part number.

Example; 139972-1 = 0.4 mm Diameter Non-Coated

139972-1 TC = 0.4 mm Diameter Titanium Coated



139972-XX
TYPE: CL-R

These blades must be used with wire guides.

(See part number 139973)

- TC Coating Available -

ARTOS MTX MACHINE SERIES

COLLINEAR RADIUS STRIP BLADES CLASS: CL-R

- PART NUMBER'S ON SUCCEEDING PAGES -

DIA MM SIZE	ITEM NUMBER
0.4	139972-1
0.5	139972-2
0.6	139972-3
0.7	139972-4
0.8	139972-5
0.9	139972-6
1.0	139972-7
1.1	139972-8
1.2	139972-9
1.3	139972-10
1.4	139972-11
1.5	139972-12
1.6	139972-13
1.7	139972-14
1.8	139972-15
1.9	139972-16
2.0	139972-17
2.1	139972-18
2.2	139972-19
2.3	139972-20
2.4	139972-21
2.5	139972-22

DIA MM SIZE	ITEM NUMBER
2.6	139972-23
2.7	139972-24
2.8	139972-25
2.9	139972-26
3.0	139972-27
3.1	139972-28
3.2	139972-29
3.3	139972-30
3.4	139972-31
3.5	139972-32
3.6	139972-33
3.7	139972-34
3.8	139972-35
3.9	139972-36
4.0	139972-37
4.1	139972-38
4.2	139972-39
4.3	139972-40
4.4	139972-41
4.5	139972-42
4.6	139972-43
4.7	139972-44

DIA MM SIZE	ITEM NUMBER
4.8	139972-45
4.9	139972-46
5.0	139972-47
5.1	139972-48
5.2	139972-49
5.3	139972-50
5.4	139972-51
5.5	139972-52
5.6	139972-53
5.7	139972-54
5.8	139972-55
5.9	139972-56
6.0	139972-57
6.1	139972-58
6.2	139972-59
6.3	139972-60
6.4	139972-61
6.5	139972-62
6.6	139972-63
6.7	139972-64
6.8	139972-65
6.9	139972-66
7.0	139972-67

DIA MM SIZE	ITEM NUMBER
7.1	139972-68
7.2	139972-69
7.3	139972-70
7.4	139972-71
7.5	139972-72
7.6	139972-73
7.7	139972-74
7.8	139972-75
7.9	139972-76
8.0	139972-83
8.1	139972-77
8.2	139972-78
8.3	139972-84
8.4	139972-85
8.5	139972-91
8.6	139972-82
9.0	139972-79
9.4	139972-86
10.2	139972-87
10.6	139972-88
11.3	139972-89
11.5	139972-80
13.0	139972-90

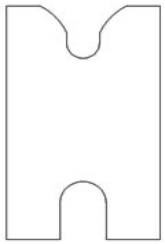
RADIUS WIRE GUIDE

Wire guides are used in conjunction with cut and strip blades to precisely guide the conductor into the strip area of the blade. This will help prevent the conductor from coming in contact with the cutting edges of the strip blades, preventing premature strip blade wear.

Choosing the correct part number

When choosing the correct size, the guide diameter chosen should be 0.00 mm to 0.1 mm larger than the measured insulation diameter.

Example; 139973-1 = 0.6 mm Diameter Guide



139973-XX

GUIDE MM SIZE	ITEM NUMBER
0.6	139973-1
0.7	139973-2
0.9	139973-3
1.0	139973-4
1.1	139973-5
1.2	139973-6
1.3	139973-7
1.4	139973-8
1.5	139973-9
1.6	139973-10
1.7	139973-11
1.8	139973-12
1.9	139973-13
2.0	139973-14
2.1	139973-15
2.2	139973-16
2.3	139973-17

GUIDE MM SIZE	ITEM NUMBER
2.4	139973-18
2.5	139973-19
2.6	139973-20
2.7	139973-21
2.8	139973-22
2.9	139973-23
3.0	139973-24
3.1	139973-25
3.2	139973-26
3.3	139973-27
3.4	139973-28
3.5	139973-29
3.6	139973-30
3.7	139973-31
3.8	139973-32
3.9	139973-33
4.0	139973-34

GUIDE MM SIZE	ITEM NUMBER
4.1	139973-35
4.2	139973-36
4.3	139973-37
4.4	139973-38
4.5	139973-39
4.6	139973-40
4.7	139973-41
4.8	139973-42
4.9	139973-43
5.0	139973-44
5.1	139973-45
5.2	139973-46
5.3	139973-47
5.4	139973-48
5.5	139973-49
5.6	139973-50
5.7	139973-51

GUIDE MM SIZE	ITEM NUMBER
5.8	139973-52
5.9	139973-53
6.0	139973-54
6.1	139973-55
6.2	139973-56
6.3	139973-57
6.5	139973-58
6.6	139773-59
6.7	139973-60
6.8	139973-61
6.9	139973-86
7.0	139973-62
7.2	139973-63
7.3	139973-64
7.4	139973-65
7.6	139973-66
7.7	139973-67
8.0	139973-68

GUIDE MM SIZE	ITEM NUMBER
8.3	139973-81
8.4	139973-77
8.5	139973-69
8.7	139973-78
9.0	139973-70
9.4	139973-76
9.8	139973-71
10.0	139973-72
10.1	139973-79
10.2	139973-82
10.3	139978-88
10.6	139973-73
10.7	139973-83
11.3	139973-75
11.6	139973-80
12.2	139973-87
12.7	139973-85
13.0	139973-74
13.6	139973-84

DIE TYPE BLADES

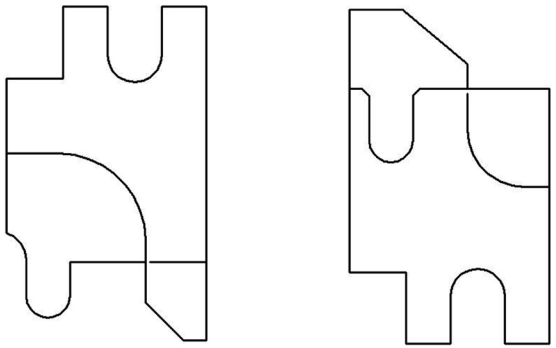
The die-type blade has a fixed shut height. The cutting edge is precisely drilled to an exact radius dimension for the conductor diameter. The insulation wall is contained in a counter-bore drilled around cutting edge.

This type of blade is the most exactly matched blade to the wire specification, giving a very precise insulation removal. This is excellent for removal of extremely thin insulation walls or where the outer jacket is oval shaped, and is also very useful for processing solid conductor insulated wire. Normally this is the blade of choice for SJT, SVT, SJO, coaxial cable outer jacket removal, and many round multi-conductor wires.

Die blades are manufactured to the exact wire specifications. Blades can be produced for most any wire.

- For a specific blade size or application, contact Lakes Precision, Inc. -

- TC Coating Available -

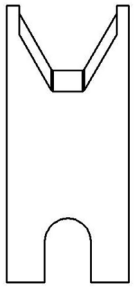


Q-XXX-XXX

SPECIAL APPLICATION BLADES

Lakes Precision Inc. also provides blades for special applications.
An example is shown here.
For blades to meet your specific application, please contact Lakes Precision, Inc.

- TC Coating Available / Wire Samples Required -

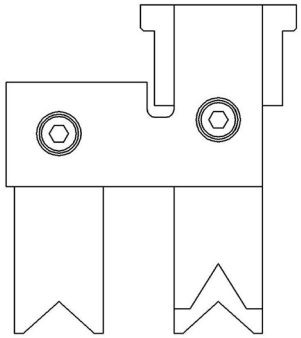


140460-XX

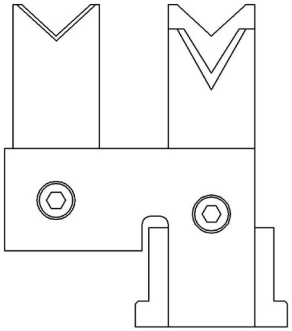
MULTI-CONDUCTOR WIRE
STRAIGHT EDGE STRIP TA-V

TOOLHOLDERS

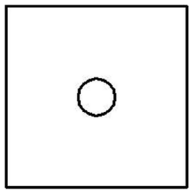
Purchase choices range from a complete assembly, with spacers, to a single toolholder, individual screw or nut. Please contact sales for further information on your specific application.



139958
UPPER BLADE



139959
LOWER BLADE



139960
NUT SP.

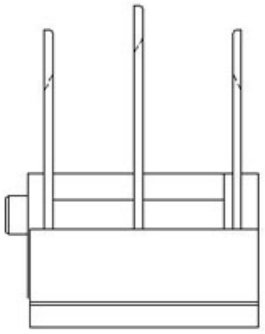
ITEM NUMBER	DESCRIPTION
139958	UPPER BAD PROCESS HOLDER
139959	LOWER BAD PROCESS HOLDER
139960	NUT SPEACIAL FOR BAD PROCESS HOLDER

TOOLHOLDERS

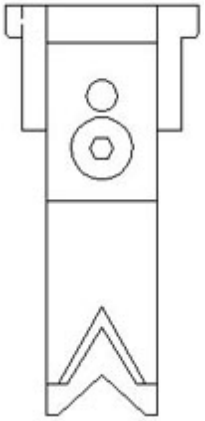
Purchase choices range from a complete assembly, with spacers, to a single toolholder, individual screw or nut. Please contact sales for further information on your specific application.

ITEM NUMBER	DESCRIPTION
5-139329-1	UPPER ASSEMBLY
138826	TOOLHOLDER
132741	STOP
121608	SPACER
138774-1	30 DEGREE STRIP
138828-26	UPPER LONG SPACER
138773	CUT-OFF BLADE
950-839	SCREW SH FLAT M4X10
950-284	SCREW SHC M4X10
138828-27	UPPER SHORT SPACER

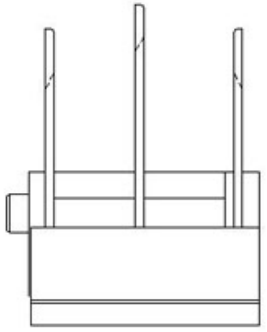
ITEM NUMBER	DESCRIPTION
5-139330-1	LOWER ASSEMBLY
121778-2	TOOL HOLDER
132741	STOP
121608	SPACER
138774-1	30 DEGREE STRIP
138829-26	LOWER SPACER
138773	CUT-OFF BLADE
950-839	SCREW SH FLAT M4X10
950-284	SCREW SHC M4X10



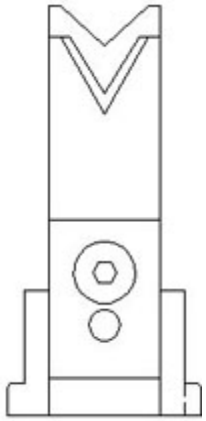
5-139329-X
UPPER ASSY



5-139329-X
UPPER ASSY



5-139330-X
LOWER ASSY



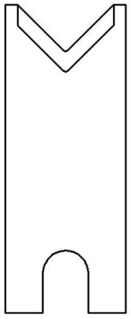
5-139330-X
LOWER ASSY

CUT-OFF BLADES

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

Characteristics: Sharp edges cut by slicing, creating a gradual cut. This produces less deformation of the material being cut. Cutting edges must be able to by-pass each other. This type cut-off is best used with circular shaped wire. *- Uncoated Blades Available -*

ITEM NUMBER	DESCRIPTION
144954	CUT-OFF



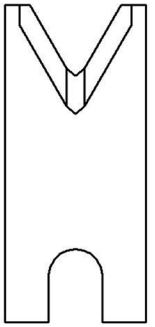
144954

UNI-V UNIVERSAL STRIP BLADE

The sharp edge is ground to an arc that has a small radius. The entry angle lines meet the arc at a tangent point. Unique to this from is an auxiliary angle that intersects the entry angle. This results in greater insulation penetration and a better strip. This patented blade type allows wire sizes from 26 awg to 10 awg to be processed using a single set of blades.

- Uncoated Blades Available -

ITEM NUMBER	DESCRIPTION
138774-1	30 DEGREE UNI-V STRIP
138774-2	20 DEGREE UNI-V STRIP



138774-XX

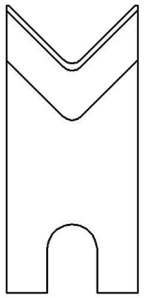
TANGENT ANGLE "V" STRIP BLADES

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.

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

- TC Coating Available -



123238

DIA MM SIZE	ITEM NUMBER	DESCRIPTION
0.2	123238-1	UNIVERSAL ENTRY / TA-V STRIP
0.5	123238-7	UNIVERSAL ENTRY / TA-V STRIP
0.7	123238-9	UNIVERSAL ENTRY / TA-V STRIP
1.0	123238-2	UNIVERSAL ENTRY / TA-V STRIP
1.5	123238-3	UNIVERSAL ENTRY / TA-V STRIP
2.0	123238-4	UNIVERSAL ENTRY / TA-V STRIP
2.8	123238-8	UNIVERSAL ENTRY / TA-V STRIP
3.0	123238-5	UNIVERSAL ENTRY / TA-V STRIP
3.5	123238-10	UNIVERSAL ENTRY / TA-V STRIP
4.0	123238-6	UNIVERSAL ENTRY / TA-V STRIP

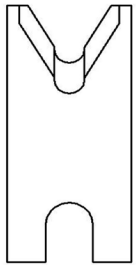
TRU-RADIUS STRIP BLADE

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.

- TC Coating Available -



140029-XX
AUTO ADJUST

DIA MM SIZE	ITEM NUMBER
0.50	140029-020
0.61	140029-024
0.80	140029-032
0.85	140029-034
1.00	140029-039
1.57	140029-062
1.09	140029-043
1.20	140029-047
1.32	140029-052
1.40	140029-055
1.70	140029-067
1.78	140029-070
2.00	140029-078
2.24	140029-088
2.29	140029-090
2.60	140029-102
2.84	140029-112
3.00	140029-118

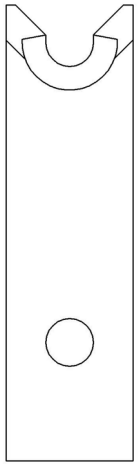
DIA MM SIZE	ITEM NUMBER
3.18	140029-125
3.30	140029-130
3.56	140029-140
3.86	140029-152
4.06	140029-160
4.45	140029-175
5.08	140029-220
6.10	140029-240
6.60	140029-280
7.11	140029-280
7.62	140029-300
8.13	140029-320
8.64	140029-340
9.14	140029-360
9.65	140029-380
10.16	140029-400
10.67	140029-420

DIE TYPE BLADES

Die type blades are made for a specific wire sizes. The cutting edge is drilled to a specific size to closely match the conductor of the wire being processed. When the proper shut height is achieved, the blades will form a complete circle around the conductor, giving a very clean strip. Normally this is the blade of choice for SJT, SVT, SJO, and most round multi-conductor wires.

- SEND WIRE SAMPLES TO LAKES PRECISION, INC.

- TC Coating Available -



B-5368-2-XX
BI-PASS DIE BLADES

DIA MM SIZE	ITEM NUMBER	DESCRIPTION
1.8	B-5368-2-47	YW2-RA-070
2.4	B-5368-2-11	YW2-RC-093
2.4	B-5368-2-36	YW2-RA-093
3.2	B-5368-2-34	YW2-RC-125
3.3	B-5368-2-32	YW2-RA-128
3.6	B-5368-2-39	YW2-RC-140
3.6	B-5368-2-40	YW2-RA-140
3.7	B-5368-2-28	YW2-RC-145
4.0	B-5368-2-45	YW2-RC-156
4.0	B-5368-2-46	YW2-RA-156
4.7	B-5368-2-17	YW2-RC-187
4.7	B-5368-2-44	YW2-RA-187
4.9	B-5368-2-37	YW2-RC-191
4.9	B-5368-2-38	YW2-RA-191
5.2	B-5368-2-19	YW2-RC-203
5.2	B-5368-2-43	YW2-RA-203
5.2	B-5368-2-20	YW2-RC-205
5.6	B-5368-2-33	YW2-RC-221
5.9	B-5368-2-5	YW2-RC-234
5.9	B-5368-2-6	YW2-RA-234
6.4	B-5368-2-16	YW2-RC-250
6.6	B-5368-2-2	YW2-RC-260
6.6	B-5368-2-31	YW2-RA-260
7.1	B-5368-2-21	YW2-RC-281

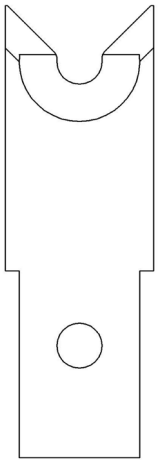
DIA MM SIZE	ITEM NUMBER	DESCRIPTION
7.9	B-5368-2-27	YW2-RC-312
8.2	B-5368-2-22	YW2-RC-323
8.3	B-5368-2-18	YW2-RC-329
8.4	B-5368-2-35	YW2-RA-329
8.7	B-5368-2-14	YW2-RC-343
8.9	B-53682-42	YW2-RC-350
9.1	B-5368-2-30	YW2-RC-359
9.3	B-5368-2-23	YW2-RC-366
9.4	B-5368-2-24	YW2-RC-371
9.5	B-5368-2-1	YW2-RC-375
9.8	B-5368-2-25	YW2-RC-386
9.9	B-5368-2-7	YW2-RC-390
9.9	B-5368-2-8	YW2-RA-390
10.1	B-5368-2-29	YW2-RC-397
10.1	B-5368-2-41	YW2-RA-397
10.3	B-5368-2-12	YW2-RC-406
10.6	B-5368-2-3	YW2-RC-418
11.1	B -5368-2-15	YW2-RC-437
11.5	B-5368-2-9	YW2-RC-543
11.5	B-5368-2-10	YW2-RA-453
12.1	B-5368-2-4	YW2-RC-478
12.3	B-5368-2-13	YW2-RC-484
13.5	B-5368-2-26	YW2-RC-530

DIE TYPE BLADES

Die type blades are made for a specific wire sizes. The cutting edge is drilled to a specific size to closely match the conductor of the wire being processed. When the proper shut height is achieved, the blades will form a complete circle around the conductor, giving a very clean strip. Normally this is the blade of choice for SJT, SVT, SJO, and most round multi-conductor wires.

RA = .125 BLADE THICKNESS / RC = .250 BLADE THICKNESS

- TC Coating Available -



B-5368A-2

DIA MM SIZE	ITEM NUMBER	DESCRIPTION
7.1	B-5368A-2-19	YW3-RC-281
8.7	B-5368A-2-14	YW3-RC-343
11.1	B-5368A-2-11	YW3-RC-437
11.5	B-5368A-2-7	YW3-RC-453
11.9	B-5368A-2-8	YW3-RC-468
11.9	B-5368A-2-12	YW3-RA-468
12.1	B-5368A-2-9	YW3-RC-478
12.1	B-5368A-2-18	YW3-RA-478
12.3	B-5368A-2-3	YW3-RC-484
12.3	B-5368A-2-4	YW3-RA-484

DIA MM SIZE	ITEM NUMBER	DESCRIPTION
12.7	B-5368A-2-2	YW-3-RC-500
13.5	B-5368A-2-6	YW3-RC-531
13.9	B-5368A-2-13	YW3-RC-546
14.3	B-5368A-2-10	YW3-RC-562
15.1	B-5368A-2-1	YW3-RC-593
15.5	B-5368A-2-5	YW3-RC-609
16.0	B-5368A-2-15	YW3-RC-630
17.4	B-5368A-2-16	YW3-RC-684
18.8	B-5368A-2-17	YW3-RC-740

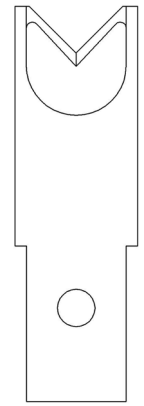
UNIVERSAL CUT-OFF BLADES

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

Characteristics: Sharp edges cut by slicing, creating a gradual cut. This produces less deformation of the material being cut. Cutting edges must be able to by-pass each other. This type cut-off is best used with circular shaped wire.

- TC Coating Available -

ITEM NUMBER	DESCRIPTION
B-5368A-1	WIDE CS-7 UN-V CUT-OFF FOR LARGE O.D. WIRE



B-5368-A-1

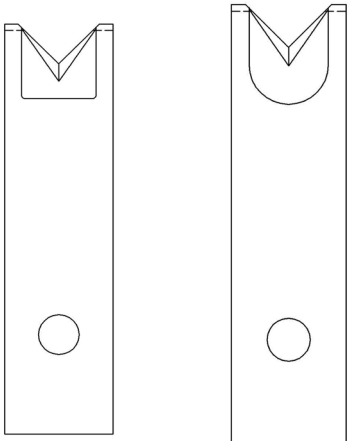
UNIVERSAL CUT-OFF BLADES

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

Characteristics: Sharp edges cut by slicing, creating a gradual cut. This produces less deformation of the material being cut. Cutting edges must be able to by-pass each other. This type cut-off is best used with circular shaped wire.

- TC Coating Available -

ITEM NUMBER	DESCRIPTION
B-5368-13	UN-V THIN CUT-OFF (.124 THICK)
B-5368-1	UN-V THICK CUT-OFF (.249 THICK)

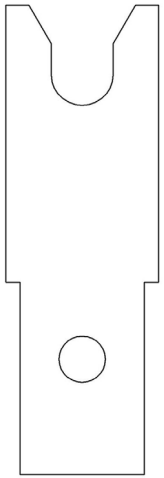


B-5368-13 THIN

B-5368-1 THICK

WIRE GUIDES

Wire guides are used in conjunction with cut and strip blades to precisely guide the conductor into the strip area of the blade. This will help prevent the conductor from coming in contact with the cutting edges of the strip blades, preventing premature strip blade wear.



B-5368A-6-XX

ITEM NUMBER	DESCRIPTION
B-5368A-6-10	YW3-WG-126
B-5368A-6-11	YW3-WG-136
B-5368A-6-1	YW3-WG-187
B-5368A-6-5	YW3-WG-312
B-5368A-6-3	YW3-WG-328
B-5368A-6-4	YW3-WG-359
B-5368A-6-9	YW3-WG-368
B-5368A-6-6	YW3-WG-390
B-5368A-6-6	YW3-WG-421
B-5368A-6-8	YW3-WG-452
B-5368A-6-7	YW3-WG-500
B-5368A-6-2	YW3-WG-689
B-5368A-6-14	YW3-WG-850
B-5368A-6-13	YW3-WG-880
B-5368A-6-15	YW3-WG-940

LAKES PRECISION INC.

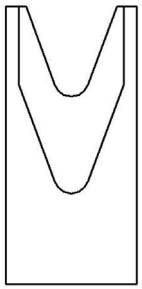
TANGENT RADIUS "V" STRIP BLADES

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.

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

- TC Coating Available -



67940

ITEM NUMBER	DESCRIPTION
67940-20	V012S TA-V
67940-21	V012L TA-V
67940-22	V022S TA-V
67940-23	V022L TA-V
67940-24	V034S TA-V
67940-25	V034L TA-V
67940-26	V042S TA-V
67940-27	V042L TA-V
67940-28	V052S TA-V
67940-29	V052L TA-V
67940-30	V062S TA-V

ITEM NUMBER	DESCRIPTION
67940-31	V062L TA-V
67940-32	V076S TA-V
67940-33	V076S TA-V
67940-34	V096S TA-V
67940-35	V096L TA-V
67940-36	V112S TA-V
67940-37	V112L TA-V
67940-38	V172S TA-V
67940-39	V172L TA-V
67940-40	V222S TA-V
67940-41	V222L TA-V

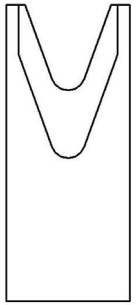
TANGENT RADIUS "V" STRIP BLADES

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.

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

- TC Coating Available -



123724

ITEM NUMBER	DESCRIPTION
123724-1	V012S TA-V
123724-2	V012L TA-V
123724-3	V022S TA-V
123724-4	V022L TA-V
123724-5	V034S TA-V
123724-6	V034L TA-V
123724-7	V042S TA-V
123724-8	V042L TA-V
123724-9	V052S TA-V
123724-10	V052L TA-V
123724-11	V062S TA-V

ITEM NUMBER	DESCRIPTION
123724-12	V062 L TA-V
123724-13	V076S TA-V
123724-14	V076L TA-V
123724-15	V096S TA-V
123724-16	V096L TA-V
123724-17	V112S TA-V
123724-18	V112L TA-V
123724-19	V172A TA-V
123724-20	V172L TA-V
123724-21	V222A TA-V
123724-22	V222L TA-V

DIE TYPE BLADES

The die-type blade has a fixed shut height. The cutting edge is precisely drilled to an exact radius dimension for the conductor diameter. The insulation wall is contained in a counter-bore drilled around cutting edge.

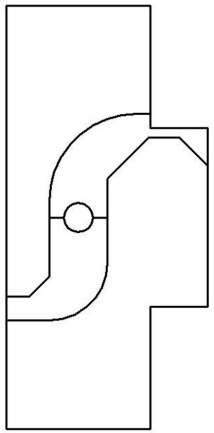
This type of blade is the most exactly matched blade to the wire specification, giving a very precise insulation removal. This is excellent for removal of extremely thin insulation walls or where the outer jacket is oval shaped, and is also very useful for processing solid conductor insulated wire. Normally this is the blade of choice for SJT, SVT, SJO, coaxial cable outer jacket removal, and many round multi-conductor wires.

Die blades are manufactured to the exact wire specifications. Blades can be produced for most any wire.

- For a specific blade size or application, contact Lakes Precision, Inc. -

- TC Coating Available -

ITEM NUMBER	DESCRIPTION
A1-XXX-XXX	AM-1 DIE TYPE BLADES

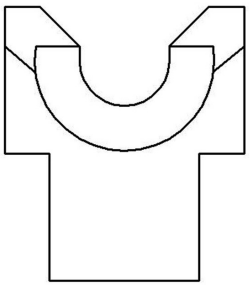


A1-XXX-XXX

DIE TYPE BLADES

Die type blades are made for a specific wire sizes. The cutting edge is drilled to a specific size to closely match the conductor of the wire being processed. When the proper shut height is achieved, the blades will form a complete circle around the conductor, giving a very clean strip. Normally this is the blade of choice for SJT, SVT, SJO, and most round multi-conductor wires.

- TC Coating Available -



67941

DIA SIZE	ITEM NUMBER	DESCRIPTION
.156	67941-1	BI-PASS DIE BLADE
.187	67941-2	BI-PASS DIE BLADE
.172	67941-21	BI-PASS DIE BLADE
.205	67941-3	BI-PASS DIE BLADE
.228	67941-18	BI-PASS DIE BLADE
.234	67941-4	BI-PASS DIE BLADE
.250	67941-20	BI-PASS DIE BLADE
.266	67941-5	BI-PASS DIE BLADE
.281	67941-6	BI-PASS DIE BLADE
.290	67941-17	BI-PASS DIE BLADE

DIA SIZE	ITEM NUMBER	DESCRIPTION
.312	67941-7	BI-PASS DIE BLADE
.343	67941-8	BI-PASS DIE BLADE
.358	67941-9	BI-PASS DIE BLADE
.366	67941-10	BI-PASS DIE BLADE
.375	67941-11	BI-PASS DIE BLADE
.386	67941-12	BI-PASS DIE BLADE
.397	67941-13	BI-PASS DIE BLADE
.406	67941-14	BI-PASS DIE BLADE
.421	67941-15	BI-PASS DIE BLADE
.437	67941-16	BI-PASS DIE BLADE
.484	67941-17	BI-PASS DIE BLADE

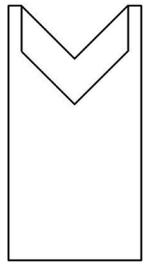
TANGENT ANGLE CUT-OFF BLADES

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

Characteristics: Sharp edges cut by slicing, creating a gradual cut. This produces less deformation of the material being cut. Cutting edges must be able to by-pass each other. This type cut-off is best used with circular shaped wire.

- TC Coating Available -

ITEM NUMBER	DESCRIPTION
67940-8	THICK CLA CUT-OFF
67940-9	THICK WSCA CUT-OFF
67940-10	THICK SCA CUT-OFF
67940-11	THIN CL CUT-OFF
67940-12	THIN WSC CUT-OFF
67940-13	THIN SC CUT-OFF



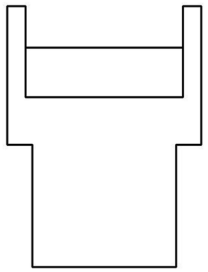
67940-XX
CL / CLA

COLLINEAR ANGLE CUT-OFF BLADES

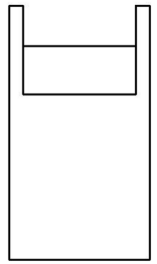
Sharp edge is ground to a flat collinear angle

Characteristics: Sharp edges cut by shearing action. This class of blade was designed to allow multiple conductor wire to be processed without deforming the wire. The main advantage of this class is the ability to process many different wire gauges with the same blades.

- TC Coating Available -



67940-XX
WSC / WSCA



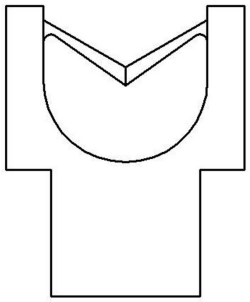
67940-XX
SC / SCA

WIDE ENTRY ANGLE CUT-OFF

The sharp edge is ground at an angle that results in a "V" opening above 90 degrees. This type of blade, when closed, presents a diamond shaped edge profile.

Characteristics: Sharp edge cut by slicing, creating a gradual cut. The wide angle allows for a wider range of wire sizes to be cut with the same blades. This type of cut-off is best used with circular shaped wire.

- TC Coating Available -

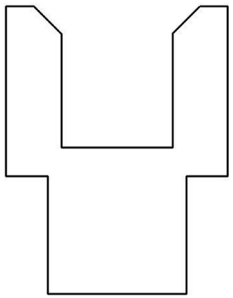


67942-XX

ITEM NUMBER	THICKNESS	ANGLE	DESCRIPTION
67942-1	1/8 THICK	120 DEGREE	WE-A CUT-OFF
67942-2	3/16 THICK	120 DEGREE	WE-A CUT-OFF

WIRE GUIDES

Wire guides are used in conjunction with cut and strip blades to precisely guide the conductor into the strip area of the blade. This will help prevent the conductor from coming in contact with the cutting edges of the strip blades, preventing premature strip blade wear.



122236

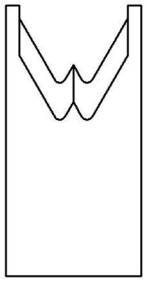
WIRE GUIDE INCH SIZE	ITEM NUMBER
.130	122236-36
.160	122236-35
.175	122236-1
.185	122236-2
.195	122236-3
.205	122236-4
.215	122236-5
.225	122236-6
.235	122236-7
.245	122236-8
.255	122236-9
.265	122236-10
.275	122236-11
.285	122236-12
.295	122236-13
.305	122236-14
.315	122236-15
.325	122236-16

ITEM NUMBER	ITEM NUMBER
.345	122236-17
.355	122236-18
.365	122236-19
.375	122236-20
.385	122236-21
.395	122236-22
.405	122236-23
.415	122236-24
.425	122236-25
.435	122236-26
.445	122236-27
.455	122236-28
.465	122236-29
.475	122236-30
.485	122236-31
.495	122236-32
.505	122236-33
.546	122236-34

SPECIAL APPLICATION BLADES

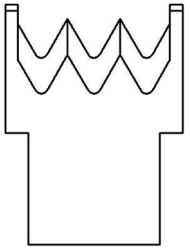
Lakes Precision, Inc. also provides blades for special applications. A few examples are shown here. For blades to meet your specific application please contact Lakes Precision, Inc.

- TC Coating Available -



122035-XX

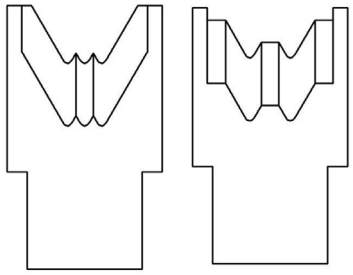
MUTLI-CONDUCTOR



122157-XX

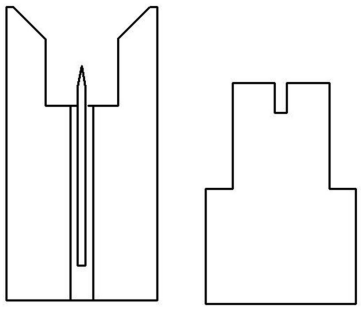
MULTI-CONDUCTOR

ITEM NUMBER	DESCRIPTION
122035-XX	2V TANGENT RADIUS "V" BLADE
122157-XX	3V TANGENT RADIUS "V" BLADE
122949-XX	3V STRIPPING & CUT BLADE
5-122180-XX	SLITTING BLOCK & PUSHER



122949-XX

MULTI-CONDUCTOR



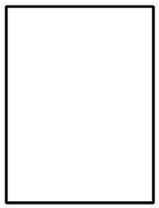
5-122180-XX

VARIABLE SPACERS

The wire end strip dimension is obtained by physically inserting spacers of different thickness in-between the blade bodies. The assembly is then held in place by set screws or other fastening devices.

This system involves measurement calculations in order to figure the correct spacer-blade combinations. Because of its inherent cumbersome nature, it is highly recommended that this setup be performed in anticipation to a scheduled production run.

To optimize equipment productivity, it is a good idea to have several sets of pre-assembled blade mounts ready for production schedules.



120145-XX

ITEM NUMBER	SIZE	DESCRIPTION
120145-1	.0310	SPACER
120145-2	.0620	SPACER
120145-3	.1245	SPACER
120145-4	.2500	SPACER
120145-5	.5000	SPACER
120145-6	1.000	SPACER

ITEM NUMBER	DESCRIPTION
5-120120	AM-1 SPACER SET
5-120121	AM-2 SPACER SET

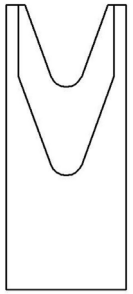
TANGENT RADIUS "V" STRIP BLADES

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.

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

- TC Coating Available -



66653

ITEM NUMBER	DESCRIPTION
66653-20	V012S TA-V
66653-21	V012L TA-V
66653-22	V022S TA-V
66653-23	V022L TA-V
66653-24	V034S TA-V
66653-25	V034L TA-V
66653-26	V042S TA-V
66653-27	V042L TA-V
66653-28	V052S TA-V
66653-29	V052L TA-V
66653-30	V062S TA-V
66653-31	V062L TA-V

ITEM NUMBER	DESCRIPTION
66653-32	V076S TA-V
66653-33	V076L TA-V
66653-34	V096S TA-V
66653-35	V096L TA-V
66653-36	V112S TA-V
66653-37	V112L TA-V
66653-38	V172A TA-V
66653-39	V172L TA-V
66653-40	V222A TA-V
66653-41	V222L TA-V
66653-42	V250A TA-V
66653-43	V350A TA-V

DIE TYPE BLADES

The die-type blade has a fixed shut height. The cutting edge is precisely drilled to an exact radius dimension for the conductor diameter. The insulation wall is contained in a counter-bore drilled around cutting edge.

This type of blade is the most exactly matched blade to the wire specification, giving a very precise insulation removal. This is excellent for removal of extremely thin insulation walls or where the outer jacket is oval shaped, and is also very useful for processing solid conductor insulated wire. Normally this is the blade of choice for SJT, SVT, SJO, coaxial cable outer jacket removal, and many round multi-conductor wires.

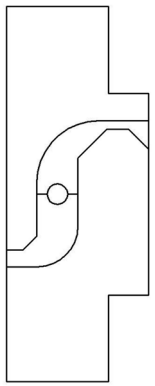
Die blades are manufactured to the exact wire specifications. Blades can be produced for most any wire.

- For a specific blade size or application, contact Lakes Precision, Inc. -

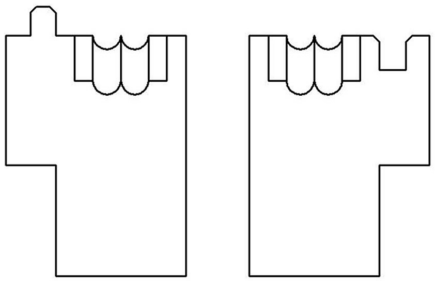
- TC Coating Available -

ITEM NUMBER	DESCRIPTION
A2-XXX-XXX	AM-2 DIE TYPE BLADES
123314-XX	AM-2 DIE TYPE BLADE

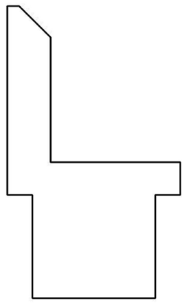
ITEM NUMBER	DESCRIPTION
123315-XX	AM-2 WIRE GUIDE



A2-XXX-XXX



123314-XX

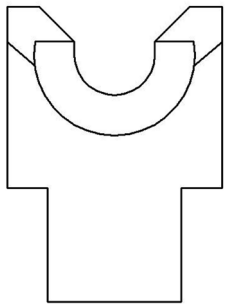


123315-XX

DIE TYPE BLADES

Die type blades are made for a specific wire sizes. The cutting edge is drilled to a specific size to closely match the conductor of the wire being processed. When the proper shut height is achieved, the blades will form a complete circle around the conductor, giving a very clean strip. Normally this is the blade of choice for SJT, SVT, SJO, and most round multi-conductor wires.

- TC Coating Available -



66649

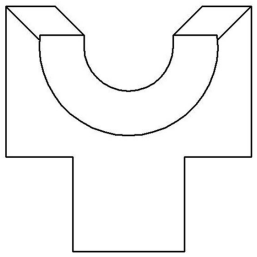
DIASIZE	ITEM NUMBER	DESCRIPTION
.140	66649-24	BI-PASS DIE BLADE
.156	66649-1	BI-PASS DIE BLADE
.187	66649-2	BI-PASS DIE BLADE
.193	66649-30	BI-PASS DIE BLADE
.205	66649-3	BI-PASS DIE BLADE
.221	66649-23	BI-PASS DIE BLADE
.224	66649-27	BI-PASS DIE BLADE
.234	66649-4	BI-PASS DIE BLADE
.242	66649-28	BI-PASS DIE BLADE
.250	66649-26	BI-PASS DIE BLADE
.266	66649-5	BI-PASS DIE BLADE
.272	66649-21	BI-PASS DIE BLADE
.281	66649-6	BI-PASS DIE BLADE
.299	66649-29	BI-PASS DIE BLADE
.307	66649-25	BI-PASS DIE BLADE

DIASIZE	ITEM NUMBER	DESCRIPTION
.312	66649-7	BI-PASS DIE BLADE
.323	66649-17	BI-PASS DIE BLADE
.332	66649-22	BI-PASS DIE BLADE
.343	66649-8	BI-PASS DIE BLADE
.358	66649-9	BI-PASS DIE BLADE
.366	66649-10	BI-PASS DIE BLADE
.375	66649-11	BI-PASS DIE BLADE
.386	66649-12	BI-PASS DIE BLADE
.397	66649-13	BI-PASS DIE BLADE
.406	66649-14	BI-PASS DIE BLADE
.421	66649-15	BI-PASS DIE BLADE
.437	66649-16	BI-PASS DIE BLADE
.462	66649-18	BI-PASS DIE BLADE
.478	66649-19	BI-PASS DIE BLADE
.515	66649-20	BI-PASS DIE BLADE

DIE TYPE BLADES

Die type blades are made for a specific wire sizes. The cutting edge is drilled to a specific size to closely match the conductor of the wire being processed. When the proper shut height is achieved, the blades will form a complete circle around the conductor, giving a very clean strip. Normally this is the blade of choice for SJT, SVT, SJO, and most round multi-conductor wires.

- TC Coating Available -



66652-XX

DIA SIZE	ITEM NUMBER	DESCRIPTION
.296	66652-26	BI-PASS DIE BLADE
.358	66652-1	BI-PASS DIE BLADE
.421	66652-2	BI-PASS DIE BLADE
.437	66652-29	BI-PASS DIE BLADE
.453	66652-3	BI-PASS DIE BLADE
.468	66652-4	BI-PASS DIE BLADE
.478	66652-5	BI-PASS DIE BLADE
.484	66652-6	BI-PASS DIE BLADE
.500	66652-7	BI-PASS DIE BLADE
.515	66652-8	BI-PASS DIE BLADE
.531	66652-9	BI-PASS DIE BLADE
.546	66652-10	BI-PASS DIE BLADE
.562	66652-11	BI-PASS DIE BLADE
.578	66652-12	BI-PASS DIE BLADE
.593	66652-13	BI-PASS DIE BLADE

DIA SIZE	ITEM NUMBER	DESCRIPTION
.609	66652-14	BI-PASS DIE BLADE
.625	66652-15	BI-PASS DIE BLADE
.640	66652-16	BI-PASS DIE BLADE
.671	66652-17	BI-PASS DIE BLADE
.687	66652-18	BI-PASS DIE BLADE
.703	66652-31	BI-PASS DIE BLADE
.718	66652-27	BI-PASS DIE BLADE
.750	66652-19	BI-PASS DIE BLADE
.797	66652-24	BI-PASS DIE BLADE
.828	66652-22	BI-PASS DIE BLADE
.844	66652-21	BI-PASS DIE BLADE
.875	66652-25	BI-PASS DIE BLADE
.905	66652-28	BI-PASS DIE BLADE
.968	66652-30	BI-PASS DIE BLADE
1.000	66652-23	BI-PASS DIE BLADE

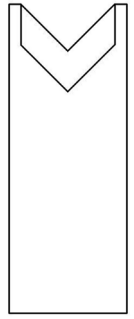
TANGENT ANGLE CUT-OFF BLADES

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

Characteristics: Sharp edges cut by slicing, creating a gradual cut. This produces less deformation of the material being cut. Cutting edges must be able to by-pass each other. This type cut-off is best used with circular shaped wire.

- TC Coating Available -

ITEM NUMBER	DESCRIPTION
66653-8	THICK CLA CUT-OFF
66653-9	THICK WSCA CUT-OFF
66653-10	THICK SCA CUT-OFF
66653-11	THIN CL CUT-OFF
66653-12	THIN WSC CUT-OFF
66653-13	THIN SC CUT-OFF



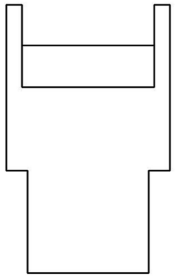
66653-XX
CL / CLA

COLLINEAR ANGLE CUT-OFF BLADES

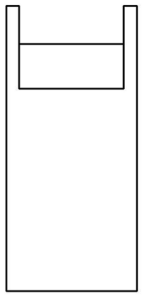
Sharp edge is ground to a flat collinear angle.

Characteristics: Sharp edges cut by shearing action. This class of blade was designed to allow multiple conductor wire to be processed without deforming the wire. The main advantage of this class is the ability to process many different wire gauges with the same blades.

- TC Coating Available -



66653-XX
WSC / WSCA



66653-XX
SC / SCA

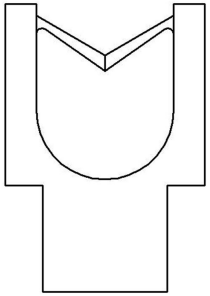
WIDE ENTRY ANGLE CUT-OFF

The sharp edge is ground at an angle that results in a "V" opening above 90 degrees. This type of blade, when closed, presents a diamond shaped edge profile.

Characteristics: Sharp edge cut by slicing, creating a gradual cut. The wide angle allows for a wider range of wire sizes to be cut with the same blades. This type of cut-off is best used with circular shaped wire.

- TC Coating Available -

ITEM NUMBER	THICKNESS	ANGLE ENTRY	DESCRIPTION
66648-1	.1245	120	WE-A CUT-OFF
66648-2	.1870	120	WE-A CUT-OFF



66648-XX

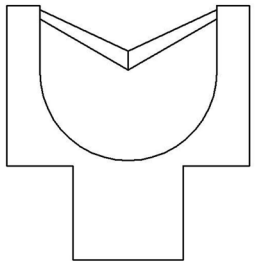
WIDE ENTRY ANGLE CUT-OFF

The sharp edge is ground at an angle that results in a "V" opening above 90 degrees. This type of blade, when closed, presents a diamond shaped edge profile.

Characteristics: Sharp edge cut by slicing, creating a gradual cut. The wide angle allows for a wider range of wire sizes to be cut with the same blades. This type of cut-off is best used with circular shaped wire.

- TC Coating Available -

ITEM NUMBER	THICKNESS	ANGLE ENTRY	DESCRIPTION
66651-1	--------	130	WE-A CUT-OFF

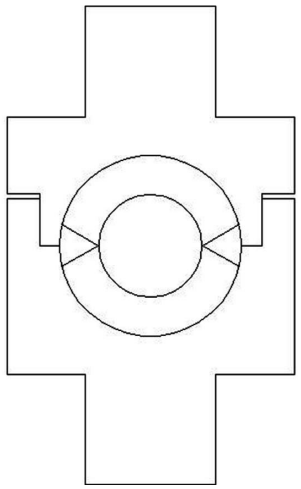


66651

DIE TYPE BLADES

Die type blades are made for a specific wire sizes. The cutting edge is drilled to a specific size to closely match the conductor of the wire being processed. When the proper shut height is achieved, the blades will form a complete circle around the conductor, giving a very clean strip. Normally this is the blade of choice for SJT, SVT, SJO, and most round multi-conductor wires.

- TC Coating Available -



81111-XX

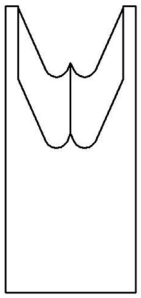
DIA SIZE	ITEM NUMBER
.087	81111-49
.093	81111-51
.098	81111-48
.118	81111-50
.135	81111-47
.149	81111-45
.156	81111-1
.172	81111-46
.187	81111-2
.205	81111-3
.218	81111-35
.228	81111-4
.234	81111-5
.250	81111-6
.261	81111-43
.266	81111-7
.281	81111-8

DIA SIZE	ITEM NUMBER
.290	81111-39
.302	81111-40
.312	81111-9
.316	81111-44
.323	81111-38
.332	81111-37
.343	81111-10
.358	81111-11
.366	81111-12
.375	81111-13
.386	81111-14
.397	81111-15
.406	81111-16
.421	81111-17
.437	81111-18
.453	81111-19
.468	81111-20

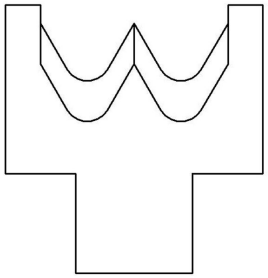
DIA SIZE	ITEM NUMBER
.478	81111-21
.484	81111-22
.500	81111-23
.515	81111-24
.531	81111-25
.543	81111-42
.546	81111-26
.562	81111-27
.578	81111-28
.593	81111-29
.609	81111-30
.625	81111-31
.640	81111-32
.671	81111-33
.687	81111-34
.734	81111-41
.750	81111-36

- FOR MORE INFORMATION ON THESE BLADES, PLEASE CONTACT LAKES PRECISION, INC.
- SEND WIRE SAMPLES TO LAKES PRECISION, INC.

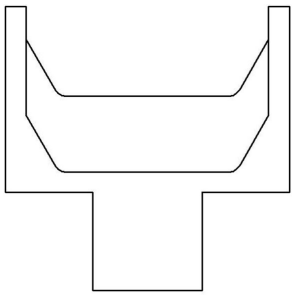
- TC Coating Available -



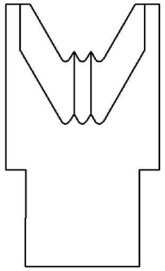
120488-XX



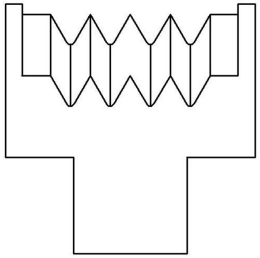
122450-XX



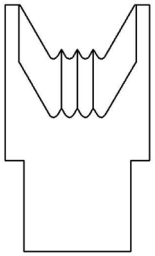
83698-XX



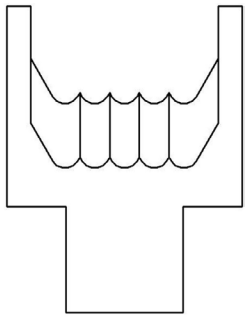
66654-XX



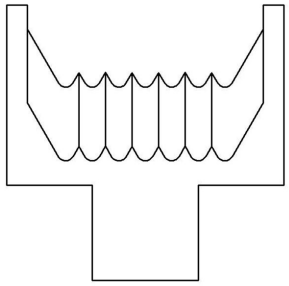
85380-XX



86766-XX



64340-XX



83697-XX

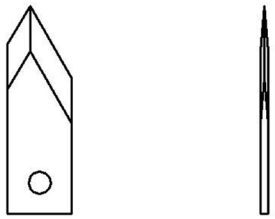
ITEM NUMBER	DESCRIPTION
124088-XX	MULTI CONDUCTOR 2V
122450-XX	MULTI CONDUCTOR 2V
83698-XX	MULTI CONDUCTOR TA-V
66654-XX	MULTI CONDUCTOR 3V
85380-XX	MULTI CONDUCTOR 4V
86766-XX	MULTI CONDUCTOR 4V
64340-XX	MULTI CONDUCTOR 5V
83697-XX	MULTI CONDUCTOR 7V

WIRE SLITTER

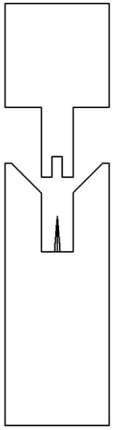
The wire slitter is used to slit multiple conductor wire, separating the individual conductors from each other. Wire slitters are fitted to the wire. For help in choosing the correct slitters for your application, please contact Lakes Precision, Inc.

- SEND WIRE SAMPLES TO LAKES PRECISION, INC.

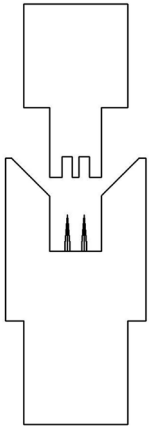
- TC Coating Available -



H-22896
SLITTER KNIFE



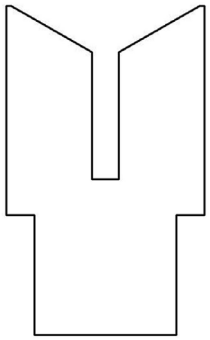
5-120495-XX
2 CONDUCTOR



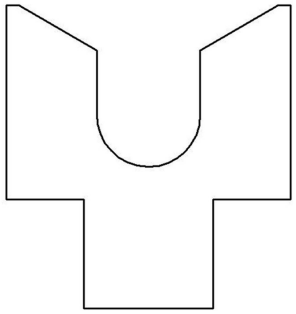
5-120497-XX
3 CONDUCTOR

WIRE GUIDES

Wire guides are used in conjunction with cut and strip blades to precisely guide the conductor into the strip area of the blade. This will help prevent the conductor from coming in contact with the cutting edges of the strip blades, preventing premature strip blade wear.



STYLE 1



STYLE 2

69402-XX

WIRE GUIDE INCH SIZE	ITEM NUMBER
.125	69402-52
.163	69402-51
.180	69402-54
.195	69402-49
.200	69402-32
.205	69402-50
.215	69402-48
.225	69402-42
.242	69402-47
.252	69402-39
.266	69402-28
.284	69402-31
.296	69402-41
.300	69402-30
.312	69402-12
.312	69402-40
.320	69402-46
.327	69402-64
.335	69402-43
.343	69402-4
.358	69402-6
.366	69402-29

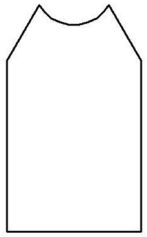
WIRE GUIDE INCH SIZE	ITEM NUMBER
.375	69402-3
.386	69402-7
.400	69402-4
.406	69402-5
.415	69402-37
.425	69402-58
.437	69402-2
.450	69402-18
.468	69402-19
.485	69402-53
.490	69402-45
.500	69402-8
.515	69402-20
.531	69402-27
.546	69402-15
.570	69402-33
.593	69402-13
.610	69402-22
.625	69402-1
.640	69402-10
.650	69402-23

WIRE GUIDE INCH SIZE	ITEM NUMBER
.670	69402-16
.687	69402-14
.703	69402-26
.710	69402-21
.720	69402-11
.750	69402-17
.780	69402-38
.800	69402-34
.810	69402-55
.830	69402-24
.845	69402-36
.880	69402-62
.925	69402-56
.932	69402-60
.950	69402-59
1.020	69402-35
1.055	69402-57
1.100	69402-25
1.156	69402-9
1.250	69402-61
1.290	69402-63

SPECIAL APPLICATION BLADES

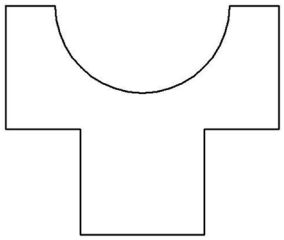
Lakes Precision, Inc. also provides blades for special applications. A few examples are shown here. For blades to meet your specific application please contact Lakes Precision, Inc.

- SEND CUSTOMER WIRE SAMPLE TO LAKES PRECISION, INC.



122045-XX

WIRE STOP



69403-XX

WIRE STOP

ITEM NUMBER	DESCRIPTION
122045-XX	WIRE STOP
69403-XX	WIRE STOP

DIE TYPE BLADES

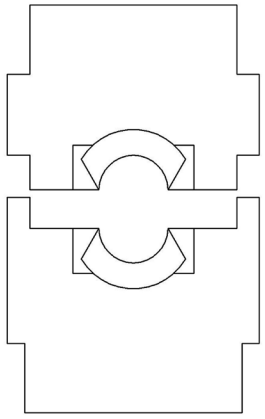
The die-type blade has a fixed shut height. The cutting edge is precisely drilled to an exact radius dimension for the conductor diameter. The insulation wall is contained in a counter-bore drilled around cutting edge.

This type of blade is the most exactly matched blade to the wire specification, giving a very precise insulation removal. This is excellent for removal of extremely thin insulation walls or where the outer jacket is oval shaped, and is also very useful for processing solid conductor insulated wire. Normally this is the blade of choice for SJT, SVT, SJO, coaxial cable outer jacket removal, and many round multi-conductor wires.

Die blades are manufactured to the exact wire specifications. Blades can be produced for most any wire.

- For a specific blade size or application, contact Lakes Precision, Inc. -

- TC Coating Available -



110251-XX

DIA SIZE	ITEM NUMBER
.082	110251-20
.089	110251-22
.149	110251-30
.177	110251-21
.187	110251-29
.191	110251-26
.246	110251-11
.266	110251-24
.281	110251-8
.296	110251-7
.312	110251-31
.323	110251-25

DIA SIZE	ITEM NUMBER
.343	110251-23
.359	110251-10
.397	110251-28
.406	110251-33
.437	110251-12
.453	110251-32
.468	110251-34
.484	110251-14
.500	110251-13
.531	110251-19
.562	110251-15
.578	110251-36

DIA SIZE	ITEM NUMBER
.593	110251-6
.609	110251-27
.625	110251-9
.672	110251-35
.734	110251-3
.796	110251-16
.828	110251-4
.859	110251-1
.875	110251-5
.906	110251-2
.921	110251-17
1.050	110251-18

DIE TYPE BLADES

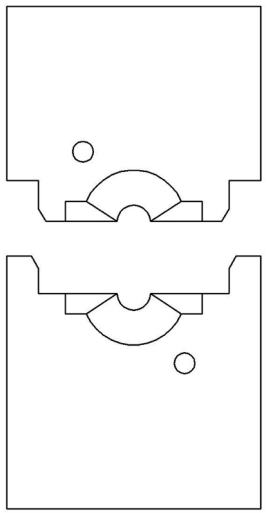
The die-type blade has a fixed shut height. The cutting edge is precisely drilled to an exact radius dimension for the conductor diameter. The insulation wall is contained in a counter-bore drilled around cutting edge.

This type of blade is the most exactly matched blade to the wire specification, giving a very precise insulation removal. This is excellent for removal of extremely thin insulation walls or where the outer jacket is oval shaped, and is also very useful for processing solid conductor insulated wire. Normally this is the blade of choice for SJT, SVT, SJO, coaxial cable outer jacket removal, and many round multi-conductor wires.

Die blades are manufactured to the exact wire specifications. Blades can be produced for most any wire.

- For a specific blade size or application, contact Lakes Precision, Inc. -

- TC Coating Available -



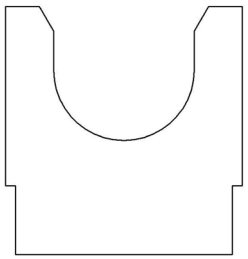
LPI-282-XX

ITEM NUMBER	MM DIA SIZE	DESCRIPTION
LPI282-12	0.5	DIE TYPE BLADE
LPI282-5	1.4	DIE TYPE BLADE
LPI282-13	3.3	DIE TYPE BLADE
LPI282-14	3.5	DIE TYPE BLADE
LPI282-21	4.0	DIE TYPE BLADE
LPI282-15	4.5	DIE TYPE BLADE
LPI282-2	4.8	DIE TYPE BLADE
LPI282-3	4.9	DIE TYPE BLADE
LPI282-4	5.0	DIE TYPE BLADE
LPI282-1	5.2	DIE TYPE BLADE
LPI282-18	5.25	DIE TYPE BLADE

ITEM NUMBER	MM DIA SIZE	DESCRIPTION
LPI282-19	5.4	DIE TYPE BLADE
LPI282-16	6.5	DIE TYPE BLADE
LPI282-6	8.3	DIE TYPE BLADE
LPI282-7	8.4	DIE TYPE BLADE
LPI282-8	8.5	DIE TYPE BLADE
LPI282-9	8.6	DIE TYPE BLADE
LPI282-10	8.7	DIE TYPE BLADE
LPI282-11	8.8	DIE TYPE BLADE
LPI282-20	13.8	DIE TYPE BLADE
LPI282-22	14.0	DIE TYPE BLADE
LPI282-17	15.0	DIE TYPE BLADE

WIRE GUIDES

Wire guides are used in conjunction with cut and strip blades to precisely guide the conductor into the strip area of the blade. This will help prevent the conductor from coming in contact with the cutting edges of the strip blades, preventing premature strip blade wear.



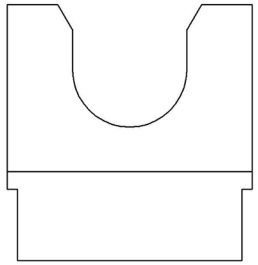
110252-XX

WIRE GUIDE DIA SIZE	ITEM NUMBER
0.236	110252-24
0.312	110252-12
0.324	110252-10
0.366	110252-23
0.386	110252-7
0.406	110252-8
0.412	110252-26
0.438	110252-9
0.470	110252-20
0.486	110252-25
0.516	110252-11
0.550	110252-19
0.566	110252-27
0.580	110252-22
0.656	110252-13
0.702	110252-5
0.750	110252-14
0.790	110252-21

WIRE GUIDE DIA SIZE	ITEM NUMBER
0.810	110252-35
0.820	110252-28
0.842	110252-6
0.906	110252-4
0.940	110252-29
0.950	110252-34
0.984	110252-2
1.000	110252-31
1.020	110252-1
1.040	110252-16
1.090	110252-15
1.112	110252-33
1.136	110252-3
1.150	110252-32
1.230	110252-17
1.252	110252-30
1.430	110252-18

WIRE GUIDES

Wire guides are used in conjunction with cut and strip blades to precisely guide the conductor into the strip area of the blade. This will help prevent the conductor from coming in contact with the cutting edges of the strip blades, preventing premature strip blade wear.



119224-XX

ITEM NUMBER	WIRE GUIDE DIA SIZE	DESCRIPTION
119224-2	0.38	WG WITH STEP
119224-1	0.47	WG WITH STEP
119224-3	0.80	WG WITH STEP
119224-4	1.06	WG WITH STEP

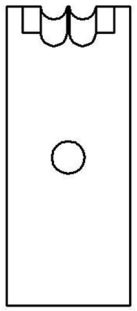
COLLINEAR RADIUS TYPE

The sharp edge is ground to a half circle whose radius approximates awg wire size. Shearing edge is ground to a straight edge. This type of blade, when closed to shut height, forms a perfect circle profile.

Advantages: This type of blade is excellent for precise and clean jacket removal because it exactly matches conductor gauge. Excellent for thin-wall cross-link PVC and most applications where precise jacket removal around the conductor is required, especially with layered coverings such as fiber over plastic, plastic over shields, etc.

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

- TC Coating Available -



123028-XX
2 CONDUCTOR

ITEM NUMBER	DESCRIPTION
123028-XX	AM-015 CL-R STRIP

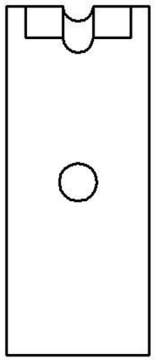
COLLINEAR RADIUS TYPE

The sharp edge is ground to a half circle whose radius approximates awg wire size. Shearing edge is ground to a straight edge. This type of blade, when closed to shut height, forms a perfect circle profile.

Advantages: This type of blade is excellent for precise and clean jacket removal because it exactly matches conductor gauge. Excellent for thin-wall cross-link PVC and most applications where precise jacket removal around the conductor is required, especially with layered coverings such as fiber over plastic, plastic over shields, etc.

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

- TC Coating Available -



122594

DIA SIZE	ITEM NUMBER
.0118	122594-32
.0158	122594-33
.0196	122594-29
.0274	122594-1
.0314	122594-2
.0354	122594-3
.0394	122594-4
.0432	122594-5
.0472	122594-6
.0512	122594-7
.0552	122594-8
.0590	122594-9
.0630	122594-10
.0670	122594-11
.0708	122594-12
.0748	122594-13
.0788	122594-14

DIA SIZE	ITEM NUMBER
.0826	122594-15
.0866	122594-16
.0906	122594-17
.0944	122594-18
.0984	122594-19
.1024	122594-20
.1062	122594-21
.1102	122594-22
.1142	122594-23
.1180	122594-24
.1220	122594-25
.1260	122594-26
.1300	122594-27
.1338	122594-28
.1456	122594-31
.1574	122594-30

COLLINEAR ANGLE STRIP

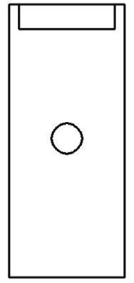
Sharp edge is ground to a flat collinear angle.

This class of blade was designed to allow multiple conductor wire to be processed with one set of blades. This class is also used in many rotary strip models. The main advantage of this class is the ability to process many different wire gauges with the same blades, (dependent upon machine function).

There will always be a percentage of insulation tear with this class of blade. This class does not work well with thin wall insulation.

- TC Coating Available -

ITEM NUMBER	DESCRIPTION
122590	AM-015 STRAIGHT EDGE STRIP



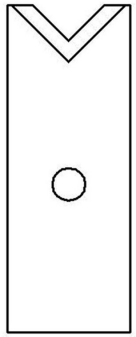
UNIVERSAL STRIP BLADES - 20 DEGREE

The sharp edge is ground at an angle that results in a "V" opening of exactly 90 degrees.

Characteristics: 90 degree angle is widely accepted as the best entry angle to use for processing a wide range of wire sizes using the same blade setup. Most of the time, this class of blade incorporates a sharp edge ground to a very small or non-existing radius. It works sufficiently for most of standard wall insulation but is marginal for thin wall, cross-linked PVC, very rubbery insulations, woven fiber or thin-walled multi-conductors.

- TC Coating Available -

ITEM NUMBER	DESCRIPTION
122589	UN-V STRIP (20 DEGREE)



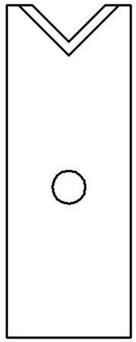
UNIVERSAL STRIP BLADES - 30 DEGREE

The sharp edge is ground at an angle that results in a "V" opening of exactly 90 degrees.

Characteristics: 90 degree angle is widely accepted as the best entry angle to use for processing a wide range of wire sizes using the same blade setup. Most of the time, this class of blade incorporates a sharp edge ground to a very small or non-existing radius. It works sufficiently for most of standard wall insulation but is marginal for thin wall, cross-linked PVC, very rubbery insulations, woven fiber or thin-walled multi-conductors.

- TC Coating Available -

ITEM NUMBER	DESCRIPTION
122702	UN-V STRIP (30 DEGREE)



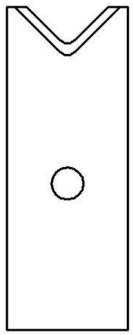
TANGENT RADIUS "V" STRIP BLADES

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.

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

- TC Coating Available -



122842-XX

ITEM NUMBER	DESCRIPTION
122842-XX	AM-015 TA-V STRIP

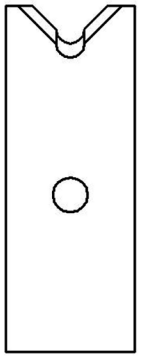
TRU-RADIUS STRIP BLADE

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.

- TC Coating Available -



122592

DIA SIZE	ITEM NUMBER
.0158	122592-29
.0196	122592-33
.0236	122592-30
.0276	122592-34
.0314	122592-28
.0354	122592-31
.0394	122592-1
.0432	122592-2
.0472	122592-3
.0512	122592-4
.0552	122592-5
.0590	122592-6
.0630	122592-7
.0670	122592-8
.0708	122592-9
.0748	122592-10
.0788	122592-11
.0812	122592-32

DIA SIZE	ITEM NUMBER
.0826	122592-12
.0866	122592-13
.0906	122592-14
.0944	122592-15
.0984	122592-16
.102	122592-17
.1062	122592-18
.1102	122592-19
.1142	122592-20
.1180	122592-21
.1220	122592-22
.1260	122592-23
.1300	122592-24
.1338	122592-25
.1575	122592-26
.1654	122592-35
.180	122592-27

DRILLED DIE TYPE BLADES

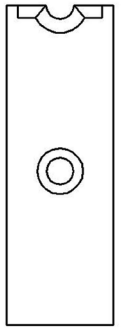
The die-type blade has a fixed shut height. The cutting edge is precisely drilled to an exact radius dimension for the conductor diameter. The insulation wall is contained in a counter-bore drilled around cutting edge.

This type of blade is the most exactly matched blade to the wire specification, giving a very precise insulation removal. This is excellent for removal of extremely thin insulation walls or where the outer jacket is oval shaped, and is also very useful for processing solid conductor insulated wire. Normally this is the blade of choice for SJT, SVT, SJO, coaxial cable outer jacket removal, and many round multi-conductor wires.
Die blades are manufactured to the exact wire specifications. Blades can be produced for most any wire.

- For a specific blade size or application, contact Lakes Precision, Inc. -

- TC Coating Available -

ITEM NUMBER	DESCRIPTION
122972-XX	AM ALL-ROUND DRILLED DIE BLADE



122972

ARTOS AM ALL-ROUND MACHINE SERIES

COLLINEAR ANGLE ROTARY STRIP BLADES CLASS: CL-A

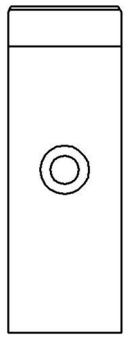
COLLINEAR ANGLE ROTARY BLADES

Sharp edge is ground to a flat collinear angle.

Characteristics: Sharp edges cut by shearing action. This class of blade was designed to allow multiple conductor wire to be processed without deforming the wire. The main advantage of this class is the ability to process many different wire gauges with the same blades.

- TC Coating Available -

ITEM NUMBER	DESCRIPTION
122560	CL-A / ROTARY STRIP



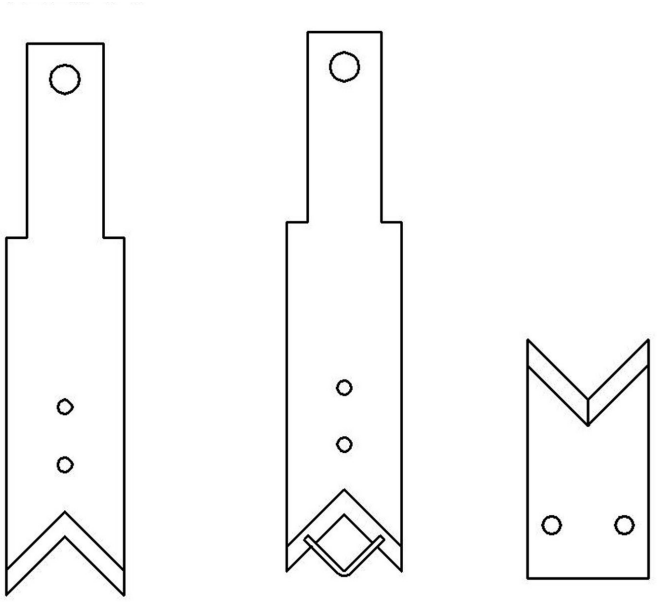
122560

UNIVERSAL STRIP BLADES

The sharp edge is ground at an angle that results in a "V" opening of exactly 90 degrees.

Characteristics: 90 degree angle is widely accepted as the best entry angle to use for processing a wide range of wire sizes using the same blade setup. Most of the time, this class of blade incorporates a sharp edge ground to a very small or non-existing radius. It works sufficiently for most of standard wall insulation but is marginal for thin wall, cross-linked PVC, very rubbery insulations, woven fiber or thin-walled multi-conductors.

- TC Coating Available -



122036 114988 114987

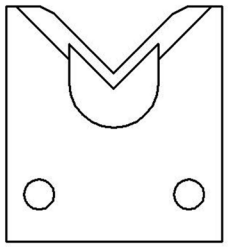
ITEM NUMBER	DESCRIPTION
122036	CS-37 UPPER BLADE (MOVABLE)
114987	CS-36 UPPER BLADE (MOVABLE)
114988	CS-36 / CS-37 LOWER BLADE (FIXED)

UNIVERSAL STRIP BLADES

The sharp edge is ground at an angle that results in a "V" opening of exactly 90 degrees.

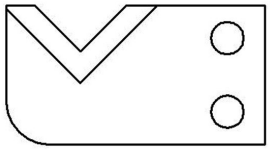
Characteristics: 90 degree angle is widely accepted as the best entry angle to use for processing a wide range of wire sizes using the same blade setup. Most of the time, this class of blade incorporates a sharp edge ground to a very small or non-existing radius. It works sufficiently for most of standard wall insulation but is marginal for thin wall, cross-linked PVC, very rubbery insulations, woven fiber or thin-walled multi-conductors.

- TC Coating Available -



122159

ITEM NUMBER	DESCRIPTION
122159-1	LONG BLADE
122159-2	SHORT BLADE

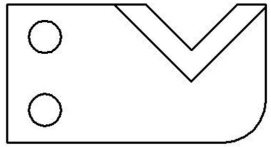


122235-1
LEFT BLADE

ITEM NUMBER	DESCRIPTION
122235-1	LEFT BLADE
122235-2	RIGHT BLADE

122235-XX

(1) 122235-1 & (1) 122235-2 = PAIR



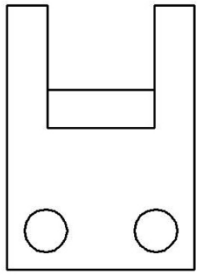
122235-2
RIGHT BLADE

COLLINEAR ANGLE CUT-OFF BLADES

Sharp edge is ground to a flat collinear angle.

Characteristics: Sharp edges cut by shearing action. This class of blade was designed to allow multiple conductor wire to be processed without deforming the wire. The main advantage of this class is the ability to process many different wire gauges with the same blades.

- TC Coating Available -



122462

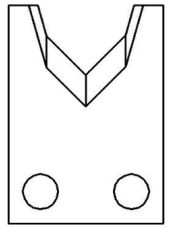
ITEM NUMBER	MARK	DESCRIPTION
122462	----------	CL-A CUT-OFF

UNIVERSAL STRIP BLADES

The sharp edge is ground at an angle that results in a "V" opening of exactly 90 degrees.

Characteristics: 90 degree angle is widely accepted as the best entry angle to use for processing a wide range of wire sizes using the same blade setup. Most of the time, this class of blade incorporates a sharp edge ground to a very small or non-existing radius. It works sufficiently for most of standard wall insulation but is marginal for thin wall, cross-linked PVC, very rubbery insulations, woven fiber or thin-walled multi-conductors.

ITEM NUMBER	OEM #	DESCRIPTION
122282-1	LB-1253	NON-COATED UN-V
122282-2	LB-1725	TIN COATED UN-V
122282-4	------	CARBIDE
122282-5	------	TITANIUM CARBONITRIDE



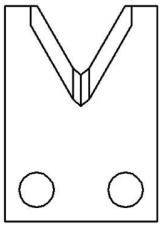
122282

UNI-V UNIVERSAL STRIP BLADE

The sharp edge is ground to an arc that has a small radius.

The entry angle lines meet the arc at a tangent point. Unique to this from is an auxiliary angle that intersects the entry angle. This results in greater insulation penetration and a better strip. This patented blade type allows wire sizes from 26 awg to 10 awg to be processed using a single set of blades.

ITEM NUMBER	DESCRIPTION
122283-1	NON-COATED UNI-V 30 DEGREE
122283-2	TIN COATED UNI-V 30 DEGREE
122283-3	NON-COATED UNI-V 20 DEGREE
122283-4	TIN COATING UNI-V 20 DEGREE



122283

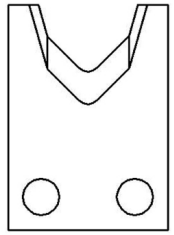
TANGENT RADIUS "V" STRIP BLADES

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.

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

- TC Coating Available -



123022-XX

AWG SIZE	ITEM NUMBER	DESCRIPTION
8	123022-1	IDEAL / ARTOS TA-V
10	123022-2	IDEAL / ARTOS TA-V
12	123022-3	IDEAL / ARTOS TA-V
14	123022-4	IDEAL / ARTOS TA-V
16	123022-5	IDEAL / ARTOS TA-V
18	123022-6	IDEAL / ARTOS TA-V
20	123022-7	IDEAL / ARTOS TA-V
22	123022-8	IDEAL / ARTOS TA-V
24 / 26 / 28	123022-9	IDEAL / ARTOS TA-V

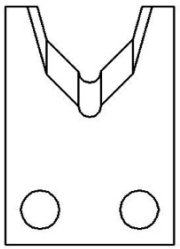
TRU-RADIUS STRIP BLADE

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.

- TC Coating Available -



122324

DIA SIZE	ITEM NUMBER	DESCRIPTION
0.4	122324-26	IDEAL / ARTOS TR-V
0.5	122324-7	IDEAL / ARTOS TR-V
0.6	122324-3	IDEAL / ARTOS TR-V
0.7	122324-25	IDEAL / ARTOS TR-V
0.9	122324-12	IDEAL / ARTOS TR-V
1.0	122324-9	IDEAL / ARTOS TR-V
1.1	122324-21	IDEAL / ARTOS TR-V
1.2	122324-8	IDEAL / ARTOS TR-V
1.3	122324-11	IDEAL / ARTOS TR-V
1.4	122324-22	IDEAL / ARTOS TR-V
1.5	122324-14	IDEAL / ARTOS TR-V
1.6	122324-1	IDEAL / ARTOS TR-V
1.7	122324-5	IDEAL / ARTOS TR-V
1.8	122324-29	IDEAL / ARTOS TR-V
1.9	122324-2	IDEAL / ARTOS TR-V
2.0	122324-15	IDEAL / ARTOS TR-V
2.2	122324-23	IDEAL / ARTOS TR-V
2.3	122324-32	IDEAL / ARTOS TR-V

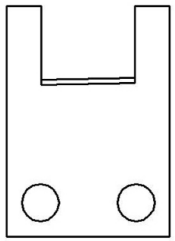
DIA SIZE	ITEM NUMBER	DESCRIPTION
2.4	122324-6	IDEAL / ARTOS TR-V
2.5	122324-16	IDEAL / ARTOS TR-V
2.6	122324-4	IDEAL / ARTOS TR-V
2.8	122324-27	IDEAL / ARTOS TR-V
3.0	122324-17	IDEAL / ARTOS TR-V
3.1	122324-28	IDEAL / ARTOS TR-V
3.2	122324-13	IDEAL / ARTOS TR-V
3.3	122324-30	IDEAL / ARTOS TR-V
3.5	122324-18	IDEAL / ARTOS TR-V
3.7	122324-34	IDEAL / ARTOS TR-V
4.0	122324-19	IDEAL / ARTOS TR-V
4.4	122324-10	IDEAL / ARTOS TR-V
4.5	122324-20	IDEAL / ARTOS TR-V
4.6	122324-33	IDEAL / ARTOS TR-V
4.8	122324-36	IDEAL / ARTOS TR-V
5.0	122324-24	IDEAL / ARTOS TR-V
5.2	122324-31	IDEAL / ARTOS TR-V
5.5	122324-35	IDEAL / ARTOS TR-V

COLLINEAR ANGLE CUT-OFF BLADES

Sharp edge is ground to a flat collinear angle.

Characteristics: Sharp edges cut by shearing action. This class of blade was designed to allow multiple conductor wire to be processed without deforming the wire. The main advantage of this class is the ability to process many different wire gauges with the same blades.

- TC Coating Available -



123255

ITEM NUMBER	DESCRIPTION
123255	CL-A CUT-OFF