



LAKES PRECISION^{INC.}

Your Global Source for Wire Processing Perishable Tooling

MAKFIL MACHINE SERIES

THIS SECTION CONTAINS BLADES FOR THE FOLLOWING MACHINE SERIES:

□ TS-200

□ LA PRIMA MODEL MACHINE SERIES

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MAKFIL TS-200 MACHINE SERIES

COLLINEAR ANGLE CUT-OFF BLADES CLASS: CL-A

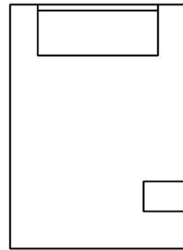


COLLINEAR ANGLE CUT-OFF BLADES

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 inherent blade longevity. This type of blade is used with collinear radius strip blades.

- *TC Coating Available* -



122492

| ITEM NUMBER | OEM # | DESCRIPTION |
|-------------|-------|------------------------|
| 122492 | 1470 | CL-R NON-CARBIDE BLADE |

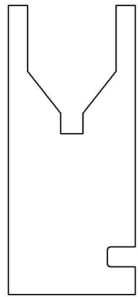
MAKFIL TS-200 MACHINE SERIES

WIRE GUIDES CLASS: WG



WIRE GUIDES

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.



122495-XX

| SLOT MM SIZE | OEM # | ITEM NUMBER |
|--------------|----------|-------------|
| 2.3 | ----- | 122495-66 |
| 2.6 | ----- | 122495-65 |
| 2.8 | ----- | 122495-62 |
| 3.0 | ----- | 122495-58 |
| 3.2 | ----- | 122495-59 |
| 3.4 | ----- | 122495-60 |
| 3.6 | ----- | 122495-61 |
| 3.7 | ----- | 122495-63 |
| 3.8 | ----- | 122495-1 |
| 4.0 | 10502600 | 122495-2 |
| 4.1 | ----- | 122495-67 |
| 4.2 | ----- | 122495-3 |
| 4.4 | ----- | 122495-4 |
| 4.6 | ----- | 122495-5 |
| 4.7 | ----- | 122492-50 |
| 4.8 | ----- | 122495-6 |
| 5.0 | 10502604 | 122495-7 |
| 5.2 | ----- | 122495-8 |
| 5.4 | ----- | 122495-9 |

| SLOT MM SIZE | OEM # | ITEM NUMBER |
|--------------|----------|-------------|
| 5.5 | 10502606 | 122495-68 |
| 5.6 | ----- | 122495-10 |
| 5.8 | ----- | 122495-11 |
| 6.0 | ----- | 122495-12 |
| 6.2 | ----- | 122495-13 |
| 6.3 | ----- | 122495-69 |
| 6.4 | ----- | 122495-14 |
| 6.5 | 10502610 | 122495-70 |
| 6.6 | ----- | 122495-15 |
| 6.75 | 10502611 | 122495-71 |
| 6.80 | ----- | 122495-16 |
| 7.0 | 10502612 | 122495-17 |
| 7.2 | ----- | 122495-18 |
| 7.24 | ----- | 122495-52 |
| 7.4 | ----- | 122495-19 |
| 7.6 | ----- | 122495-20 |
| 7.7 | ----- | 122495-64 |
| 7.75 | ----- | 122495-72 |
| 7.8 | ----- | 122495-21 |

| SLOT MM SIZE | OEM # | ITEM NUMBER |
|--------------|----------|-------------|
| 8.0 | 10502616 | 122495-22 |
| 8.2 | ----- | 122495-23 |
| 8.4 | ----- | 122495-24 |
| 8.6 | ----- | 122495-25 |
| 8.8 | ----- | 122495-26 |
| 9.0 | ----- | 122495-27 |
| 9.2 | ----- | 122495-28 |
| 9.4 | ----- | 122495-29 |
| 9.6 | ----- | 122495-30 |
| 9.8 | ----- | 122495-31 |
| 10.0 | ----- | 122495-32 |
| 10.3 | ----- | 122495-33 |
| 10.5 | ----- | 122495-34 |
| 10.8 | ----- | 122495-35 |
| 11.10 | ----- | 122495-37 |
| 11.35 | ----- | 122495-38 |
| 12.0 | ----- | 122495-42 |
| 12.2 | ----- | 122495-43 |
| 12.6 | ----- | 122495-45 |
| 15.0 | | 122495-57 |

• THREE LAKES, WI (715) 546-3070 • **CONTACT LAKES PRECISION** • EL PASO, TX (915) 856-6606 •

• EMAIL: BLADES@LAKESPRECISION.COM •

DIE TYPE BLADES

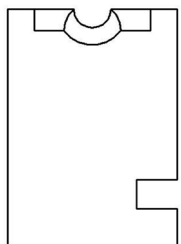
The die-type blade has a fixed shut height. The cutting edge is precisely drilled to an exact radius dimension for the conductor diameter. The insulation wall is contained in a counter-bore drilled around cutting edge.

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 --



122493-XX

| DIA MM SIZE | ITEM NUMBER | DIA MM SIZE | ITEM NUMBER | DIA MM SIZE | ITEM NUMBER | DIA MM SIZE | ITEM NUMBER | DIA MM SIZE | ITEM NUMBER |
|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| 1.0 | 122493-1 | 2.8 | 122493-19 | 4.6 | 122493-37 | 6.4 | 122493-55 | 8.2 | 122493-73 |
| 1.1 | 122493-2 | 2.9 | 122493-20 | 4.7 | 122493-38 | 6.5 | 122493-56 | 8.3 | 122493-74 |
| 1.2 | 122493-3 | 3.0 | 122493-21 | 4.8 | 122493-39 | 6.6 | 122493-57 | 8.4 | 122493-75 |
| 1.3 | 122493-4 | 3.1 | 122493-22 | 4.9 | 122493-40 | 6.7 | 122493-58 | 8.5 | 122493-76 |
| 1.4 | 122493-5 | 3.2 | 122493-23 | 5.0 | 122493-41 | 6.8 | 122493-59 | 8.6 | 122493-77 |
| 1.5 | 122493-6 | 3.3 | 122493-24 | 5.1 | 122493-42 | 6.9 | 122493-60 | 8.7 | 122493-78 |
| 1.6 | 122493-7 | 3.4 | 122493-25 | 5.2 | 122493-43 | 7.0 | 122493-61 | 8.75 | 122493-89 |
| 1.7 | 122493-8 | 3.5 | 122493-26 | 5.3 | 122493-44 | 7.1 | 122493-62 | 8.8 | 122493-79 |
| 1.8 | 122493-9 | 3.6 | 122493-27 | 5.4 | 122493-45 | 7.2 | 122493-63 | 8.9 | 122493-80 |
| 1.9 | 122493-10 | 3.7 | 122493-28 | 5.5 | 122493-46 | 7.3 | 122493-64 | 9.0 | 122493-81 |
| 2.0 | 122493-11 | 3.8 | 122493-29 | 5.6 | 122493-47 | 7.4 | 122493-65 | 9.1 | 122493-82 |
| 2.1 | 122493-12 | 3.9 | 122493-30 | 5.7 | 122493-48 | 7.5 | 122493-66 | 9.2 | 122493-83 |
| 2.2 | 122493-13 | 4.0 | 122493-31 | 5.8 | 122493-49 | 7.6 | 122493-67 | 9.3 | 122493-84 |
| 2.3 | 122493-14 | 4.1 | 122493-32 | 5.9 | 122493-50 | 7.7 | 122493-68 | 9.7 | 122493-85 |
| 2.4 | 122493-15 | 4.2 | 122493-33 | 6.0 | 122493-51 | 7.8 | 122493-69 | 10.0 | 122493-88 |
| 2.5 | 122493-16 | 4.3 | 122493-34 | 6.1 | 122493-52 | 7.9 | 122493-70 | 10.5 | 122493-86 |
| 2.6 | 122493-17 | 4.4 | 122493-35 | 6.2 | 122493-53 | 8.0 | 122493-71 | 11.25 | 122493-87 |
| 2.7 | 122493-18 | 4.5 | 122493-36 | 6.3 | 122493-54 | 8.1 | 122493-72 | | |

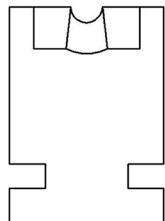
DIE TYPE BLADES

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.

- TC Coating Available -



123248

| DIA MM SIZE | ITEM NUMBER |
|-------------|-------------|
| 1.0 | 123248-1 |
| 1.1 | 123248-2 |
| 1.2 | 123248-3 |
| 1.3 | 123248-4 |
| 1.4 | 123248-5 |
| 1.5 | 123248-6 |
| 1.6 | 123248-7 |
| 1.7 | 123248-8 |
| 1.8 | 123248-9 |
| 1.9 | 123248-10 |
| 2.0 | 123248-11 |
| 2.1 | 123248-12 |
| 2.2 | 123248-13 |
| 2.3 | 123248-14 |
| 2.4 | 123248-15 |
| 2.5 | 123248-16 |

| DIA MM SIZE | ITEM NUMBER |
|-------------|-------------|
| 2.6 | 123248-17 |
| 2.7 | 123248-18 |
| 2.8 | 123248-19 |
| 2.9 | 123248-20 |
| 3.0 | 123248-21 |
| 3.1 | 123248-22 |
| 3.2 | 123248-23 |
| 3.3 | 123248-24 |
| 3.4 | 123248-25 |
| 3.5 | 123248-26 |
| 3.6 | 123248-27 |
| 3.7 | 123248-28 |
| 3.8 | 123248-29 |
| 3.9 | 123248-30 |
| 4.0 | 123248-31 |
| 4.1 | 123248-32 |

| DIA MM SIZE | ITEM NUMBER |
|-------------|-------------|
| 4.2 | 123248-33 |
| 4.3 | 123248-34 |
| 4.4 | 123248-35 |
| 4.5 | 123248-36 |
| 4.6 | 123248-37 |
| 4.7 | 123248-38 |
| 4.8 | 123248-39 |
| 4.9 | 123248-40 |
| 5.0 | 123248-41 |
| 5.1 | 123248-42 |
| 5.2 | 123248-43 |
| 5.3 | 123248-44 |
| 5.4 | 123248-45 |
| 5.5 | 123248-46 |
| 5.6 | 123248-47 |
| 5.7 | 123248-48 |

| DIA MM SIZE | ITEM NUMBER |
|-------------|-------------|
| 5.8 | 123248-49 |
| 5.9 | 123248-50 |
| 6.0 | 123248-51 |
| 6.1 | 123248-52 |
| 6.2 | 123248-53 |
| 6.3 | 123248-54 |
| 6.4 | 123248-55 |
| 6.5 | 123248-56 |
| 6.6 | 123248-57 |
| 6.7 | 123248-58 |
| 6.8 | 123248-59 |
| 6.9 | 123248-60 |
| 7.0 | 123248-61 |
| 7.1 | 123248-62 |
| 7.2 | 123248-63 |
| 7.3 | 123248-64 |

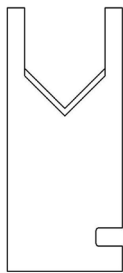
| DIA MM SIZE | ITEM NUMBER |
|-------------|-------------|
| 7.4 | 123248-65 |
| 7.5 | 123248-66 |
| 7.6 | 123248-67 |
| 7.7 | 123248-68 |
| 7.8 | 123248-6 |
| 7.9 | 123248-70 |
| 8.0 | 123248-71 |
| 8.1 | 123248-72 |
| 8.2 | 123248-73 |
| 8.3 | 123248-74 |
| 8.4 | 123248-75 |
| 8.5 | 123248-76 |
| 8.6 | 123248-77 |
| 8.7 | 123248-78 |
| 8.8 | 123248-79 |

UNIVERSAL CUT-OFF BLADES

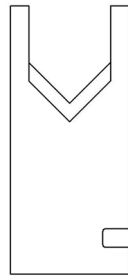
The sharp edge is ground to a radius size. The entry angle lines meet the radius at a tangent point. This type of blade, when closed, presents a diamond shaped edge profile.

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.

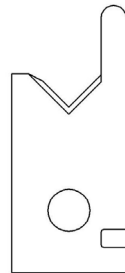
- TC Coating Available -



122959



123771



122496

| ITEM NUMBER | OEM # | DESCRIPTION |
|-------------|-------|--------------------------|
| 123771 | ----- | THICK STYLE UN-V CUT OFF |
| 122496 | 2283 | UN-V CUT-OFF |
| 122959 | 1412 | UN-V CUT-OFF |

MAKFIL TS-200 MACHINE SERIES

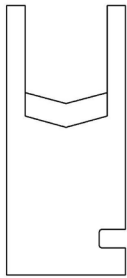
WIDE ENTRY ANGLE CUT-OFF BLADES CLASS: WE-A

WIDE ENTRY ANGLE

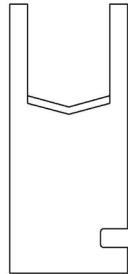
The sharp edge is ground at an angle that results in a “V” opening above 90 degrees.

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).

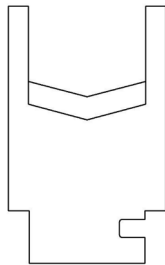
- TC Coating Available -



122494



122491



122947

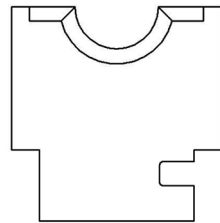
| ITEM NUMBER | OEM # | ENTRY ANGLE | DESCRIPTION |
|-------------|-------|-------------|---------------|
| 122491 | 1413 | 150 | THIN CUT-OFF |
| 122494 | 10055 | 150 | THICK CUT-OFF |
| 122947 | 1471 | 150 | WE-A CUT-OFF |

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.

- TC Coating Available -



123772

| DIA MM SIZE | ITEM NUMBER | DESCRIPTION |
|-------------|--------------|-------------------|
| 10.20 | 123772-10.20 | DRILLED DIE BLADE |
| 12.00 | 123772-12.0 | DRILLED DIE BLADE |

MAKFIL LA PRIMA MODEL MACHINE SERIES

TANGENT RADIUS “V” CUT / STRIP BLADES CLASS: TA-V

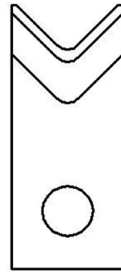
TANGENT RADIUS “V” CUT / STRIP BLADES

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 -



123496-XX

| ITEM NUMBER | DIA MM SIZE | DESCRIPTION |
|-------------|-------------|------------------|
| 123496-0.1 | 0.1 | TA-V CUT / STRIP |
| 123496-0.3 | 0.3 | TA-V CUT / STRIP |
| 123496-0.6 | 0.6 | TA-V CUT / STRIP |
| 123496-2.6 | 2.6 | TA-V CUT / STRIP |
| 123496-4.5 | 4.5 | TA-V CUT / STRIP |