



LAKES PRECISION^{INC.}

Your Global Source for Wire Processing Perishable Tooling

METZNER MACHINE SERIES

THIS SECTION CONTAINS BLADES FOR THE FOLLOWING MACHINE SERIES:

- AM-130 / 150
- AM-180
- ST-OB 150 / 30 / 400
- METZNER MACHINE SERIES

Your Global Source for Wire Processing Perishable Tooling

www.lakesprecision.com

METZNER AM-130 / 150 MACHINE SERIES

DRILLED DIE TYPE BLADES

DIE TYPE BLADES

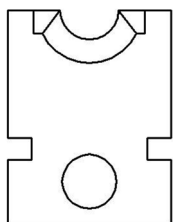
The die-type blade has a fixed shut height. The cutting edge is precisely drilled to an exact radius dimension for the conductor diameter. The insulation wall is contained in a counter-bore drilled around cutting edge.

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* -



122892-XX

MARK	ITEM NUMBER
0.7	122892-1
0.8	122892-2
0.9	122892-3
1.0	122892-4
1.1	122892-5
1.2	122892-6
1.3	122892-7
1.4	122892-8
1.5	122892-9
1.6	122892-10
1.7	122892-11
1.8	122892-12
1.9	122892-13
2.0	122892-14
2.1	122892-15

MARK	ITEM NUMBER
2.2	122892-16
2.3	122892-17
2.4	122892-18
2.5	122892-19
2.6	122892-20
2.7	122892-21
2.8	122892-22
2.9	122892-23
3.0	122892-24
3.1	122892-25
3.2	122892-26
3.3	122892-27
3.4	122892-28
3.5	122892-29
3.6	122892-30

METZNER AM-130 / 150 MACHINE SERIES

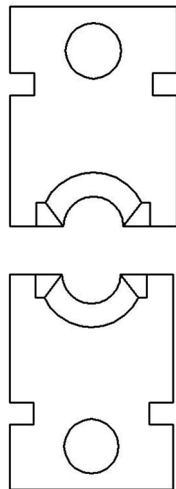
DRILLED DIE TYPE BLADES

- ADDITIONAL PART NUMBER'S ON SUCCEEDING PAGE -

- THREE LAKES, WI (715) 546-3070 • CONTACT LAKES PRECISION • EL PASO, TX (915) 856-6606 •
- EMAIL: BLADES@LAKESPRECISION.COM •

METZNER AM-130 / 150 MACHINE SERIES

DRILLED DIE TYPE BLADES ADDITIONAL PART NUMBER'S



122892-XX

MARK	ITEM NUMBER
3.7	122892-31
3.8	122892-32
3.9	122892-33
4.0	122892-34
4.1	122892-35
4.2	122892-36
4.3	122892-37
4.4	122892-38
4.5	122892-39
4.6	122892-40
4.7	122892-41
4.8	122892-42
4.9	122892-43
5.0	122892-44
5.1	122892-45
5.2	122892-46
5.3	122892-47
5.4	122892-48
5.5	122892-49
5.6	122892-50
5.7	122892-51
5.8	122892-52
5.9	122892-53
6.0	122892-54

MARK	ITEM NUMBER
6.1	122892-55
6.2	122892-56
6.3	122892-57
6.4	122892-58
6.5	122892-59
6.6	122892-60
6.7	122892-61
6.8	122892-62
6.9	122892-63
7.0	122892-64
7.1	122892-65
7.2	122892-66
7.3	122892-67
7.4	122892-68
7.5	122892-69
7.6	122892-70
7.7	122892-80
7.8	122892-81
7.9	122892-82
8.0	122892-83
8.1	122892-84
8.2	122892-85
8.3	122892-86
8.4	122892-87

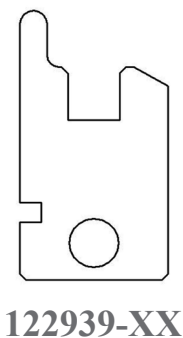
MARK	ITEM NUMBER
8.5	122892-88
8.6	122892-89
8.7	122892-90
8.8	122892-91
8.9	122892-92
9.0	122892-93
9.1	122892-94
9.2	122892-95
9.3	122892-96
9.4	122892-97
9.5	122892-98
9.6	122892-99
9.7	122892-100
9.8	122892-101
9.9	122892-102
10.0	122892-103
10.8	122892-71
10.9	122892-72
11.0	122892-73
11.1	122892-74
11.2	122892-75
13.0	122892-104
13.1	122892-105
13.2	122892-106

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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.



122939-XX

MARK	ITEM NUMBER
1.0	122939-1
1.1	122939-2
1.2	122939-3
1.3	122939-4
1.4	122939-5
1.5	122939-6
1.6	122939-7
1.7	122939-8
1.8	122939-9
1.9	122939-10
2.0	122939-11
2.1	122939-12
2.2	122939-13
2.3	122939-14
2.4	122939-15
2.5	122939-16
2.6	122939-17
2.7	122939-18
2.8	122939-19
2.9	122939-20
3.0	122939-21
3.1	122939-22
3.2	122939-23
3.3	122939-24
3.4	122939-25

MARK	ITEM NUMBER
3.5	122939-26
3.6	122939-27
3.7	122939-28
3.8	122939-29
3.9	122939-30
4.0	122939-31
4.1	122939-32
4.2	122939-33
4.3	122939-34
4.4	122939-35
4.5	122939-36
4.6	122939-37
4.7	122939-38
4.8	122939-39
4.9	122939-40
5.0	122939-41
5.1	122939-42
5.2	122939-43
5.3	122939-44
5.4	122939-45
5.5	122939-46
5.6	122939-47
5.7	122939-48
5.8	122939-49
5.9	122939-50

MARK	ITEM NUMBER
6.0	122939-51
6.1	122939-52
6.2	122939-53
6.3	122939-54
6.4	122939-55
6.5	122939-56
6.6	122939-57
6.7	122939-58
6.8	122939-59
6.9	122939-60
7.0	122939-61
7.1	122939-62
7.2	122939-63
7.3	122939-64
7.4	122939-65
7.5	122939-66
7.6	122939-67
7.7	122939-68
7.8	122939-69
7.9	122939-70
8.0	122939-71
8.1	122939-72
8.2	122939-73
8.3	122939-74
8.4	122939-75

MARK	ITEM NUMBER
8.5	122939-76
8.6	122939-77
8.7	122939-78
8.8	122939-79
8.9	122939-80
9.0	122939-81
9.1	122939-82
9.2	122939-83
9.3	122939-84
9.4	122939-85
9.5	122939-86
9.6	122939-87
9.7	122939-88
9.8	122939-89
9.9	122939-90
10.0	122939-91
10.1	122939-92
10.2	122939-93
10.3	122939-94
10.4	122939-95
10.5	122939-96
10.6	122939-97
10.7	122939-98
10.8	122939-99
10.9	122939-100
11.0	122939-101

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METZNER AM-130 / 150 MACHINE SERIES

CUT-OFF BLADES CLASS: CL-A / WE-A

COLLINEAR ANGLE CUT-OFF BLADES

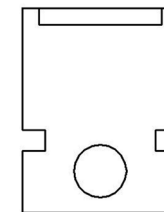
Sharp edge is ground to a collinear angle.

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 -

ITEM NUMBER	DESCRIPTION
123282	CL-A DIE TYPE CUT-OFF



123282

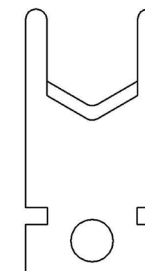
WIDE ENTRY ANGLE

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 -

ITEM NUMBER	ENTRY ANGLE	DESCRIPTION
122891	130	WE-A CUT-OFF



122891

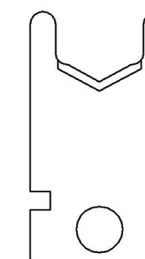
WIDE ENTRY ANGLE

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 -

ITEM NUMBER	ENTRY ANGLE	DESCRIPTION
122994	123	WE-A CUT-OFF



122994

METZNER AM-130 / 150 MACHINE SERIES

UNIVERSAL CUT-OFF BLADES CLASS: UN-V

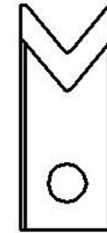
UNIVERSAL CUT-OFF BLADES

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	OEM #	DESCRIPTION
122893	944 20 072	STRIPPER / CRIMPER BLADE



122893

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	OEM #	DESCRIPTION
122894	944 20 082	STRIPPER / CRIMPER BLADE
122895	944 30 080	STRIPPER / CRIMPER BLADE



122894



122895

METZNER AM-130 / 150 MACHINE SERIES

WIDE ENTRY ANGLE / TANGENT “V” CUT-OFF BLADES CLASS: WE-A / TA-V

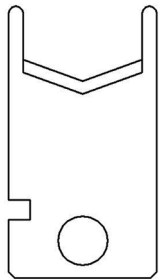


WIDE ENTRY ANGLE

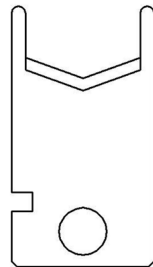
The sharp edge is ground at an angle that results in a “V” opening above 90 degrees.

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 -



123495



123433

ITEM NUMBER	MM THICKNESS	ENTRY ANGLE	DESCRIPTION
123495	0.8	140	WE-A / TA-V CUT-OFF
123433	1.6	140	WE-A / TA-V CUT-OFF

METZNER ST-OB 150 / 30 / 400 MACHINE SERIES

COLLINEAR ANGLE CUT-OFF BLADES CLASS: CL-A



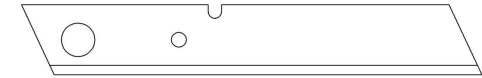
COLLINEAR ANGLE CUT-OFF BLADES

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	MM LENGTH	DESCRIPTION
123274-1	123.6	CL-A CUT-OFF
123274-2	183.5	CL-A CUT-OFF



123274

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
123275	CL-A CUT-OFF



123275

METZNER AM-180 MACHINE SERIES

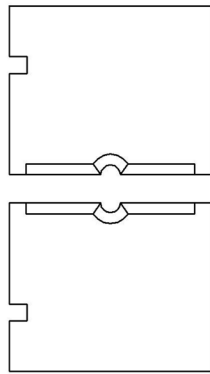
DIE TYPE STRIP BLADES

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.

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 -



122319-XX

MM SIZE	ITEM NUMBER
1.60	122319-150
1.90	122319-151
2.00	122319-153
2.10	122319-154
2.20	122319-155
2.30	122319-156
2.40	122319-157
2.50	122319-158
2.60	122316-159
2.30	122319-152
2.80	122319-76
2.90	122319-1
2.95	122319-2
3.00	122319-77
3.10	122319-78

MM SIZE	ITEM NUMBER
3.20	122319-79
3.30	122319-80
3.40	122319-81
3.50	122319-82
3.60	122319-9
3.70	122319-4
3.80	122319-5
3.90	122319-112
4.00	122319-10
4.10	122319-21
4.20	122319-3
4.30	122319-6
4.40	122319-22
4.50	122319-7
4.60	122319-23

MM SIZE	ITEM NUMBER
4.70	122319-24
4.80	122319-11
4.90	122319-25
5.00	122319-26
5.10	122319-27
5.20	122319-28
5.30	122319-17
5.40	122319-29
5.50	122319-30
5.60	122319-31
5.70	122319-32
5.80	122319-33
5.90	122319-34
6.00	122319-35
6.10	122319-36

MM SIZE	ITEM NUMBER
6.20	122319-37
6.30	122319-38
6.40	122319-39
6.50	122319-40
6.60	122319-41
6.70	122319-42
6.80	122319-43
6.90	122319-44
7.00	122319-18
7.10	122319-45
7.20	122319-19
7.30	122319-46
7.40	122319-47
7.50	122319-48
7.60	122319-49

METZNER AM-180 MACHINE SERIES

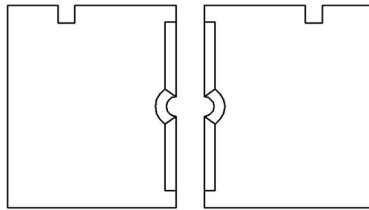
DIE TYPE STRIP BLADES

- ADDITIONAL PART NUMBER'S ON SUCCEEDING PAGES -

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METZNER AM-180 MACHINE SERIES

DIE TYPE STRIP BLADES ADDITIONAL PART NUMBER'S



122319-XX

MM SIZE	ITEM NUMBER
7.70	122319-50
7.80	122319-51
7.90	122319-52
8.00	122319-53
8.10	122319-54
8.20	122319-13
8.30	122319-20
8.40	122319-16
8.50	122319-55
8.60	122319-12
8.70	122319-15
8.80	122319-14
8.90	122319-56
9.00	122319-57
9.10	122319-58
9.20	122319-59
9.30	122319-8
9.40	122319-60
9.50	122319-61
9.60	122319-62
9.70	122319-63
9.80	122319-64
9.90	122319-65
10.00	122319-66
10.10	122319-83

MM SIZE	ITEM NUMBER
10.20	122319-84
10.30	122319-85
10.40	122319-86
10.50	122319-87
10.60	122319-67
10.70	122319-68
10.80	122319-69
10.90	122319-88
11.00	122319-89
11.10	122319-113
11.20	122319-90
11.30	122319-91
11.40	122319-92
11.50	122319-98
11.60	122319-114
11.70	122319-115
11.80	122319-116
11.90	122319-117
12.00	122319-100
12.10	122319-118
12.20	122319-119
12.30	122319-71
12.40	122319-72
12.50	122319-73
12.60	122319-74

MM SIZE	ITEM NUMBER
12.70	122319-75
12.80	122319-120
12.90	122319-121
13.00	122319-106
13.10	122319-108
13.20	122319-109
13.30	122319-110
13.40	122319-111
13.50	122319-107
13.60	122319-99
13.70	122319-93
13.80	122319-94
13.90	122319-95
14.00	122319-96
14.10	122319-97
14.20	122319-122
14.30	122319-123
14.40	122319-124
14.50	122319-125
14.60	122319-126
14.70	122319-127
14.80	122319-128
14.90	122319-129
15.00	122319-130
15.10	122319-131

MM SIZE	ITEM NUMBER
15.20	122319-132
15.30	122319-101
15.40	122319-102
15.50	122319-103
15.60	122319-104
15.70	122319-105
15.80	122319-133
15.90	122319-134
16.00	122319-135
16.10	122319-136
16.20	122319-70
16.30	122319-137
16.40	122319-138
16.50	122319-139
16.60	122319-140
16.70	122319-141
16.80	122319-142
16.90	122319-143
17.00	122319-144
17.10	122319-145
17.20	122319-146
17.30	122319-147
17.40	122319-148
17.50	122319-149

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METZNER AM-180 MACHINE SERIES

TRU-RADIUS STRIP BLADES CLASS: TR-V

TRU-RADIUS STRIP BLADE

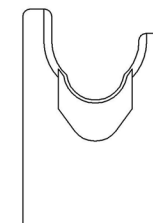
The sharp edge is ground to a half circle whose radius approximates awg wire size. The entry angle lines intersect the half circle at the quadrant points. This type of blade, when closed, presents a true circle profile.

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 -

ITEM NUMBER	SIZE	DESCRIPTION
123416-1	180.1,6 D1=12 D2=18	TR-V STRIP
123416-2	180.1,6 D1=15 D2=20	TR-V STRIP



123416-XX

METZNER AM-180 MACHINE SERIES

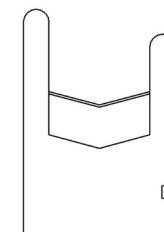
WIDE ENTRY ANGLE / TANGENT “V” CUT-OFF BLADES CLASS: WE-A / TA-V

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 -

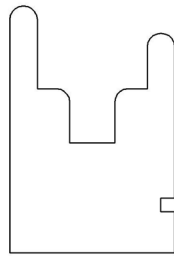
ITEM NUMBER	MM THICKNESS	ENTRY ANGLE	DESCRIPTION
123434-2	0.8	150	WE-A / TA-V CUT-OFF
123434-1	1.6	150	WE-A / TA-V CUT-OFF
123434-3	2.9	150	WE-A/ TA-V CUT-OFF



123434-XX

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.



123310-XX

MM SIZE	ITEM NUMBER
4.0	123310-4.0
4.4	123310-4.4
4.5	123310-4.5
4.6	123310-4.6
4.8	123310-4.8
5.0	123310-5.0
5.4	123310-5.4
5.5	123310-5.5
5.6	123310-5.6
6.0	123310-6.0
6.5	123310-6.5
6.7	123310-6.7
6.9	123310-6.9
7.3	123310-7.3
8.0	123310-8.0
8.1	123310-8.1
8.2	123310-8.2
8.3	123310-8.3
8.4	123310-8.4
8.6	123310-8.6
8.8	123310-8.8
9.0	123310-9.0
9.4	123310-9.4
9.5	123310-9.5

MM SIZE	ITEM NUMBER
9.8	123310-9.8
10.0	123310-10.0
10.4	123310-10.4
10.7	123310-10.7
10.8	123310-10.8
11.0	123310-11.0
11.2	123310-11.2
11.4	123310-11.4
12.8	123310-12.8
13.0	123310-13.0
13.4	123310-13.4
13.6	123310-13.6
14.0	123310-14.0
14.4	123310-14.4
14.8	123310-14.8
15.0	123310-15.0
15.2	123310-15.2
15.6	123310-15.6
16.1	123310-16.1
16.5	123310-16.5
16.6	123310-16.6
16.8	123310-16.8
17.0	123310-17.0
18.0	123310-18.0
19.0	123310-19.0

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

• EMAIL: BLADES@LAKESPRECISION.COM •

METZNER MACHINE SERIES

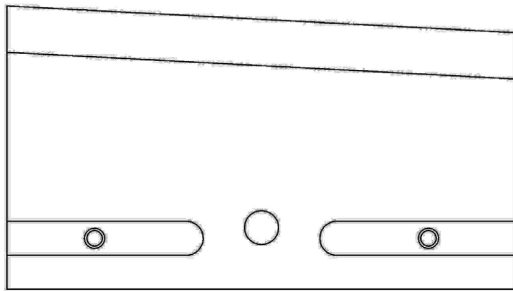
COLLINEAR ANGLE CUTTER BLADE & ANVIL CLASS: CL-A

COLLINEAR ANGLE CUT-OFF BLADES

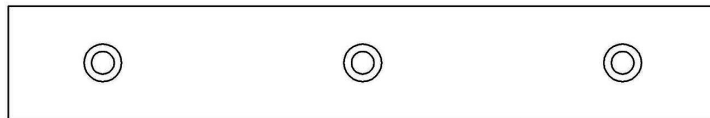
Sharp edge is ground to a flat collinear angle.

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 -



122982
CUTTER BLADE



122983
ANVIL

ITEM NUMBER	MATERIAL	DESCRIPTION
122982	TOOL STEEL	CUTTER BLADE
122983	TOOL STEEL	ANVIL