



# LAKES PRECISION<sup>INC.</sup>

*Your Global Source for Wire Processing Perishable Tooling*

## SCHÄFER / MEGOMAT MACHINE SERIES

THIS SECTION CONTAINS BLADES FOR THE FOLLOWING MACHINE SERIES:

- APE-300
- EUROPEAN ASM 1000
- ASM 3000
- ASM 3001A
- CONTACT MACHINE SERIES
- ULTIMA MODEL MACHINE SERIES

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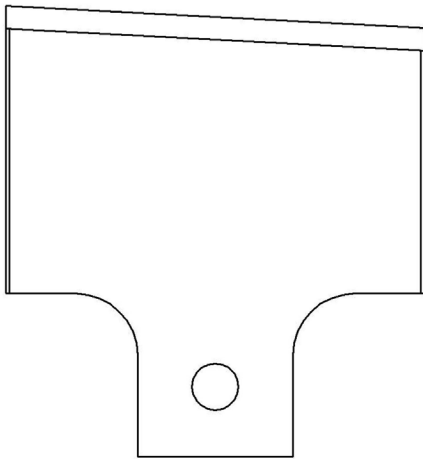
[www.lakesprecision.com](http://www.lakesprecision.com)

### 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 -



123214

ITEM NUMBER	OEM #	DESCRIPTION
123214	6.041.7083.400	CL-A CUT BLADE

# MEGOMAT EUROPEAN ASM 1000 MACHINE SERIES

COLLINEAR RADIUS STRIP BLADES CLASS: CL-R



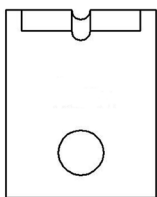
## COLLINEAR RADIUS TYPE

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 -



122602-XX

DIA MM SIZE	OEM #	ITEM NUMBER
0.40	6.013.0250.404	122602-53
0.50	6.013.0251.405	122602-51
0.60	6.013.0252.406	122602-52
0.70	6.013.0253.407	122602-1
0.80	6.013.0254.408	122602-2
0.90	6.013.0255.409	122602-3
1.00	6.013.0256.410	122602-4
1.10	6.013.0257.411	122602-5
1.15	-----	122602-54
1.20	6.013.0258.412	122602-6
1.30	6.013.0259.413	122602-7
1.40	6.013.0260.414	122602-8
1.50	6.013.0261.415	122602-9
1.60	6.013.0262.416	122602-10
1.70	6.013.0263.417	122602-11
1.80	6.013.0264.418	122602-12
1.90	6.013.0265.419	122602-13
2.00	6.013.0266.420	122602-14

DIA MM SIZE	OEM #	ITEM NUMBER
2.10	-----	122602-15
2.20	6.013.0267.422	122602-16
2.30	-----	122602-17
2.40	6.013.0268.424	122602-18
2.50	-----	122602-19
2.61	6.013.0269.426	122602-20
2.70	-----	122602-21
2.80	6.013.0270.428	122602-22
2.90	-----	122602-23
3.00	6.013.0271.430	122602-24
3.10	-----	122602-25
3.20	6.013.0272.432	122602-26
3.30	-----	122602-27
3.40	6.013.0273.434	122602-28
3.50	-----	122602-29
3.60	6.013.0274.436	122602-30
3.70	-----	122602-31
3.80	6.013.0275.438	122602-32

DIA MM SIZE	OEM #	ITEM NUMBER
3.90	-----	122602-33
4.00	6.013.0276.440	122602-34
4.10	-----	122602-35
4.20	6.013.0277.442	122602-36
4.30	-----	122602-37
4.40	6.013.0278.444	122602-38
4.50	-----	122602-39
4.60	6.013.0279.446	122602-40
4.70	-----	122602-41
4.80	6.013.0280.448	122602-42
4.90	-----	122602-43
5.00	6.013.0281.450	122602-44
5.10	-----	122602-45
5.20	-----	122602-46
5.30	-----	122602-47
5.40	-----	122602-48
5.50	-----	122602-49
5.60	-----	122602-50

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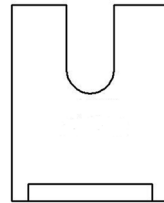
### COLLINEAR ANGLE CUT-OFF BLADES

Sharp edge is ground to a collinear angle.

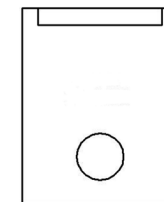
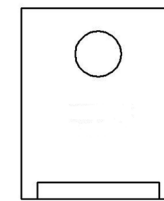
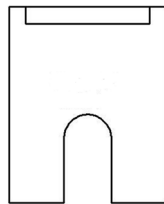
**Characteristics:** Sharp edges cut by compression. This class of blade was designed to allow positive control of cutter head closure. It also allows precision processing of specific wire sizes with an inherent blade longevity.

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

- *TC Coating Available* -



**122407  
CUT-OFF BLADE**



**122616  
CUT-OFF BLADE  
OEM #= 6.013.0186.400**

## RADIUS WIRE GUIDE

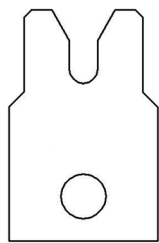
Wire guides are used in conjunction with collinear radius strip blades to precisely guide the conductor into the strip area of the blade. This will help prevent the conductor from coming in contact with the cutting edges of the strip blades, preventing premature strip blade wear.

### 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:

122617-1 = 1.0 mm Diameter Guide



122617

DIA MM SIZE	OEM #	ITEM NUMBER
0.6	6.013.0300.406	122617-46
0.7	6.013.0301.407	122617-47
0.8	6.013.0302.408	122617-48
0.9	6.013.0303.409	122617-49
1.0	6.013.0304.410	122617-1
1.1	6.013.0305.411	122617-2
1.2	6.013.0306.412	122617-3
1.3	6.013.0307.413	122617-4
1.4	6.013.0308.414	122617-5
1.5	6.013.0309.415	122617-6
1.6	6.013.0310.416	122617-7
1.7	6.013.0311.417	122617-8
1.8	6.013.0312.418	122617-9
1.9	6.013.0313.419	122617-10
2.0	6.013.0314.420	122617-11
2.1	6.013.0315.421	122617-12
2.2	6.013.0316.422	122617-13
2.3	6.013.0317.423	122617-14

DIA MM SIZE	OEM #	ITEM NUMBER
2.4	6.013.0318.424	122617-15
2.5	6.013.0319.425	122617-16
2.6	6.013.0320.426	122617-17
2.7	6.013.0321.427	122617-18
2.8	6.013.0322.428	122617-19
2.9	6.013.0323.429	122617-20
3.0	6.013.0324.430	122617-21
3.1	-----	122617-22
3.2	6.013.0325.432	122617-23
3.3	-----	122617-24
3.4	6.013.0326.434	122617-25
3.5	-----	122617-26
3.6	6.013.0327.436	122617-27
3.7	-----	122617-28
3.8	6.013.0328.438	122617-29
3.9	-----	122617-30
4.0	6.013.0329.440	122617-31
4.1	-----	122617-32

DIA MM SIZE	OEM #	ITEM NUMBER
4.2	6.013.0330.442	122617-33
4.3	-----	122617-34
4.4	6.013.0331.444	122617-35
4.5	-----	122617-36
4.6	6.013.0332.446	122617-37
4.7	-----	122617-38
4.8	6.013.0333.448	122617-39
4.9	-----	122617-40
5.0	6.013.0334.450	122617-41
5.1	-----	122617-42
5.2	6.013.0335.452	122617-43
5.3	-----	122617-44
5.4	6.013.0336.454	122617-45
6.4	-----	122617-50
6.5	-----	122617-51
6.6	-----	122617-52
6.7	-----	122617-53
6.8	-----	122617-54

# MEGOMAT ASM 3000 MACHINE SERIES

TRU-RADIUS “V” STRIP BLADES CLASS: TR-V



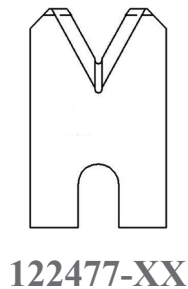
## TRU-RADIUS “V” STRIP BLADE

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 -



DIA MM SIZE	ITEM NUMBER
1.00	122477-1
1.10	122477-8
1.20	122477-2
1.30	122477-9
1.40	122477-3
1.50	122477-10
1.60	122477-11
1.70	122477-4
1.80	122477-12
1.90	122477-13
2.00	122477-5
2.10	122477-14

DIA MM SIZE	ITEM NUMBER
2.20	122477-15
2.30	122477-16
2.40	122477-17
2.50	122477-18
2.60	122477-6
2.70	122477-19
2.80	122477-20
2.90	122477-21
3.00	122477-22
3.10	122477-23
3.20	122477-7
3.30	122477-24

# MEGOMAT ASM 3000 MACHINE SERIES

COLLINEAR RADIUS STRIP BLADES CLASS: CL-R



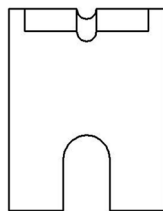
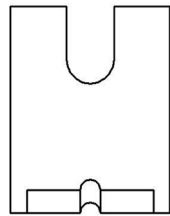
## COLLINEAR RADIUS TYPE

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 -



122385-XX

DIA MM SIZE	OEM #	ITEM NUMBER
0.40	-----	122385-51
0.70	-----	122385-1
0.80	-----	122385-2
0.90	-----	122385-3
1.00	-----	122385-4
1.10	-----	122385-5
1.15	-----	122385-53
1.20	M.013.0258.412	122385-6
1.30	M.013.0259.413	122385-7
1.40	M.013.0260.414	122385-8
1.50	M.013.0261.415	122385-9
1.60	M.013.0262.416	122385-10
1.70	-----	122385-11
1.80	-----	122385-12
1.90	-----	122385-13
2.00	-----	122385-14
2.10	-----	122385-15

DIA MM SIZE	OEM #	ITEM NUMBER
2.20	-----	122385-16
2.30	-----	122385-17
2.25	-----	122385-54
2.40	-----	122385-18
2.50	-----	122385-19
2.60	-----	122385-20
2.70	-----	122385-21
2.80	-----	122385-22
2.90	-----	122385-23
3.00	-----	122385-24
3.10	-----	122385-25
3.20	-----	122385-26
3.30	-----	122385-27
3.40	-----	122385-28
3.50	-----	122385-29
3.60	-----	122385-30
3.70	-----	122385-31

DIA MM SIZE	OEM #	ITEM NUMBER
3.80	-----	122385-32
3.90	-----	122385-33
4.00	-----	122385-34
4.10	-----	122385-35
4.20	-----	122385-36
4.30	-----	122385-37
4.40	-----	122385-38
4.50	-----	122385-39
4.60	-----	122385-40
4.70	-----	122385-41
4.80	-----	122385-42
4.90	-----	122385-43
5.30	-----	122385-44
5.70	-----	122385-47
6.00	-----	122385-45
6.10	-----	122385-52
6.50	-----	122385-46

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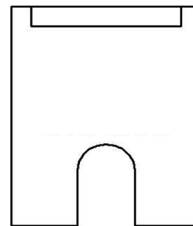
### COLLINEAR ANGLE CUT-OFF BLADES

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.

OEM # = M.013.0186.400

- *TC Coating Available* -



122384



# MEGOMAT ASM 3000 MACHINE SERIES

RADIUS WIRE GUIDES PART NUMBER'S



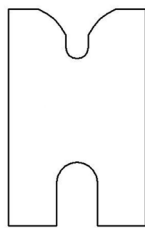
## RADIUS WIRE GUIDES

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.

### 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: 122445-1 = 1.0 mm Diameter Guide



122445-XX

DIA MM SIZE	ITEM NUMBER
1.0	122445-1
1.1	122445-2
1.2	122445-3
1.3	122445-4
1.4	122445-5
1.5	122445-6
1.6	122445-7
1.7	122445-8
1.8	122445-9
1.9	122445-10
2.0	122445-11
2.1	122445-12
2.2	122445-13
2.3	122445-14
2.4	122445-15
2.5	122445-16
2.6	122445-17

DIA MM SIZE	ITEM NUMBER
2.7	122445-18
2.8	122445-19
2.9	122445-20
3.0	122445-21
3.1	122445-22
3.2	122445-23
3.3	122445-24
3.4	122445-25
3.5	122445-26
3.6	122445-27
3.7	122445-28
3.8	122445-29
3.9	122445-30
4.0	122445-31
4.1	122445-32
4.2	122445-33
4.3	122445-34

DIA MM SIZE	ITEM NUMBER
4.4	122445-35
4.5	122445-36
4.6	122445-37
4.7	122445-38
4.8	122445-39
4.9	122445-40
5.0	122445-41
5.1	122445-42
5.2	122445-43
5.3	122445-44
5.4	122445-45
5.5	122445-46
5.6	122445-47
5.7	122445-48
5.8	122445-49
5.9	122445-50
6.0	122445-51

DIA MM SIZE	ITEM NUMBER
6.1	122445-52
6.2	122445-53
6.3	122445-54
6.4	122445-55
6.5	122445-56
6.6	122445-57
6.7	122445-58
6.8	122445-59
6.9	122445-60
7.0	122445-61
7.1	122445-62
7.2	122445-63
7.3	122445-64
7.4	122445-65
7.5	122445-66
10.0	122445-67

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# MEGOMAT ASM 3000 MACHINE SERIES

TANGENT RADIUS “V” STRIP & UNIVERSAL CUT-OFF BLADES CLASS: TA-V / UN-V

## TANGENT RADIUS “V” STRIP BLADES

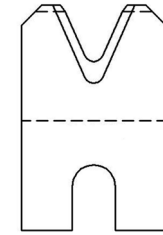
The sharp edge is ground tangent to an arc whose radius approximates awg wire size. The entry angle lines meet the arc at a tangent point. This type of blade, when closed, presents a diamond shaped edge profile.

**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 -

DIA MM SIZE	OEM #	ITEM NUMBER
0.30	-----	122270-1
0.55	6.013.0501.506	122270-2
0.86	6.013.0504.509	122270-3
1.06	6.013.0506.511	122270-4
1.32	6.013.0508.513	122270-5
1.57	6.013.0511.516	122270-6
1.93	6.013.0514.519	122270-7
2.43	6.013.0519.524	122270-8
2.84	6.013.0523.528	122270-9
4.36	6.013.0532.544	122270-10
5.63	-----	122270-11



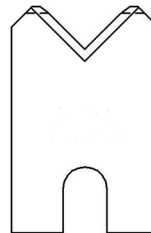
122270

## OLD STYLE 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.

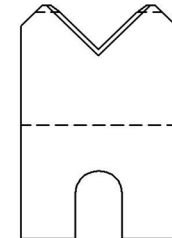
**Characteristics:** Sharp edges cut by slicing, creating a gradual cut. This produces less deformation of the material being cut. Cutting edges must be able to by-pass each other. This type cut-off is best used with circular shaped wire.

- TC Coating Available -



122476  
STYLE A

OEM #	ITEM NUMBER
-----	122476
M.013.0187.400	122271



122271  
STYLE B

# MEGOMAT ASM 3000 MACHINE SERIES

VARIABLE SPACERS ( WITH HOLE )



## VARIABLE SPACERS

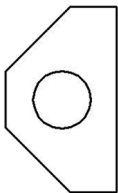
The wire end strip dimension is obtained by physically inserting spacers of different thickness in-between the blade bodies. The assembly is then held in place by set screws or other fastening devices.

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.

OEM # = M.330.0157.000

**SPACER SET  
5-123005**



**122877-XX**

DIA MM SIZE	OEM #	ITEM NUMBER
0.5	6.013.0350.400	122877-53
0.6	6.013.0350.400	122877-1
0.7	6.013.0351.400	122877-2
0.8	6.013.0352.400	122877-3
0.9	6.013.0353.400	122877-4
1.0	6.013.0354.400	122877-5
1.1	6.013.0355.400	122877-6
1.2	6.013.0356.400	122877-7
1.3	6.013.0357.400	122877-8
1.4	6.013.0358.400	122877-9
1.5	6.013.0359.400	122877-10
1.6	6.013.0360.400	122877-11
1.7	6.013.0361.400	122877-12
1.8	6.013.0362.400	122877-13
1.9	6.013.0363.400	122877-14
2.0	6.013.0364.400	122877-15
2.1	6.013.0365.400	122877-16
2.2	6.013.0366.400	122877-17

DIA MM SIZE	OEM #	ITEM NUMBER
2.3	6.013.0367.400	122877-18
2.4	6.013.0368.400	122877-19
2.5	6.013.0369.400	122877-20
2.6	6.013.0370.400	122877-21
2.7	6.013.0371.400	122877-22
2.8	6.013.0372.400	122877-23
2.9	6.013.0373.400	122877-24
3.0	6.013.0374.400	122877-25
3.1	6.013.0375.400	122877-26
3.2	6.013.0375.400	122877-27
3.3	6.013.0377.400	122877-28
3.4	6.013.0378.400	122877-29
3.5	6.013.0379.400	122877-30
3.6	6.013.0380.400	122877-31
3.7	6.013.0381.400	122877-32
3.8	6.013.0382.400	122877-33
3.9	6.013.0383.400	122877-34
4.0	6.013.0384.400	122877-35

DIA MM SIZE	OEM #	ITEM NUMBER
4.1	6.013.0385.400	122877-36
4.2	6.013.0386.400	122877-37
4.3	6.013.0387.400	122877-38
4.4	6.013.0388.400	122877-39
4.5	6.013.0389.400	122877-40
4.6	6.013.0390.400	122877-41
4.7	6.013.0391.400	122877-42
4.8	6.013.0392.400	122877-43
4.9	6.013.0393.400	122877-44
5.0	6.013.0394.400	122877-45
6.0	6.013.0395.400	122877-46
7.0	6.013.0396.400	122877-47
8.0	6.013.0397.400	122877-48
9.0	6.013.0398.400	122877-49
10.0	6.013.0399.400	122877-50
11.4	6.013.0400.400	122877-51
14.7	M.0130.395.4147	122877-54
15.4	6.013.0401.400	122877-52

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

• EMAIL: [BLADES@LAKESPRECISION.COM](mailto:BLADES@LAKESPRECISION.COM) •

# MEGOMAT ASM 3000 MACHINE SERIES

VARIABLE SPACERS ADDITIONAL PART NUMBER'S



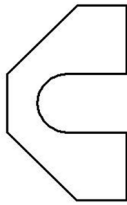
## QUICK CHANGE VARIABLE SPACERS

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.

SPACER SET  
5-122423



122422

DIA MM SIZE	ITEM NUMBER
0.5	122422-1
1.0	122422-2
1.3	122422-49
1.4	122422-61
1.5	122422-3
1.6	122422-62
2.0	122422-4
2.2	122422-63
2.5	122422-5
2.7	122422-50
3.0	122422-6
3.2	122422-51
3.5	122422-7
3.6	122422-52
3.7	122422-35
4.0	122422-8
4.1	122422-36
4.2	122422-53
4.4	122422-54
4.5	122422-9
4.6	122422-55

DIA MM SIZE	TEM NUMBER
4.7	122422-37
4.8	122422-48
4.9	122422-38
5.0	122422-10
5.1	122422-39
5.2	122422-40
5.4	122422-41
5.5	122422-11
5.6	122422-56
5.7	122422-42
5.9	122422-43
6.0	122422-12
6.1	122422-44
6.2	122422-57
6.4	122422-45
6.5	122422-13
6.6	122422-58
6.9	122422-46
7.0	122422-14
7.1	122422-59
7.4	122422-47

DIA MM SIZE	ITEM NUMBER
7.5	122422-15
7.9	122422-60
8.0	122422-16
8.5	122422-17
9.0	122422-18
9.5	122422-19
10.0	122422-20
10.5	122422-21
11.0	122422-22
11.5	122422-23
12.0	122422-24
12.5	122422-25
13.0	122422-26
13.5	122422-27
14.0	122422-28
14.5	122422-29
15.0	122422-30
15.4	122422-64
15.5	122422-31
16.0	122422-32
16.5	122422-33
17.0	122422-34

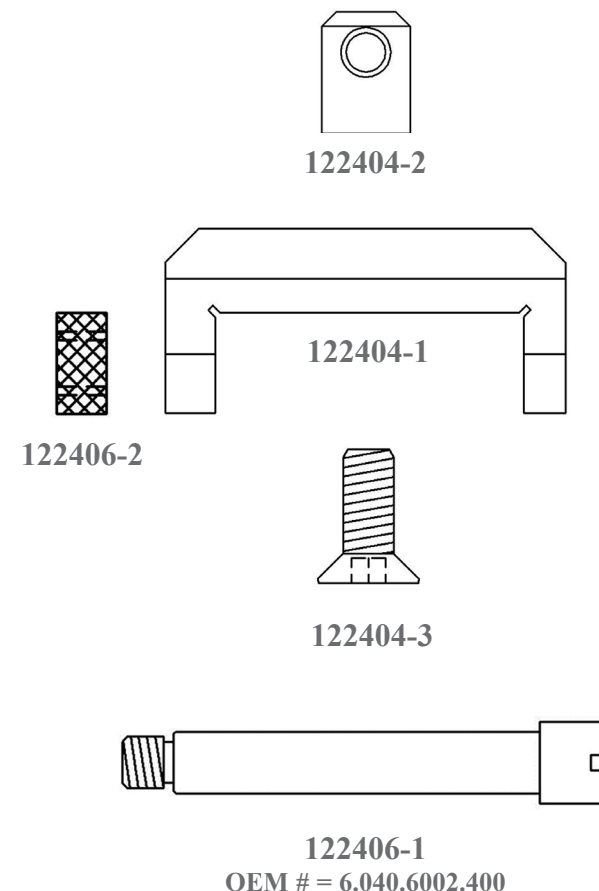
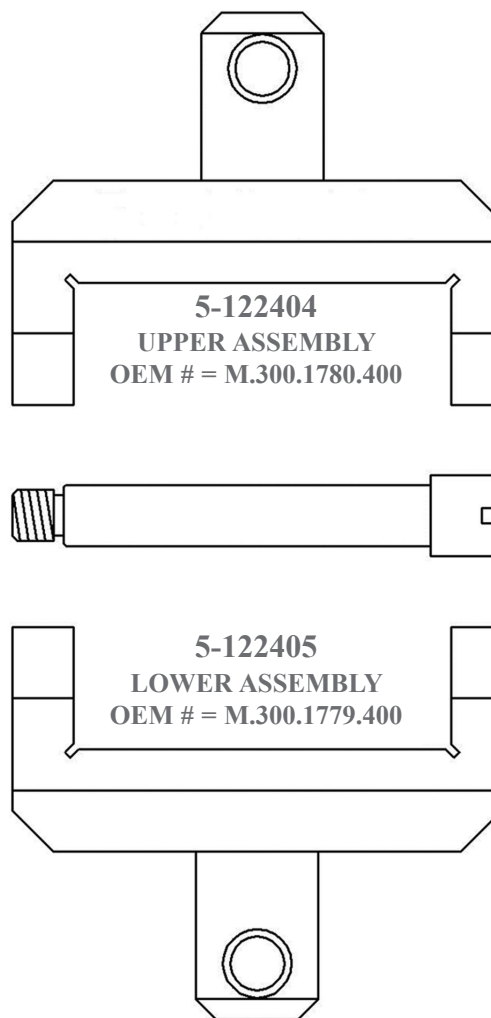
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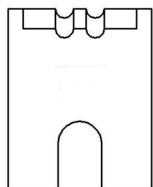
• EMAIL: [BLADES@LAKESPRECISION.COM](mailto:BLADES@LAKESPRECISION.COM) •

### 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.

ITEM NUMBER	DESCRIPTION
122404-1	TOOLHOLDER BASE
122404-2	LOCATOR PIN
122404-3	SCREW
122406	SCREW & NUT
122406-1	SCREW
122406-2	NUT
5-122404	UPPER TOOLHOLDER ASSEMBLY
5-122405	LOWER TOOLHOLDER ASSEMBLY



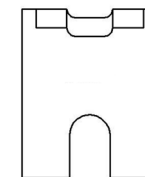


**122468-XX**  
**MUTLI-CONDUCTOR**

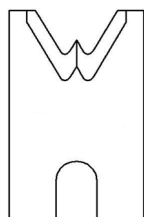
### SPECIAL APPLICATION BLADES

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.

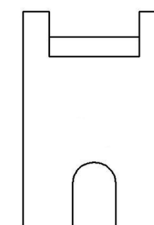
*- TC Coating Available -*



**122730-XX**  
**OVAL STRIP BLADE**



**122459**  
**MUTLI-CONDUCTOR**



**122479**  
**CL-A CUT-OFF**

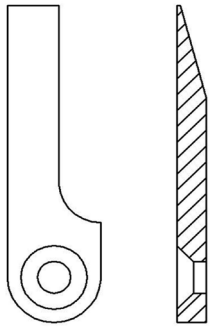
# MEGOMAT ASM 3001A MACHINE SERIES

## KNOCK-OFF BLADES

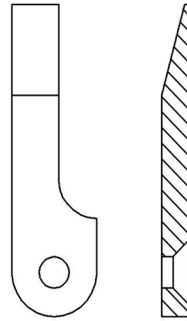
### KNOCK-OFF BLADES

- For more information, contact Lakes Precision, Inc.

- TC Coating Available -



123215



123216

ITEM NUMBER	OEM #	DESCRIPTION
123215	6.050.0431.400	KNOCK-OFF
123216	6.050.0494.400	KNOCK-OFF

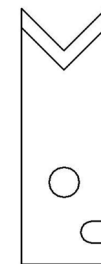
## MEGOMAT CONTACT MACHINE SERIES UNIVERSAL CUT / STRIP BLADES

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 -

ITEM NUMBER	OEM#	DESCRIPTION
122909	T2AB0017R	UN-V CUT / STRIP FOR CONTACT MACHINE



122909

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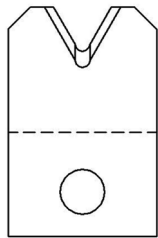
### TRU-RADIUS STRIP BLADE

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 -



122599-XX

DIA MM SIZE	ITEM NUMBER	DESCRIPTION
0.50	122599-30	TR-V 020
0.60	122599-31	TR-V 024
0.80	122599-32	TR-V 031
0.90	122599-29	TR-V 035
1.00	122599-1	TR-V 039
1.10	122599-8	TR-V 043
1.20	122599-2	TR-V 047
1.30	122599-9	TR-V 051
1.40	122599-3	TR-V 055
1.50	122599-10	TR-V 059
1.60	122599-11	TR-V 063
1.70	122599-4	TR-V 067
1.80	122599-12	TR-V 070
1.90	122599-13	TR-V 075
2.00	122599-5	TR-V 079
2.10	122599-14	TR-V 083

DIA MM SIZE	ITEM NUMBER	DESCRIPTION
2.20	122599-15	TR-V 087
2.30	122599-16	TR-V 090
2.40	122599-17	TR-V 094
2.50	122599-18	TR-V 098
2.60	122599-6	TR-V 102
2.70	122599-19	TR-V 106
2.80	122599-20	TR-V 110
2.90	122599-21	TR-V 114
3.00	122599-22	TR-V 118
3.10	122599-23	TR-V 122
3.20	122599-7	TR-V 125
3.30	122599-24	TR-V 129
3.60	122599-28	TR-V 142
4.30	122599-25	TR-V 169
4.70	122599-27	TR-V 185
4.80	122599-26	TR-V 189



# MEGOMAT ULTIMA MODEL MACHINE SERIES

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



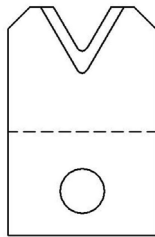
## TANGENT RADIUS “V” STRIP BLADES

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 -



122600-XX

DIA MM SIZE	OEM #	ITEM NUMBER
0.30	-----	122600-1
0.46	-----	122600-25
0.56	6.013.0501.406	122600-2
0.71	6.013.0502.407	122600-20
0.81	6.013.0503.408	122600-21
0.86	6.013.0504.409	122600-3
1.02	6.013.0505.410	122600-22
1.07	6.013.0506.411	122600-4
1.22	6.013.0507.412	122600-12
1.32	6.013-0508.413	122600-5
1.42	6.013.0509.414	122600-13
1.47	6.013.0510.415	122600-18

DIA MM SIZE	OEM #	ITEM NUMBER
1.57	6.013.0511.416	122600-6
1.78	6.013.0513.418	122600-14
1.93	6.013.0514.419	122600-7
1.98	6.013.0515.420	122600-23
2.08	6.013.0516.421	122600-19
2.44	6.013.0519.424	122600-8
2.49	6.013.0520.425	122600-24
2.84	6.013.0523.428	122600-9
3.00	6.013.0525.430	122600-10
3.61	6.013.0528.436	122600-15
4.01	6.013.0530.440	122600-16
4.22	6.013.0531.442	122600-17
4.37	6.013.0532.444	122600-11

# MEGOMAT ULTIMA MODEL MACHINE SERIES

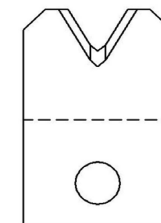
UNIVERSAL STRIP BLADES CLASS: UN-V

## 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
122658-1	30 DEGREE UNIVERSAL STRIP BLADE
122658-2	20 DEGREE UNIVERSAL STRIP BLADE



122658-XX

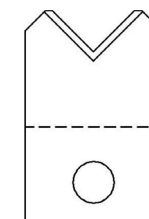
## UNIVERSAL STRIP BLADE

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 tangent to a very small or non-existing radius. It works sufficiently for most standard wall insulations but is marginal for thin wall, cross-linked PVC, very rubbery insulations, woven fiber or thin-walled multi-conductors.

- TC Coating Available -

ITEM NUMBER	OEM #	DESCRIPTION
122596	6.013.0191.400	UNIVERSAL STRIP BLADE



122596

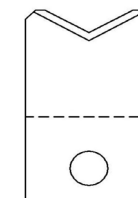
## CUT-OFF BLADE CLASS: WE-A

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	OEM #	DESCRIPTION
122595	6.013.0190.400	CUT-OFF BLADE



122595

# MEGOMAT ULTIMA MODEL MACHINE SERIES

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

## TANGENT RADIUS “V” STRIP BLADES

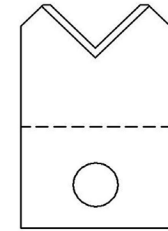
The sharp edge is ground to an arc whose radius approximates awg wire size. The entry angle lines meet the arc at a tangent point. This type of blade, when closed, presents a diamond shaped edge profile.

**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* -

DIA MM SIZE	ITEM NUMBER	OEM #	DESCRIPTION
1.0	122966-2	----	0.5 MM RADIUS
1.2	122966-1	6.013.0192.400	06. MM RADIUS



122966-XX

## WIDE ENTRY ANGLE CLASS: WE-A

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

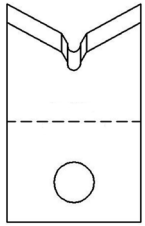
**Characteristics:** Wide angle is not as effective for gathering wire towards the operating radius. This type works well for gathering thick, soft insulations, ( such as ignition wire ).

- *TC Coating Available* -

ITEM NUMBER	OEM #	DESCRIPTION
123004	6.013.0196.400	DUO4 REJECT CUT BLADE



123004



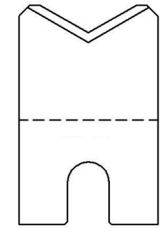
**122917-XX**

### IGNITION WIRE APPLICATION BLADES

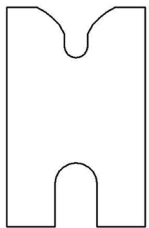
Ignition cable strips require the use of wire stops. These stops are used to control the cable and to prevent the conductor from coming into contact with the strip blades. This is required due to the soft nature of the outer jacket and the conductor wire guides and strip blades are sized for the individual application.

- FOR IGNITION CABLE APPLICATIONS  
PLEASE CONTACT LAKES PRECISION INC.

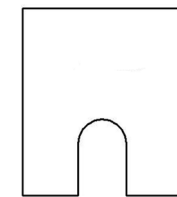
- *TC Coating Available* -



**122920-XX  
CUT-OFF**



**122919-XX  
WIRE GUIDE**



**122921-XX  
WIRE STOPS**