



LAKES PRECISION^{INC.}

Your Global Source for Wire Processing Perishable Tooling

AMP MACHINE SERIES

THIS SECTION CONTAINS BLADES FOR THE FOLLOWING MACHINE SERIES:

- CLS
- CLS IV
- CLS IV +
- IV-A
- AM-4
- STRIPPER

Your Global Source for Wire Processing Perishable Tooling

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AMP CLS MACHINE SERIES

TANGENT ANGLE “V” BLADES CLASS: TA-V

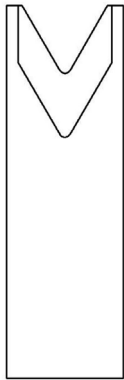
TANGENT RADIUS “V” STRIP BLADES

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 -



LPI-812285 &
LPI-1-812285

ITEM NUMBER	THICKNESS	DESCRIPTION
LPI-812285-7	.125	V022 LONG
LPI-812285-8	.062	V022 SHORT
LPI-1-812285-2	.047	V022 SHORT
LPI-812285-5	.125	V042 LONG
LPI-812285-6	.062	V042 SHORT
LPI-1-812285-1	.047	V042 SHORT
LPI-1-812285-6	.041	V-042SHORT

ITEM NUMBER	THICKNESS	DESCRIPTION
LPI-812285-3	.125	V062 LONG
LPI-812285-4	.062	V062 SHORT
LPI-1-812285-5	.041	V062 SHORT
LPI-812285-1	.125	V112 LONG
LPI-812285-2	.062	V112 SHORT
LPI-1-812285-3	.125	V172 LONG
LPI-1-812285-4	.062	V172 SHORT

AMP CLS MACHINE SERIES

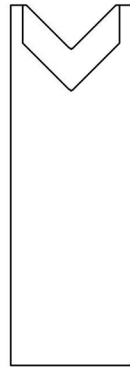
UNIVERSAL CUT-OFF BLADES CLASS: UN-V

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 -



LPI-812284

THICKNESS	ITEM NUMBER	DESCRIPTION
.0410	LPI-812284-4	UNIVERSAL CUT-OFF
.0470	LPI-812284-3	UNIVERSAL CUT-OFF
.0620	LPI-812284-1	UNIVERSAL CUT-OFF
.1245	LPI-812284-2	UNIVERSAL CUT-OFF

AMP CLS MACHINE SERIES

DUAL FORM 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 -



122856

THICKNESS	ITEM NUMBER	DESCRIPTION
.0620	122856-1	30 DEGREE DUAL CUT-OFF BLADE
.1245	122856-2	30 DEGREE DUAL CUT-OFF BLADE
.0470	122856-3	30 DEGREE DUAL CUT-OFF BLADE
.0410	122856-4	30 DEGREE DUAL CUT-OFF BLADE

AMP CLS IV MACHINE SERIES

TRU-RADIUS “V” STRIP BLADES (FIXED BLADE MODE)

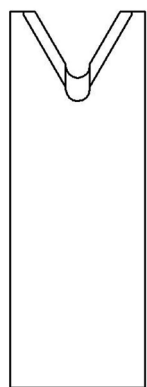
TRU-RADIUS STRIP BLADE

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 -



122709-XX
LONG THICK



122708-XX
SHORT THIN

122708-XX SHORT BLADE
122709-XX LONG BLADE

INCH DIA SIZE	ITEM NUMBER	DESCRIPTION
.024	122708-024	TR-V SHORT BLADE
.024	122709-024	TR-V LONG BLADE
.028	122708-028	TR-V SHORT BLADE
.028	122709-028	TR-V LONG BLADE
.039	122708-039	TR-V SHORT BLADE
.039	122709-039	TR-V LONG BLADE
.042	122708-042	TR-V SHORT BLADE
.042	122709-042	TR-V LONG BLADE
.047	122708-047	TR-V SHORT BLADE
.047	122709-047	TR-V LONG BLADE
.055	122708-055	TR-V SHORT BLADE
.055	122709-055	TR-V LONG BLADE
.067	122708-067	TR-V SHORT BLADE
.067	122709-067	TR-V LONG BLADE
.078	122708-078	TR-V SHORT BLADE
.078	122709-078	TR-V LONG BLADE
.090	122708-090	TR-V SHORT BLADE

INCH DIA SIZE	ITEM NUMBER	DESCRIPTION
.090	122709-090	TR-V LONG BLADE
.102	122708-102	TR-V SHORT BLADE
.102	122709-102	TR-V LONG BLADE
.112	122708-112	TR-V SHORT BLADE
.112	122709-112	TR-V LONG BLADE
.125	122708-125	TR-V SHORT BLADE
.125	122709-125	TR-V LONG BLADE
.140	122708-140	TR-V SHORT BLADE
.140	122709-140	TR-V LONG BLADE
.152	122708-152	TR-V SHORT BLADE
.152	122709-152	TR-V LONG BLADE
.160	122708-160	TR-V SHORT BLADE
.160	122709-160	TR-V LONG BLADE
.175	122708-175	TR-V SHORT BLADE
.175	122709-175	TR-V LONG BLADE
.200	122708-200	TR-V SHORT BLADE
.200	122709-200	TR-V LONG BLADE

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

• EMAIL: BLADES@LAKESPRECISION.COM •

AMP CLS IV MACHINE SERIES

DUAL FORM UNIVERSAL STRIP BLADES CLASS: UN-V

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 -



123225

THICKNESS	ITEM NUMBER	DESCRIPTION
.0620	123225-1	30 DEGREE UN-V DUAL
.1245	123225-2	30 DEGREE UN-V DUAL

AMP CLS IV + MACHINE SERIES

UNIVERSAL STRIP & CUT-OFF BLADES (UN-V MACHINE MODE)

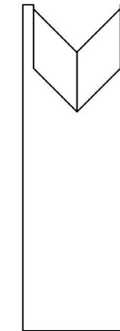
UNIVERSAL ENTRY ANGLE STRIP BLADE

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 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 -

INCH DIA SIZE	ITEM NUMBER	OEM #	DESCRIPTION
.020	122575-1	-----	UN-V STRIP .062 THIN
.020	122575-2	-----	UN-V STRIP .1245 THICK
.032	122575-3	356553-1	UN-V STRIP .062 THIN
.032	122575-4	356553-2	UN-V STRIP .1245 THICK



122575

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 -

THICKNESS	ITEM NUMBER	DESCRIPTION
.1245	844764-5	UNIVERSAL CUT-OFF



844764

AMP CLS IV + MACHINE SERIES

UNIVERSAL STRIP & CUT-OFF BLADES (UN-V DUAL FORM MODE)

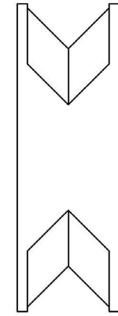
UNIVERSAL ENTRY ANGLE STRIP BLADE

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 to a very small or non-existing vertex 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 -

INCH DIA SIZE	ITEM NUMBER	DESCRIPTION
.020	122855-1	UN-V STRIP .062 THIN
.020	122855-2	UN-V STRIP .1245 THICK
.032	122855-3	UN-V STRIP .062 THIN
.032	122855-4	UN-V STRIP .1245 THICK



122855

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 -

THICKNESS	ITEM NUMBER	DESCRIPTION
.1245	122856-5	UNIVERSAL CUT-OFF



122856

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 form 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 -



123220-XX

DEGREE	ITEM NUMBER	DESCRIPTION
30	123220-1	SHORT THIN BLADE
30	123220-2	LONG THICK BLADE
20	123220-3	SHORT THIN BLADE
20	123220-4	LONG THICK BLADE

AMP CLS IV + MACHINE SERIES

TANGENT ANGLE “V” STRIP BLADES (FIXED BLADE MODE)

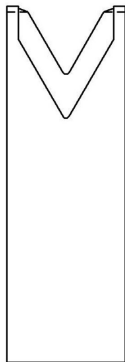
TANGENT RADIUS “V” STRIP BLADES

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 -



844765-XX

1 SHORT BLADE (S) &
1 LONG BLADE (L) = PAIR

INCH DIA SIZE	ITEM NUMBER	DESCRIPTION
.012	2-844765-1	V012S SHORT
.012	2-844765-2	V012L LONG
.022	1-844765-9	V022S SHORT
.022	2-844765-0	V022L LONG
.022	2-844765-5	V022S SPECIAL
.022	3-844765-0	V022S SPECIAL
.034	844765-1	V034S SHORT
.034	844765-2	V034L LONG
.034	2-844765-4	V034S SPECIAL
.034	2-844765-9	V034S SPECIAL
.042	844765-3	V042S SHORT
.042	844765-4	V042L LONG
.042	2-844765-3	V042S SPECIAL
.042	2-844765-8	V042S SPECIAL
.052	844765-5	V052S SHORT

INCH DIA SIZE	ITEM NUMBER	DESCRIPTION
.052	844765-6	V052L LONG
.052	2-844765-7	V052S SPECIAL
.062	844765-7	V062S SHORT
.062	844765-8	V062L LONG
.062	2-844765-6	V062S SPECIAL
.076	844765-9	V076S SHORT
.076	1-844765-0	V076L LONG
.096	1-844765-1	V096S SHORT
.096	1-844765-2	V096L LONG
.112	1-844765-3	V112S SHORT
.112	1-844765-4	V112L LONG
.172	1-844765-5	V172S SHORT
.172	1-844765-6	V172L LONG
.222	1-844765-7	V222S SHORT
.222	1-844765-8	V222L LONG

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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 -



844764-XX

THICKNESS	ITEM NUMBER
.0410	844764-4
.0470	844764-3
.0620	844764-1
.1245	844764-2

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
122205	TOOLHOLDER WITH SCREW AND WASHER
123159	TOOLHOLDER WITH SCREW AND WASHER
5-120213	SPACER SET



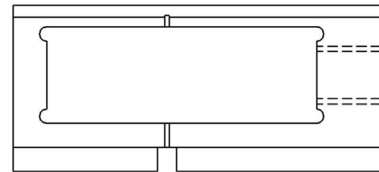
H-33783

37646

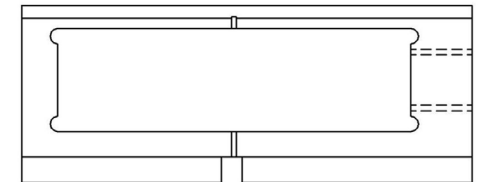


H-33783

37646



122205
OEM # 568964-1E



123159
OEM # 768439-2-A

AMP IV-A MACHINE SERIES

TANGENT ANGLE “V” BLADES CLASS: TA-V

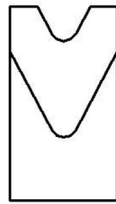
TANGENT RADIUS “V” STRIP BLADES

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 -



LPI-467651-XX

ITEM NUMBER	INCLUDED ANGLE	THICKNESS	DESCRIPTION
LPI-467651-1	60 DEGREE	THIN	V034 STRIP
LPI-467651-2	60 DEGREE	THIN	V042 STRIP
LPI-1-467651-0	50 DEGREE	THIN	V052 STRIP
LPI-467651-10	60 DEGREE	THIN	V062 STRIP
LPI-467651-3	70 DEGREE	THIN	V062 STRIP
LPI-467651-4	55 DEGREE	THIN	V096 STRIP
LPI-467651-7	55 DEGREE	THICK	V096 STRIP
LPI-467651-5	48 DEGREE	THIN	V112 STRIP
LPI-467651-8	48 DEGREE	THICK	V112 STRIP
LPI-467651-6	40 DEGREE	THIN	V172 STRIP
LPI-467651-9	40 DEGREE	THICK	V172 STRIP

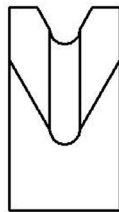
TRU-RADIUS STRIP BLADE

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 -



122574-XX

INCH DIA SIZE	ITEM NUMBER	DESCRIPTION
0.039	122574-1	TR-V 039 THIN
0.047	122574-2	TR-V 047 THIN
0.055	122574-3	TR-V 055 THIN
0.067	122574-4	TR-V 067 THIN
0.078	122574-5	TR-V 078 THIN
0.102	122574-6	TR-V 102 THIN
0.102	122574-7	TR-V 102 THICK

AMP AM-4 MACHINE SERIES

STRIPPER / CRIMPER TANGENT ANGLE “V” BLADES CLASS: TA-V

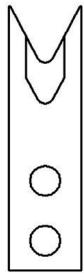
TANGENT RADIUS “V” STRIP BLADES

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 -



463310-XX

2 PIECES = 1 PAIR

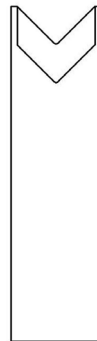
ITEM NUMBER	DESCRIPTION	GAUGE SIZE
463310-9	V020 STRIP	28
463310-8	V024 STRIP	26
463310-7	V030 STRIP	24
463310-6	V036 STRIP	22
463310-5	V046 STRIP	20
463310-4	V056 STRIP	18
463310-3	V066 STRIP	16
463310-2	V084 STRIP	14
463310-1	V104 STRIP	12

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 -



LPI-467647

THICKNESS	ITEM NUMBER
.0620	LPI-467647-1
.1245	LPI-467647-2

AMP STRIPPER MACHINE SERIES

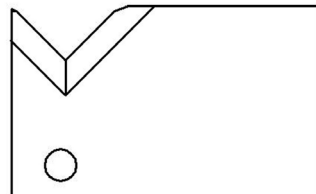
UNIVERSAL CUT / STRIP BLADES CLASS: UN-V

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* -



123194

ITEM NUMBER	OEM #	DESCRIPTION
123194	952859-1	UN-V CUT / STRIP