



**IDEAL INDUSTRIES, INC.**

Becker Place • Sycamore, Illinois 60178 • 815.895.5181 • [www.idealindustries.com](http://www.idealindustries.com)

**Blade Sets** - After disconnecting from the air and power, remove the four socket head screws located at the corners of the front cover plate. Remove the front cover plate, for better view of the blade sets, disconnect the air line leading to the face plate by pushing in red ring on the connector. Each of the six blade sets is marked starting with HA and followed with numbers, example HA1800. This is the part number you would use to reorder your 45-950 blade set HA-1800.

<b>10 AWG</b>		<b>12 AWG</b>		<b>14 AWG</b>	
<b>Blade #</b>	<b>Dia/C'Bore</b>	<b>Blade #</b>	<b>Dia/C'Bore</b>	<b>Blade #</b>	<b>Dia/C'Bore</b>
HA-1000	.116/.154	HA-1200	.0937/.136	HA-1400	.076/.113
HA-1001	.119/.144	HA-1201	.096/.125	HA-1401	.076/.104
HA-1002	.119/.136	HA-1202	.096/.113	HA-1402	.076/.0935
HA-1003	.110/.141	HA-1203	.088/.115	HA-1403	.071/.099
HA-1004	.112/.128	HA-1204	.089/.105	HA-1404	.069/.085
HA-1005	.112/.143	HA-1205	.089/.117	HA-1405	.073/.100
HA-1006	.112/.124	HA-1206	.089/.101	HA-1406	.069/.081
HA-1007		HA-1207		HA-1407	.071/.098
HA-1013	.111/.150	HA-1209	.087/.1083	HA-1408	.078/.136
		HA-1210	.0906/.114	HA-1409	.070/.0906
		HA-1213	.0886/.129	HA-1410	
				HA-1411	
				HA-1412	.0689/.086
				HA-1413	.070/.110

  

<b>16 AWG</b>		<b>18 AWG</b>		<b>20 AWG</b>	
<b>Blade #</b>	<b>Dia/C'Bore</b>	<b>Blade #</b>	<b>Dia/C'Bore</b>	<b>Blade #</b>	<b>Dia/C'Bore</b>
HA-1600	.062/.096	HA-1800	.052/.086	HA-2000	.042/.073
HA-1601	.061/.089	HA-1801	.052/.0785	HA-2001	.042/.067
HA-1602	.061/.081	HA-1802	.052/.070	HA-2002	.042/.0595
HA-1603	.057/.083	HA-1803	.050/.074	HA-2003	.040/.063
HA-1604	.057/.073	HA-1804	.051/.067	HA-2004	.041/.057
HA-1605	.058/.083	HA-1805	.052/.074	HA-2005	.042/.063
HA-1606	.056/.070	HA-1806	.0497/.064	HA-2006	.040/.054
HA-1607	.057/.069	HA-1807	.051/.063	HA-2007	.041/.053
HA-1608	.067/.125	HA-1808	.062/.113	HA-2008	
HA-1609	.059/.072	HA-1809	.052/.064	HA-2009	.043/.055
HA-1610	.061/.085	HA-1810	.051/.074	HA-2010	.041/.064
HA-1611		HA-1811		HA-2011	.040/.072
HA-1612	.055/.074	HA-1812	.0492/.065	HA-2012	.0394/.055
HA-1613	.057/.096	HA-1813	.051/.090	HA-2013	.042/.081
HA-1620	.0595/.080	HA-1820	.0492/.070	HA-2020	.039/.0595
		HA-1822	.0492/.0669	HA-2021	.039/.055
				HA-2022	.0394/.057

Tolerance +/- .001 Cutting Hole  
+/- .002 Counterbore

**Die-Type Blades**

<b><u>22 AWG</u></b>	
<b><u>Blade #</u></b>	<b><u>Dia/C'Bore</u></b>
HA-2200	.035/.0635
HA-2201	.034/.0595
HA-2202	.034/.052
HA-2203	.032/.055
HA-2204	.033/.049
HA-2205	.034/.055
HA-2206	.032/.046
HA-2207	.033/.045
HA-2208	.042/.084
HA-2209	.034/.046
HA-2210	.031/.054
HA-2211	.032/.064
HA-2212	.031/.047
HA-2213	.0335/.072
HA-2220	.031/.0492
HA-2221	.031/.045
HA-2222	.0312/.048

<b><u>24 AWG</u></b>	
<b><u>Blade #</u></b>	<b><u>Dia/C'Bore</u></b>
HA-2400	.0292/.0595
HA-2401	.028/.055
HA-2402	.028/.043
HA-2403	.026/.048
HA-2404	.027/.043
HA-2405	.028/.048
HA-2406	.0265/.040
HA-2407	.027/.039
HA-2408	
HA-2409	.028/.040
HA-2410	.024/.033
HA-2411	.025/.047
HA-2412	.025/.043
HA-2413	.0276/.068
HA-2420	.024/.043
HA-2422	.0256/.042

<b><u>26 AWG</u></b>	
<b><u>Blade #</u></b>	<b><u>Dia/C'Bore</u></b>
HA-2600	.022/.052
HA-2601	.023/.0465
HA-2602	.023/.039
HA-2603	.021/.043
HA-2604	.022/.038
HA-2605	.023/.043
HA-2606	.0217/.036
HA-2607	.022/.034
HA-2608	
HA-2609	.023/.033
HA-2610	.018/.025
HA-2611	
HA-2612	
HA-2613	.0225/.064

<b><u>28 AWG</u></b>	
<b><u>Blade #</u></b>	<b><u>Dia/C'Bore</u></b>
HA-2800	.020/.040
HA-2801	.019/.043
HA-2802	.019/.035
HA-2803	
HA-2804	
HA-2805	
HA-2806	
HA-2807	
HA-2808	
HA-2809	
HA-2810	.014/.023
HA-2811	
HA-2812	

<b><u>30 AWG</u></b>	
<b><u>Blade #</u></b>	<b><u>Dia/C'Bore</u></b>
HA-3000	.016/.037
HA-3001	.016/.042
HA-3002	.016/.032
HA-3003	
HA-3004	
HA-3005	
HA-3006	
HA-3007	
HA-3008	
HA-3009	
HA-3010	.012/.019
HA-3011	
HA-3012	

<b><u>"Corners Out"</u></b>	
<b><u>Blade #</u></b>	<b><u>Dia/C'Bore</u></b>
45-2525-1	.056/.070
45-2526-1	.0497/.064
45-2527-1	.040/.054
45-2528-2	.034/.046
45-2529-2	.032/.046
45-2557-2	.043/.055
45-2613-3	.031/.045
45-2614-3	.041/.064
45-2615-3	.033/.049
45-2616-4	.031/.054
45-2755-1	18 ga med
45-2756-1	20 ga med
45-2757-1	22 ga med
45-2758-1	20 ga thk
45-2759-1	22 ga thk
45-2760-1	24 ga med
45-2774-1	18 ga thk

**Knife-Type Blades**

<b><u>Cutting</u></b>		
<b><u>Blade #</u></b>	<b><u>Diameter</u></b>	<b><u>AWG</u></b>
HA-416	.016	30
HA-418	.018	
HA-421	.021	28
HA-423	.023	
HA-426	.026	26
HA-429	.029	
HA-432	.032	24
HA-435	.035	
HA-439	.039	22
HA-441	.041	
HA-443	.043	
HA-445	.045	
HA-448	.048	20
HA-450	.050	
HA-452	.052	
HA-455	.055	

<b><u>Blade #</u></b>	<b><u>Diameter</u></b>	<b><u>AWG</u></b>
HA-473	.073	16
HA-479	.079	
HA-485	.085	14
HA-490	.090	14
HA-497	.097	14
HA-400	.144	10
HA-401	.113	12
HA-402	.105	12
HA-403	.162	8
HA-404	.052	.032 thk
HA-405	.059	.032 thk
HA-406	.067	.032 thk
HA-407	.128	
HA-408	.120	
LA-2527	Cutting Bld	

HA-459	.059	
HA-461	.061	18
HA-467	.067	

Wire Bushings are the located on the outside of the front cover plate. The markings above and below the center hole are the guide for ordering replacement bushings. For example, if the bushing is marked "102" the correct replacement part number would be HA-102. To replace your bushing, remove the guide retaining plate by removing the thumbscrew. Remove the old bushing and insert new bushing making sure that the cross slot of each shushing faces downward. Replace the retaining plate and thumb screw.

**950 Bushing List**

<b><u>Part #</u></b>	<b><u>Marking</u></b>	<b><u>Part #</u></b>	<b><u>Marking</u></b>
HA-025	.025	HA-110	.110
HA-027	.027	HA-112	.112
HA-029	.029	HA-114	.114
HA-031	.031	HA-116	.116
HA-033	.033	HA-118	.118
HA-035	.035	HA-120	.120
HA-037	.037	HA-122	.122
HA-039	.039	HA-124	.124
HA-041	.041	HA-126	.126
HA-043	.043	HA-128	.128
HA-045	.045	HA-130	.130
HA-047	.047	HA-132	.132
HA-049	.049	HA-134	.134
HA-051	.051	HA-136	.136
HA-053	.053	HA-138	.138
HA-055	.055	HA-140	.140
HA-057	.057	HA-142	.142
HA-059	.059	HA-144	.144
HA-061	.061	HA-146	.146
HA-063	.063	HA-147	.147
HA-065	.065	HA-149	.149
HA-067	.067	HA-151	.151
HA-069	.069	HA-153	.153
HA-071	.071	HA-155	.155
HA-073	.073	HA-157	.157
HA-075	.075	HA-159	.159
HA-077	.077	HA-161	.161
HA-079	.079	HA-165	.165
HA-081	.081	HA-169	.169
HA-084	.084	HA-173	.173
HA-086	.086	HA-177	.177
HA-088	.088	HA-181	.181
HA-090	.090	HA-185	.185
HA-092	.092	HA-189	.189
HA-094	.094	HA-193	.193
HA-096	.096	HA-197	.197
HA-098	.098	HA-201	.201
HA-100	.100	HA-205	.205
HA-102	.102	HA-209	.209
HA-104	.104	HA-212	.212
HA-106	.106	HA-216	.216
HA-108	.108	HA-220	.220