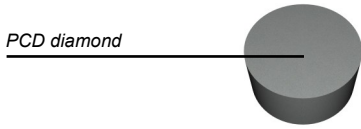
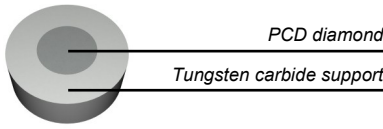


Esteves Select PCD Blanks (metric)

Blank Type ¹	Self-Supported (without support ring)				Supported (with support ring)							
												
ADDMA size	D6	D12	D15	D18	D12	D15	D18	D21	D24	D27	D30	D33
S - Maximum recommended die hole diameter (mm) when drawing soft wire												
max. new diameter ²	0.5	1.0	1.5	2.0	0.8	1.8	2.3	3.5	4.6	5.8	7.6	10.5
max. recut diameter ³	1.0	1.4	2.2	2.8	1.0	2.2	2.4	3.7	5.0	7.5	8.0	11.0
H - Maximum recommended die hole diameter (mm) when drawing hard wire												
max. new diameter ²	0.4	0.7	1.1	1.4	0.6	1.3	1.6	2.5	3.2	4.1	5.3	7.4
max. recut diameter ³	0.7	1.0	1.5	2.0	0.7	1.5	1.7	2.6	3.5	5.3	5.6	7.7
Grain Size (µm)												
1	D6-N1	D12-N1	D15-N1	D18-N1	D12-S1	D15-S1	D18-S1					
3					D12-S3	D15-S3	D18-S3	D21-S3	D24-S3			
5	D6-N5	D12-N5	D15-N5	D18-N5	D12-S5	D15-S5	D18-S5	D21-S5	D24-S5	D27-S5	D30-S5	
12	D6-N12	D12-N12	D15-N12	D18-N12	D12-S12	D15-S12	D18-S12	D21-S12	D24-S12	D27-S12	D30-S12	D33-S12
25	D6-N25	D12-N25	D15-N25	D18-N25	D12-S25	D15-S25	D18-S25	D21-S25	D24-S25	D27-S25	D30-S25	D33-S25
50						D15-S50	D18-S50	D21-S50	D24-S50	D27-S50	D30-S50	
Blank dimensions (mm)												
total blank diameter ⁴	-	-	-	-	4.0	8.12	8.12	13.65	13.65	24.13	24.13	24.13
diamond diameter	2.5	3.2	5.2	5.2	1.5	4.0	4.0	7.0	7.0	13.0	13.0	15.0
diamond height ⁵	1.0	1.5	2.5	3.5	1.5	2.3	2.9	4.0	5.3	8.6	11.6	15.0
Standard casing dimensions (mm)												
diameter x height ⁶	28 x 8	28 x 10	28 x 12	28 x 15	28 x 10	28 x 12	28 x 15	28 x 15	28 x 15	43 x 27	43 x 27	75 x 40

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¹ Operating temperature for all blanks should not exceed 650°C.

² Maximum recommended diameters for new dies are advised by die blank supplier.

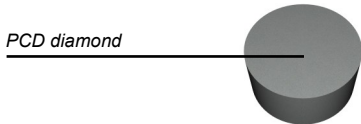
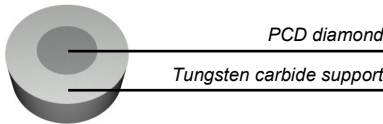
³ Maximum recommended diameters for recut dies are calculated for 21% wire elongation with the following geometries:

- soft wire: reduction angle: 18°, bearing length=30%
- hard wire: reduction angle: 12°, bearing length=30%

⁴ Outside diameter of tungsten carbide support ring

⁵ Other casing dimensions are available on request

Esteves Select PCD Blanks (imperial)

Blank Type ¹	Self-Supported (without support ring)				Supported (with support ring)							
												
ADDMA size	D6	D12	D15	D18	D12	D15	D18	D21	D24	D27	D30	D33
S - Maximum recommended die hole diameter (inch) when drawing soft wire												
max. new diameter ²	.0197	.0394	.0591	.0787	.0315	.0709	.0906	.1378	.1811	.2283	.2992	.4134
max. recut diameter ³	.0394	.0551	.0866	.1102	.0394	.0866	.0945	.1457	.1969	.2953	.3150	.4331
H - Maximum recommended die hole diameter (inch) when drawing hard wire												
max. new diameter ²	.0138	.0276	.0413	.0551	.0220	.0496	.0634	.0965	.1268	.1598	.2094	.2894
max. recut diameter ³	.0276	.0386	.0606	.0772	.0276	.0606	.0661	.1020	.1378	.2067	.2205	.3031
Grain Size (µm)												
1	D6-N1	D12-N1	D15-N1	D18-N1	D12-S1	D15-S1	D18-S1					
3					D12-S3	D15-S3	D18-S3	D21-S3	D24-S3			
5	D6-N5	D12-N5	D15-N5	D18-N5	D12-S5	D15-S5	D18-S5	D21-S5	D24-S5	D27-S5	D30-S5	
12	D6-N12	D12-N12	D15-N12	D18-N12	D12-S12	D15-S12	D18-S12	D21-S12	D24-S12	D27-S12	D30-S12	D33-S12
25	D6-N25	D12-N25	D15-N25	D18-N25	D12-S25	D15-S25	D18-S25	D21-S25	D24-S25	D27-S25	D30-S25	D33-S25
50						D15-S50	D18-S50	D21-S50	D24-S50	D27-S50	D30-S50	
Blank dimensions (inch)												
total blank diameter ⁴	-	-	-	-	.1575	.3197	.3197	.5374	.5374	.9500	.9500	.9500
diamond diameter	.0984	.1260	.2047	.2047	.0591	.1575	.1575	.2756	.2756	.5118	.5118	.5906
diamond height ⁵	.0394	.0591	.0984	.1378	.0591	.0906	.1142	.1575	.2087	.3386	.4567	.5906
Standard casing dimensions (inch)												
diameter x height ⁶	1 1/8 x 3/8	1 1/8 x 3/8	1 1/8 x 1/2	1 1/8 x 1/2	1 1/8 x 3/8	1 1/8 x 1/2	1 1/8 x 1/2	1 1/8 x 5/8	1 1/8 x 5/8	1 1/2 x 7/8	1 1/2 x 7/8	1 1/2 x 7/8

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² Maximum recommended diameters for new dies are advised by die blank supplier.

³ Maximum recommended diameters for recut dies are calculated for 21% wire elongation with the following geometries:

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