Bunching, stranding & compacting dies

Cabling tools

www.estevesgroup.com

Highlights

- Tooling tailored to your stranding process
- Available in a wide size range
- Superior performance and wire quality
- Available in TC, PCD, SSCD and ND and as diamond coated dies (DC)

Esteves Group bunching, stranding, and compacting dies for high quality cable.

Bunching, stranding, and compacting dies are commonly used to guide and compact wires to create cables that usually consist of several electrically conducting wires. Applications include high, medium and low voltage cables and automotive wires.

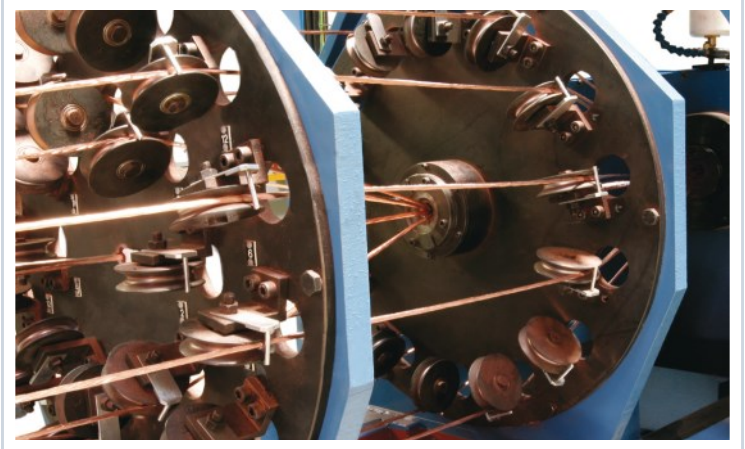
Esteves Group bunching, stranding, and compacting dies have well blended profiles with highly polished surfaces enabling superior performance and wire quality.

Esteves Group offers a wide variety of materials for you to choose from to meet your cabling requirements.

Higher **throughput, fewer die changes**, **less scrap**, and **higher quality** all add up to more profit for the wire and cable manufacturer.

We Specialize in...

- Wire Drawing Dies
- Bunching, Stranding & Compacting Dies
- Split Dies
- Tubing Dies
- Shaped Dies
- Extrusion Tooling
- Die Reconditioning Tools
- Engineering Services
- Customer Support



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Key Features

- Optimal die profile, tailored to your process
- Available in a wide size range
- Available in TC, PCD, SSCD and ND and as diamond coated dies

Benefits

- Superior performance and wire quality
- Low surface friction
- Smooth wire surface

Bunching and Stranding Die Specifications

Product name		Bunching Die	Stranding Die	Compacting Die
Standard size range	Tungsten Carbide (TC)	≥ 0.800 mm		
	Diamond Coated Tungsten Carbide (DC)	10.0 – 77 mm		
	Polycrystalline Diamond (PCD)	Up to 35 mm		
	Single Crystal Diamond (SSCD/ND)	Up to 1.5 mm		
Standard tolerance		Tolerance depends on hole diameter		
Available angles		Matched to stranding process		
Standard angle tolerance		± 2°		

Tungsten Carbide Die Standard Tolerances

Metric tolerances [mm]	
Diameter	Tolerance
≥ 0.800	+0 / -0.0150

PCD, SSCD and ND Die Standard Tolerances

Metric tolerances [mm]		
Diameter	Tolerance	Max. ovality
≤ 0.020	+0 / -1.5% x Ø	1.5% x Ø
0.021 - 0.025	+0 / -0.0003	0.0002
0.026 - 0.050	+0 / -0.0004	0.0003
0.051 - 0.075	+0 / -0.0006	0.0004
0.076 - 0.100	+0 / -0.0008	0.0004
0.101 - 0.200	+0 / -0.001	0.001
0.201 - 0.500	+0 / -0.002	0.0015
0.501 - 1.000	+0 / -0.003	0.002
1.001 - 2.000	+0 / -0.004	0.0025
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Metric tolerances [mm]		
Diameter	Tolerance	Max. ovality
2.001 - 3.500	+0 / -0.005	0.003
3.501 - 5.500	+0 / -0.006	0.0035
5.501 - 8.000	+0 / -0.007	0.004
8.001 - 10.00	+0 / -0.008	0.004
10.001 - 12.0	+0 / -0.010	0.005
12.001 - 15.0	+0 / -0.012	0.006
15.001 - 18.0	+0 / -0.014	0.007
18.001 - 21.0	+0 / -0.016	0.008
21.001 - 24.0	+0 / -0.018	0.009
24.001 - 35.0	+0 / -0.020	0.010

Tighter tolerances are available when required

More drawing die types, cabling tooling, and extrusion tools are available.
Please contact **Esteves Group** for a quotation for your wire and cable tooling.

Drawing, and cabling tooling below:
TC dies, PCD dies, ND dies, split dies, extrusion tools

Detailed technical specifications available on request. Names, pictures, and specifications of all products are subject to change without further notice. © Esteves Group, 2019-03-EU-R1