



# 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.

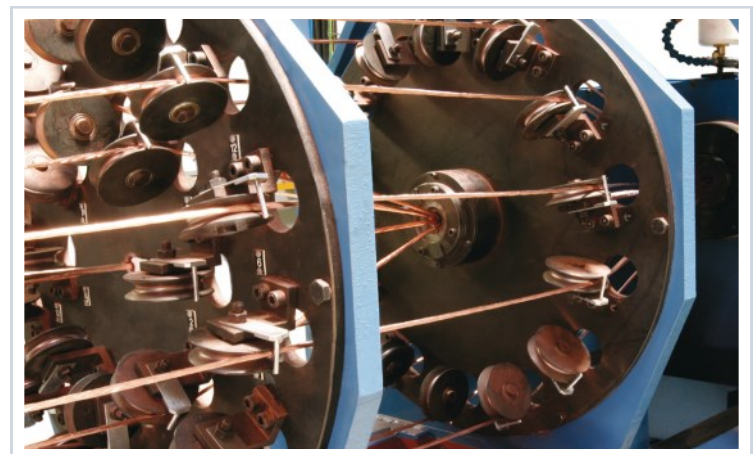
**Esteves Group** bunching, stranding, and compacting dies have well blended profiles with highly polished surfaces enabling superior performance and wire quality.

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





# Bunching, stranding & compacting dies

## Cabling tools

### 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) |              |                                    | ≥ .005"                      |                |
| Diamond Coated Tungsten Carbide (DC)  |                            |                       | .315 – 3.03" |                                    |                              |                |
| Polycrystalline Diamond (PCD)   |                            |                       | Up to 1.38"  |                                    |                              |                |
| Single Crystal Diamond (SSCD/ND)  |                            |                       | Up to .059"  |                                    |                              |                |
| Standard tolerance  |                            |                       |              | Tolerance depends on hole diameter |                              |                |
| Available angles  |                            |                       |              | Matched to stranding process       |                              |                |
| Standard angle tolerance  |                            |                       |              | ± 2°                               |                              |                |
| Tungsten Carbide Die Standard Tolerances<br><i>(Tighter tolerances are available when required)</i> | Imperial tolerances [inch] |                       |              | Imperial tolerances [inch]         |                              |                |
|   | Diameter                   | Tolerance             |              | Diameter                           | Tolerance                    |                |
|   | .0050 - .009               | +0 / -.0002           |              | .1031 - .295                       | +0 / -.001                   |                |
|   | .0091 - .052               | +0 / -.0003           |              | .2951 - .500                       | +0 / -.002                   |                |
|   | .0521 - .103               | +0 / -.0005           |              | .5001 - 1.00                       | +0 / -.003                   |                |
|   | Continued ⇨                |                       |              | ≥ .1001                            | Please contact Esteves Group |                |
| PCD, SSCD and ND Die Standard Tolerances<br><i>(Tighter tolerances are available when required)</i> | Imperial tolerances [inch] |                       |              | Imperial tolerances [inch]         |                              |                |
|   | Diameter                   | Tolerance             | Max. ovality | Diameter                           | Tolerance                    | Max. ovality   |
|   | ≤ .001                     | +0 / -1.5% x Ø        | 1.5% x Ø     | .0791 - .1380                      | +0 / -.00020                 | .00012         |
|   | .0008 - .0010              | +0 / -.00001          | .00001       | .1381 - .2170                      | +0 / -.00024                 | .00014         |
|   | .0011 - .0020              | +0 / -.00002          | .00001       | .2171 - .3150                      | +0 / -.00028                 | .00016         |
|   | .0021 - .0030              | +0 / -.00002          | .00002       | .3151 - .3940                      | +0 / -.00031                 | .00016         |
|   | .0031 - .0040              | +0 / -.00003          | .00002       | .3941 - .4720                      | +0 / -.00039                 | .00020         |
|   | .0041 - .0080              | +0 / -.00004          | .00004       | .4721 - .5910                      | +0 / -.00047                 | .00024         |
|   | .0081 - .0200              | +0 / -.00008          | .00006       | .5911 - .7090                      | +0 / -.00055                 | .00028         |
|   | .0201 - .0390              | +0 / -.00012          | .00008       | .7091 - .8270                      | +0 / -.00063                 | .00031         |
|   | .0391 - .0790              | +0 / -.00016          | .00010       | .8271 - .9450                      | +0 / -.00071                 | .00035         |
|   | Continued ⇨                |                       |              | .9451 - 1.378                      | +0 / -.00079                 | .00039         |

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

