



ESTEVES
GROUP

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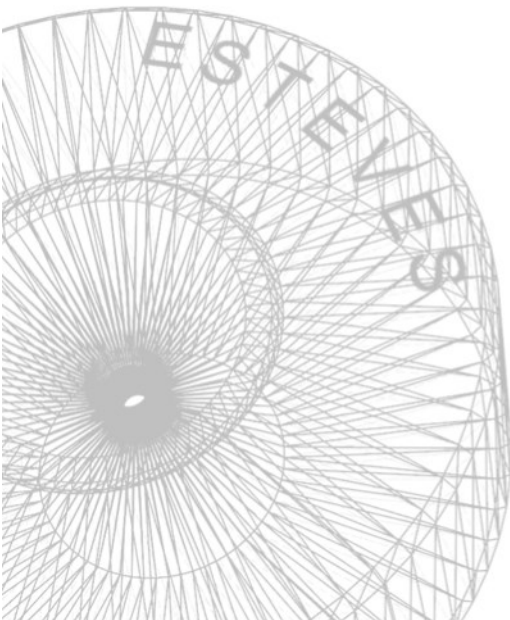
Natural diamond dies

Wire drawing dies



Highlights

- Ideal for fine and super fine wires
- Low surface friction
- Smooth wire surface
- Ultra-high accuracy dies available
- From .00019-.0787" [0.005 to 2 mm]



High performance natural diamond dies allow wire manufacturers to meet wire surface quality, and dimension standards.

Wire drawing dies are commonly used to reduce the diameter of various ferrous and non-ferrous rods and wires. Applications include high, medium and low voltage cables, automotive, medical wire, superconducting, and bonding wire.

Esteves Group natural diamond drawing dies (ND dies) give the wire manufacturer the ability to produce even smallest sizes of wires with uniform wire roundness and high surface quality while meeting or exceeding the required wire diameter tolerances.

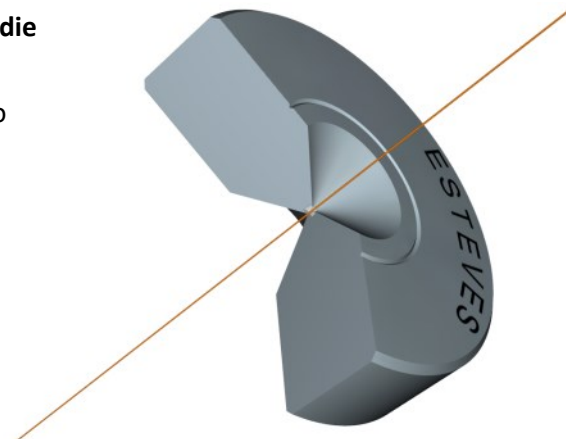
ND dies enable long drawing die life with long lasting dimensional tolerances, even for high demanding applications. Esteves Group ND drawing dies are manufactured with a mirror polish and a smooth wire entry to ensure optimal die life and string-up.

Esteves Group offers a complete line of ND drawing dies for small to ultra fine wire.

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

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





Natural diamond dies

Wire drawing dies

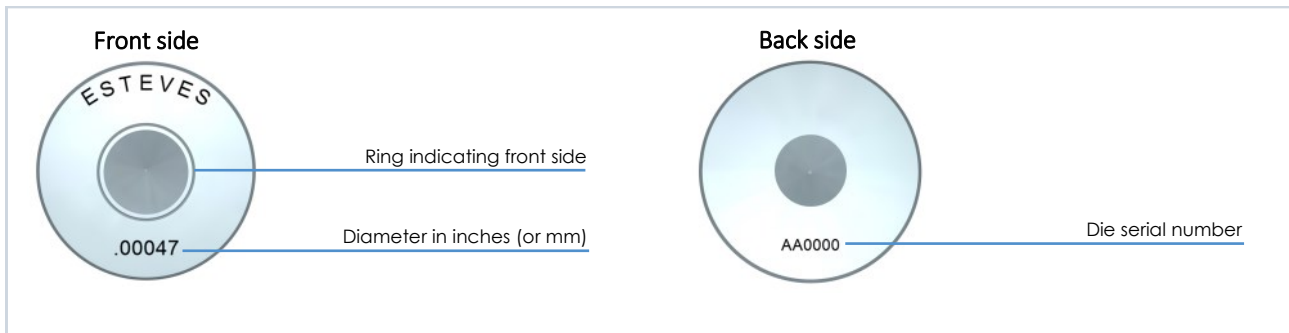
Key Features

- High quality natural diamond only
- High-temperature resistant
- Ultra-high accuracy dies available
- Available from .00019-.0787" [0.005 to 2 mm]

Benefits

- Ideal for fine and super fine wires
- Low surface friction
- Smooth wire surface

STANDARD PRODUCT CODING



Please contact Esteves Group for any special engraving requirements.

ND Wire Drawing Die Standard Tolerances

Diameter	Imperial tolerances [inch]		Diameter	Metric tolerances [mm]	
	Tolerance	Max. ovality		Tolerance	Max. ovality
≤ .001	+0 / -1.5% x Ø	1.5% x Ø	≤ 0.020	+0 / -1.5% x Ø	1.5% x Ø
.0008 - .0010	+0 / -.00001	.00001	0.021 - 0.025	+0 / -0.0003	0.0002
.0011 - .0020	+0 / -.00002	.00001	0.026 - 0.050	+0 / -0.0004	0.0003
.0021 - .0030	+0 / -.00002	.00002	0.051 - 0.075	+0 / -0.0006	0.0004
.0031 - .0040	+0 / -.00003	.00002	0.076 - 0.100	+0 / -0.0008	0.0004
.0041 - .0080	+0 / -.00004	.00004	0.101 - 0.200	+0 / -0.001	0.001
.0081 - .0200	+0 / -.00008	.00006	0.201 - 0.500	+0 / -0.002	0.0015
.0201 - .0390	+0 / -.00012	.00008	0.501 - 1.000	+0 / -0.003	0.002
.0391 - .0790	+0 / -.00016	.00010	1.001 - 2.000	+0 / -0.004	0.0025
.0791 - .1380	+0 / -.00020	.00012	2.001 - 3.500	+0 / -0.005	0.003

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, SSD dies, bunching and stranding dies, split dies, extrusion tools

