



ESTEVES  
GROUP

www.estevesgroup.com

# Refurbishing services

## Drawing die recutting/repolishing/resizing



## Highlights

- Drawing die cost savings by re-using dies
- Recover initial drawing die performance
- Easy ordering, one price per size
- Available for TC, PCD, SSCD and ND dies

**Die refurbishing services save costs by restoring or enhancing the original performance in drawing dies.**

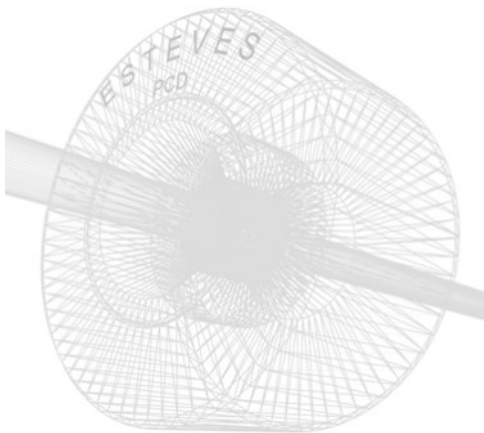
At Esteves Group, we have spent years developing processes that have helped the wire drawing industry save cost.

This experience delivers recutting, repolishing, and resizing capabilities that fully recover or sometimes enhance the initial drawing die performance.

Drawing dies can usually be reused several times. When you send your dies to us to be refurbished we will inform you about the die condition, if we detect any abnormal wear, and if the dies can be repolished or need to be recut.

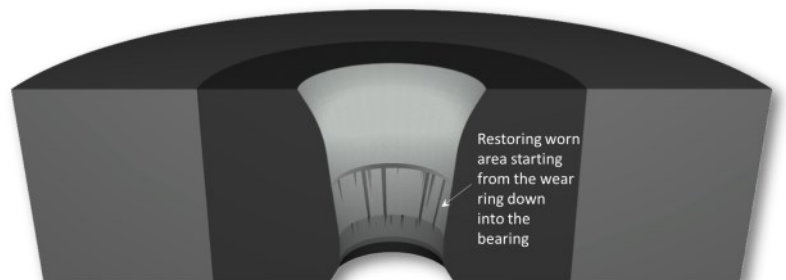
You can count on us to find the most cost-effective solution for your die recutting needs.

**Esteves Group** die refurbishing is available for all types of diamond and carbide drawing dies, regardless of the original 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





# Refurbishing services

## Drawing die recutting/repolishing/resizing

### Key Features

- Available for TC, PCD, SSCD and ND dies
- Recutting and resizing of dies
- Die repolishing when wear is slight
- Die profile changes possible

### Benefits

- Drawing die cost savings by reusing your dies
- Fully recover or enhance initial drawing die performance
- Fast turn-around time
- Easy ordering, one price per size

### Diamond Wire Drawing Die Standard Tolerances

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

Tighter tolerances are available when required

### Tungsten Carbide Wire Drawing Die Standard Tolerances

Imperial tolerances [inch]	
Diameter	Tolerance
.0050 - .009	+0 / -.0002
.0091 - .052	+0 / -.0003
.0521 - .103	+0 / -.0005
.1031 - .295	+0 / -.001
.2951 - .500	+0 / -.002
.5001 - 1.00	+0 / -.003
≥ .1001	Please contact Esteves Group

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, bunching and stranding dies, split dies, extrusion tools

