



Tungsten carbide dies

Wire drawing dies

www.estevesgroup.com



Highlights

- Virtually no maximum size
- Ideal for ferrous rod-size wire
- Ideal for short runs and trial runs
- Several grades available
- Starting from .004"

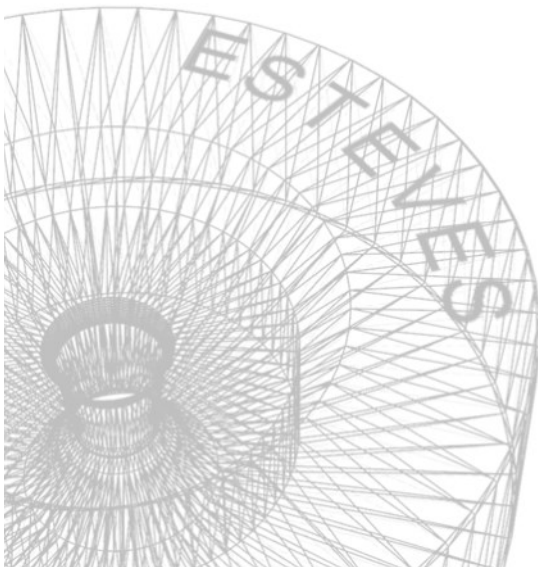
High performance tungsten carbide drawing dies allow wire drawing companies to meet quality, uptime and speed standards.

Wire drawing dies are commonly used to reduce the diameter of various ferrous and non-ferrous rods and wires. Applications include various grades of low, medium and high carbon steels, steel alloys, stainless steel, welding wire as well as various non-ferrous rods and wires.

Esteves Group tungsten carbide drawing dies (TC dies) give the wire manufacturer the ability to maintain uniform wire roundness, minimizing material usage and scrap.

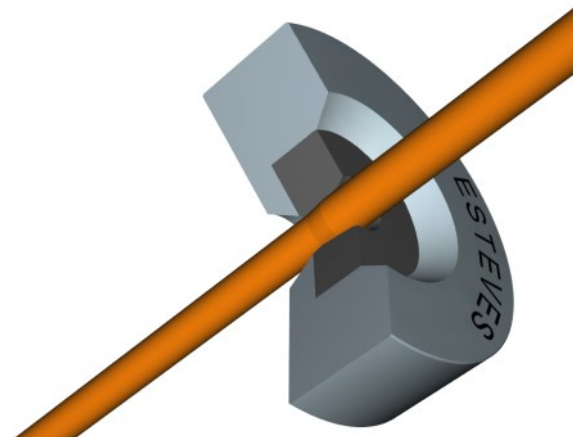
Tungsten carbide dies are an excellent option for manufacturing ferrous rod-size wires. They are also ideal for short trial runs. Esteves Group TC drawing dies are manufactured with a mirror polish and a smooth wire entry to ensure optimal die life and string-up.

Esteves Group offers a complete line of TC drawing dies for rod-size wire down to medium-size 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





Tungsten carbide dies

Wire drawing dies

Key Features

- Usable for dry and wet draw
- Available in any casing size
- Various carbide grades available
- Low cost dies
- Starting from .004"

Benefits

- Ideal for ferrous rod-size wire
- Ideal for short and trial runs
- Wire remains round, even with significant wear
- Carbide grade tailored to wire material when required
- Predictable cast & helix

| Blank Type | Tungsten Carbide | | | | | | | |
|--|-------------------|-------------------|-------------------|-------------------|-------------------|-------------------|-------------------|-------------------|
| size | R2 | R3 | R4 | R5 | R6 | R7 | R8 | R9 |
| <i>Standard die hole diameter (inch)¹</i> | | | | | | | | |
| new die size range | .004 - .106 | .008 - .128 | .015 - .230 | .020 - .280 | .025 - .350 | .100 - .425 | .220 - .516 | .310 - .687 |
| <i>Standard casing dimensions²</i> | | | | | | | | |
| diameter [inch] | 1.0 or 1.5 | 1 or 1.5 | 1.5 | 1.5 | 2.0 | 3.0 | 3.0 | 3.0 |
| height [inch] | .5625 or .75 | .75 | .75 | .875 | 1.125 | 1.375 | 1.75 | 1.75 |

| Blank Type | Tungsten Carbide | | | | | | | |
|---|-------------------|--------------------|--------------------|---------------------|---------------------|---------------------|---------------------|------------------------------|
| size | R10 | R11 | R12 | R14 | R15 | R16 | R17 | ≥ R18 |
| <i>Recommended die hole diameter - inches¹</i> | | | | | | | | |
| new die size range | .400 - .875 | .710 - 1.250 | .950 - 1.500 | 1.225 - 1.750 | 1.475 - 2.250 | 1.850 - 2.500 | 2.225 - 3.000 | Please contact Esteves Group |
| <i>Standard casing dimensions²</i> | | | | | | | | |
| diameter [inch] | 3.0 or 4.0 | 3.0 or 4.0 | 4.0 | 6.0 | 6.0 or 7.0 | 6.0 or 7.0 | 9.0 | Please contact Esteves Group |
| height [inch] | 2.0 | 2.25 | 2.375 | 2.5 | 2.5 | 2.5 | 3.0 | Please contact Esteves Group |

¹ Other sizes are available on request

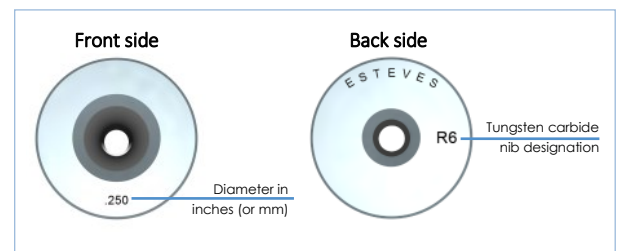
² More casing dimensions are available

TC Wire Drawing Die Standard Tolerances

| 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 |

Tighter tolerances are available when required

STANDARD PRODUCT CODING



Please contact Esteves Group for any special engraving requirements

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:
PCD dies, SSCD dies, ND dies, shape dies, bunching and stranding dies, split dies

