



ESTEVESES
GROUP

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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.

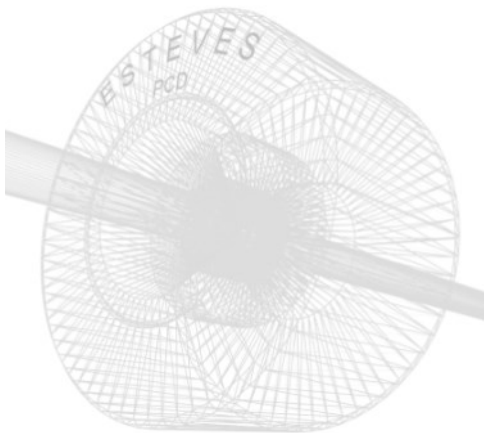
At Esteves Group, we have spent years developing processes that have helped the wire drawing industry save cost.

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

PCD, SSCD, and ND Die Standard Tolerances

	Imperial tolerances [inch]			Metric tolerances [mm]		
	Diameter	Tolerance	Max. ovality	Diameter	Tolerance	Max. ovality
	.00027 - .00560	± .00002	.00002	0.007 - 0.141	± 0.00051	0.00051
	.00561 - .00891	± .00003	.00003	0.142 - 0.226	± 0.00076	0.00076
	.00892 - .01263	± .00004	.00004	0.227 - 0.320	± 0.00102	0.00102
	.01264 - .02009	± .00005	.00005	0.321 - 0.510	± 0.00127	0.00127
	.02010 - .02845	± .00006	.00006	0.511 - 0.722	± 0.00152	0.00152
	.02846 - .04029	± .00007	.00007	0.723 - 1.023	± 0.00178	0.00178
	.04030 - .05706	± .00008	.00008	1.024 - 1.449	± 0.00203	0.00203
	.05707 - .08079	± .00009	.00009	1.450 - 2.051	± 0.00229	0.00229
	.08080 - .14427	± .00010	.00010	2.052 - 3.664	± 0.00254	0.00254
	.14428 - .22941	± .00012	.00012	3.665 - 5.826	± 0.00305	0.00305
	.22942 - .32485	± .00014	.00014	5.827 - 8.250	± 0.00356	0.00356
	.32486 - .36479	± .00016	.00016	8.251 - 9.265	± 0.00406	0.00406
	.36480 - .40963	± .00018	.00018	9.266 - 10.404	± 0.00457	0.00457
	.40964 - .45999	± .00020	.00020	10.405 - 11.683	± 0.00508	0.00508
	.46000 - .51654	± .00022	.00022	11.684 - 13.119	± 0.00559	0.00559
	.51655 - .58004	± .00024	.00024	13.120 - 14.732	± 0.00610	0.00610
	.58005 - .65135	± .00026	.00026	14.733 - 16.544	± 0.00660	0.00660
	.65136 - .73142	± .00028	.00028	16.545 - 18.577	± 0.00711	0.00711
	.73143 - .82134	± .00030	.00030	18.578 - 20.861	± 0.00762	0.00762
	.82135 - .92232	± .00032	.00032	20.862 - 23.426	± 0.00813	0.00813
	.92233 - 1.3780	± .00035	.00035	23.427 - 35.000	± 0.00889	0.00889

Tighter tolerances are available when required



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Tungsten Carbide Die Standard Tolerances

Imperial tolerances [inch]		Imperial tolerances [inch]	
Diameter	Tolerance	Diameter	Tolerance
.0050 - .009	+0 / -.0002	0.127 - 0.230	+0 / -.00051
.0091 - .052	+0 / -.0003	0.231 - 1.322	+0 / -.00076
.0521 - .103	+0 / -.0005	1.323 - 2.618	+0 / -.00127
.1031 - .295	+0 / -.001	2.619 - 7.495	+0 / -.00254
.2951 - .500	+0 / -.002	7.496 - 12.724	+0 / -.00508
.5001 - 1.000	+0 / -.003	12.725 - 25.424	+0 / -.00762
1.001 - 7.000	+0 / -.004	25.425 - 177.80	+0 / -.01016

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





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