



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.

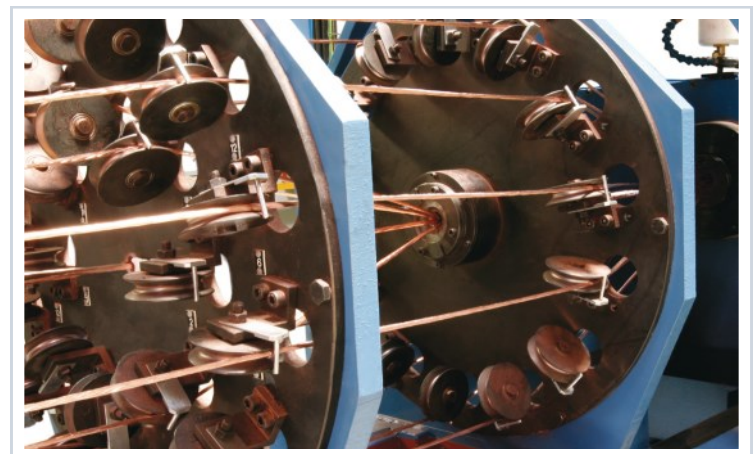
Esteves Group bunching, stranding, and compacting dies have well blended profiles with highly polished surfaces enabling superior performance and wire quality.

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

www.estevesgroup.com



Bunching and Stranding Die Specifications	Product name		Bunching Die	Stranding Die	Compacting Die
	Standard size range	Tungsten Carbide (TC)		≥ .005" [≥ 0.800 mm]	
Diamond Coated Tungsten Carbide (DC)			.3937 – 3.03" [10.0 – 77 mm]		
Polycrystalline Diamond (PCD)			Up to 1.38" [Up to 35 mm]		
Single Crystal Diamond (SSCD/ND)			Up to .059" [Up to 1.5 mm]		
Standard tolerance			Tolerance depends on hole diameter		
Available angles			Matched to stranding process		
Standard angle tolerance			± 2°		

Standard product coding	Blank material	Front engraving	Back engraving
		Polycrystalline diamond (PCD)	<p>Polycrystalline diamond die identifier Ring indicating front side Diameter in inches (or mm)</p>
Synthetic single crystal diamond (SSCD)	<p>Synthetic single crystal diamond die identifier Ring indicating front side Diameter in inches (or mm)</p>	<p>Synthetic single crystal diamond die type Die serial number</p>	
Natural diamond (ND)	<p>Ring indicating front side Diameter in inches (or mm)</p>	<p>Die serial number</p>	
Tungsten carbide (TC)	<p>Diameter in inches (or mm)</p>	<p>Tungsten carbide nib designation</p>	



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

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



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

Tungsten Carbide Die Standard Tolerances

Imperial tolerances [inch]		Metric tolerances [mm]	
Diameter	Tolerance	Diameter	Tolerance
.0050 - .009	+0 / -.0002	0.127 - 0.230	+0 / -0.0051
.0091 - .052	+0 / -.0003	0.231 - 1.322	+0 / -0.0076
.0521 - .103	+0 / -.0005	1.323 - 2.618	+0 / -0.0127
.1031 - .295	+0 / -.001	2.619 - 7.495	+0 / -0.0254
.2951 - .500	+0 / -.002	7.496 - 12.724	+0 / -0.0508
.5001 - 1.000	+0 / -.003	12.725 - 25.424	+0 / -0.0762
1.001 - 7.000	+0 / -.004	25.425 - 177.80	+0 / -0.1016

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, split dies, extrusion tools

