

# Custom-Made Shaped Wire Drawing Dies

## / SPECIFICATIONS

Fort Wayne Wire Die produces dies in a wide variety of shapes, including half-round, oval, hexagon, rectangle, triangle, square and flat. Fort Wayne Wire Die will also custom-manufacture specially shaped dies upon request. For uniquely shaped wire requirements, Fort Wayne Wire Die designers can create a series of dies that will gradually deform the wire from round to the desired shape in a sequence of reductions that optimize your drawing machine capabilities.

Shaped dies come in Poly-Di® polycrystalline diamond and tungsten carbide. Poly-Di polycrystalline diamond dies maintain high wear resistance and work best with nonferrous metals, such as copper and aluminum. Tungsten carbide dies offer dependable quality, and they are especially useful in steel wire applications or when short runs do not justify the expense of polycrystalline diamond material.



### DIMENSIONAL LIMITS

	Tungsten Carbide / Tool Steel	Polycrystalline Diamond
Minimum Height and Width	.020 in / 0.5 mm	.040 in / 1.0 mm
Minimum Corner Radius	.004 in / 0.1 mm	.010 in / 0.25 mm
Minimum Tolerance	.0005 in / 0.0125 mm	.0005 in / 0.0125 mm

\*Limits not applicable in all applications.

### POLY-DI STANDARD CASING SIZES

	INCH	MILLIMETER
<b>BLANK SIZE</b>	<b>CASING SIZE D X T</b>	<b>CASING SIZE D X T</b>
D-6 thru D-12	1 or 1 1/8 x 3/8	25 or 28 x 10
D-15 thru D-24	1 or 1 1/8 x 1/2	25 or 28 x 12
D-27 thru D-30	1 1/2 x 7/8	38 x 22
D-33	2 x 1 1/8	51 x 28
D-36	3 x 2	76 x 51

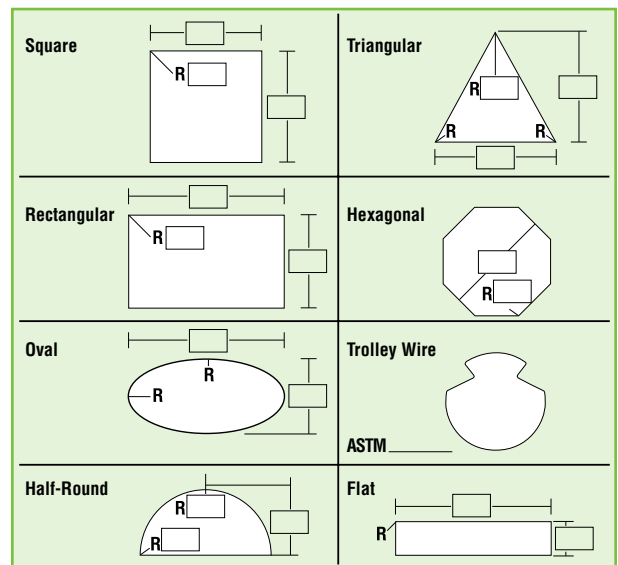
\*Special casing sizes available upon request.

### TUNGSTEN CARBIDE STANDARD CASING SIZES

	INCH	MILLIMETER
<b>BLANK SIZE</b>	<b>CASING SIZE D X T</b>	<b>CASING SIZE D X T</b>
R-2 thru R-5	1 1/2 x 7/8	38 x 22
R-6	2 x 1 1/8	50 x 28
R-7	2 x 1 3/8	50 x 35
R-8 and R-9	3 x 1 3/4	75 x 44
R-10	3 x 2	75 x 50
R-11	4 x 2 1/4	100 x 56
R-12	4 x 2 3/8	100 x 60

Poly-Di® is a registered trademark of Fort Wayne Wire Die, Inc.

### TYPICAL DIE SHAPES



Special shapes available by request.

### ORDERING INFORMATION

To assure prompt service, please be sure that the following information appears on the quotation request.

- 1 Finish Profile \_\_\_\_\_
- 2 Material Being Drawn \_\_\_\_\_
- 3 Incoming Wire Size and Shape \_\_\_\_\_
- 4 All Critical Dimensions \_\_\_\_\_
- 5 Corner Radius (R) \_\_\_\_\_
- 6 Reduction Angle \_\_\_\_\_
- 7 Die Nib Size \_\_\_\_\_
- 8 Bearing Length \_\_\_\_\_
- 9 Casing Size \_\_\_\_\_

Mail or fax your complete ordering information to the address below.



Fort Wayne Wire Die, Inc.

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