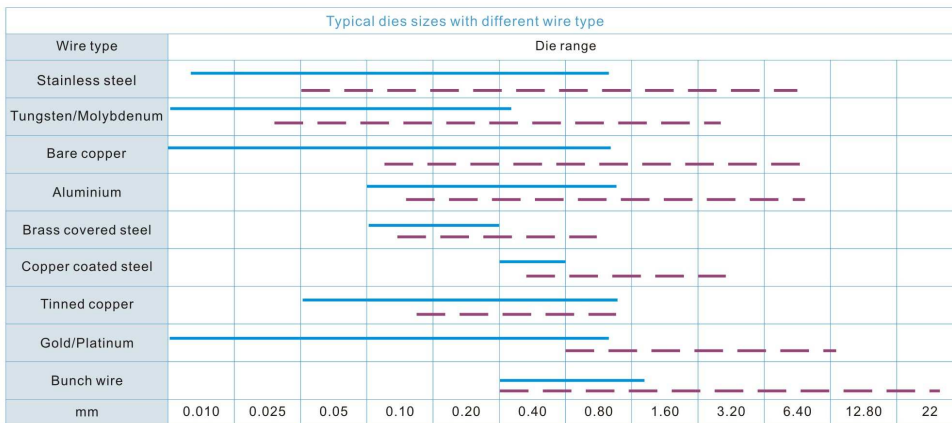




Contrast of Die Service Life												
Wire Material	Size(m m)	Area Reducti on(%)	Relief Angle (°)	ND		PCD		Drawing Speed(m/ min)	Die Service Life			Application
				Reduction Angle(°)	Bearing Length(%)	Reduction Angle(°)	Bearing Length(%)		TC	ND(m ultriple)	PCD(multipl e)	
Nonferrous												
Copper	0.05-1.60	18-21	15	16-20	30-50	16-20	15-35	600-3300	1	40-100	200-500	Electrical wire, Magnet wire
	1.60-7.60	20-35	15			16-25	15-35	600-2500	1		200-500	Cable
Aluminum	0.20-1.60	15-22	15	18-22	15-35	18-22	15-35	600-2000	1	30-80	100-200	Cable, Magnet wire
	1.60-7.60	18-30	15			16-25	15-35	600-1500	1		100-200	Cable
Aluminium Magnesium Alloy	2.00-5.00	18-22	15			16-20	20-40	350-650	1		100-200	TC cable, Braided wire
Tin-Plated Copper(electroplated)	0.20-1.60	15-26	20	18-22	10-30	18-22	20-40	300-1000	1	10-40	100-200	Electron ray tube, Light
Nickel 200	0.30-1.60	20-30	5	16-20	30-50	16-20	20-40	200-500	1	50-80	100-200	Electronic instrument, Welding wire
Tungsten	0.10-1.00	18-22	5	12-16	40-60	12-16	20-40	30-80	1	50-80	100-200	Light, Instruments
Molybdenum	0.10-1.00	18-22	5	12-16	40-60	12-16	20-40	30-80	1	10-30	50-80	Cut wire
Ferrous												
Galvanized High Carbon Steel	0.20-1.50	15-20	5	10-14	40-60	10-14	25-45	400-800	1	5-25	30-50	Screen, Spring, Rope
Brass-Plated High Carbon Steel	0.15-0.50	18-21	5	10-16	40-60	10-16	25-45	600-1000	1	5-20	10-30	Tire Cords
Stainless Steel 316	0.15-1.60	18-21	5	10-14	40-60	10-14	25-45	200-600	1	4-8	10-20	Mesh, Welding wire
Stainless Steel 302	0.15-1.60	18-21	5	10-14	40-60	10-14	25-45	200-600	1	2-4	8-15	Spring, Welding wire
Ni-Cr-Fe Alloy 60:15:25	0.20-1.20	18-26	5	10-14	40-60	10-14	25-45	200-600	1	5-20	30-50	High temperature electric furnaces
Low Carbon Steel	0.20-1.60	18-21	5	8-14	40-60	8-14	25-45	400-800	1	5-20	30-70	Building wire, Welding wire, Rope



— ND - - - PCD