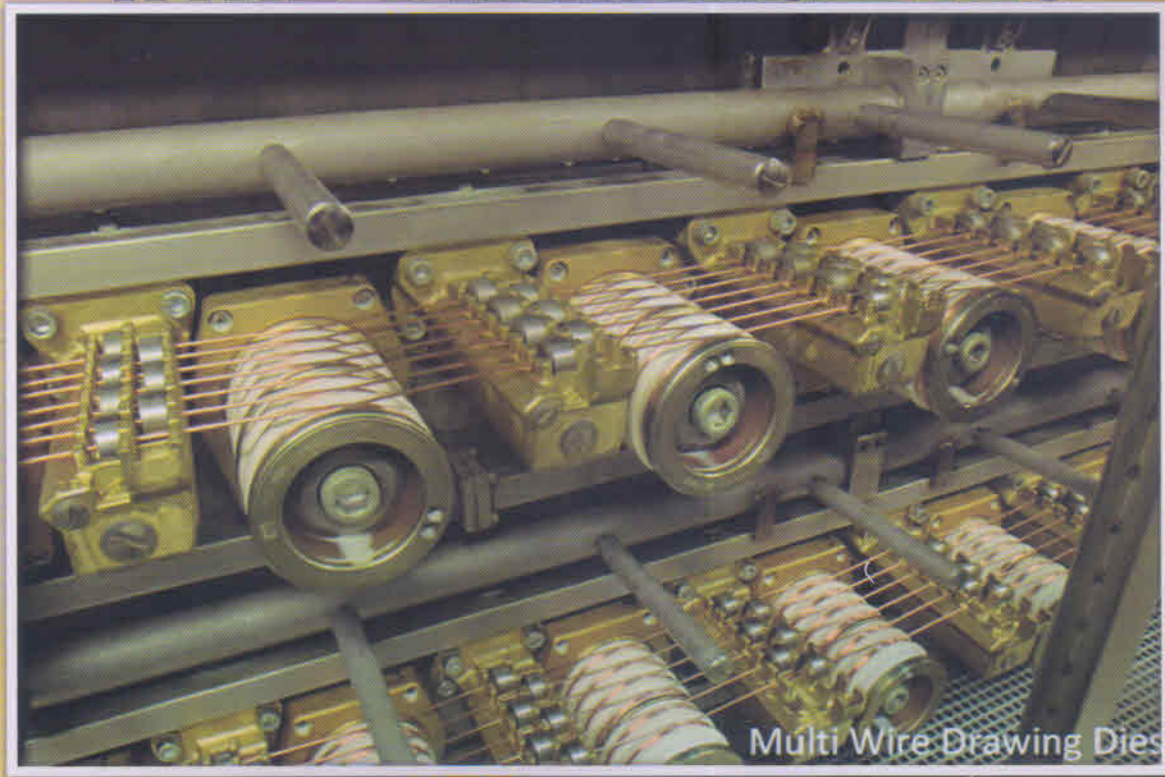
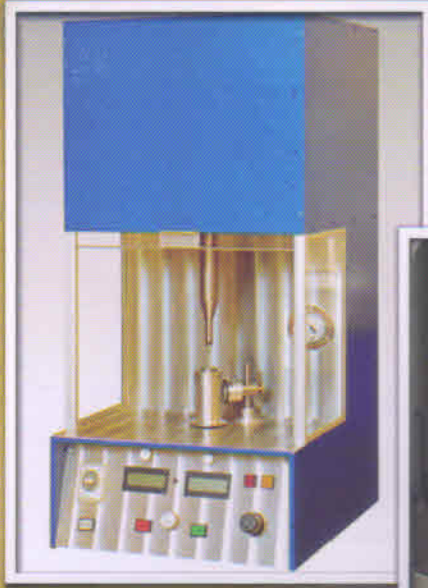


WIRE DRAWING DIES

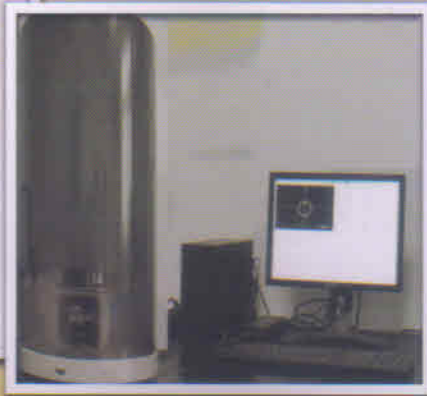


SHREE
M **MAHALAXMI**
DIE INDUSTRIES

SURAT-395 003. GUJARAT. (INDIA)
E mail : mahalaxmidie@yahoo.co.in



Ultra Sonic Machine
Leyer & Kikus. De Germany



Profile Measurement System

MAHALAXMI WIRE DRAWING DIES have been tested successfully on most non-ferrous metals, since Fifty Five years. On copper and aluminium for example Synthetic die bore life is up to 200 times better than tungsten carbide and 3-5 times greater than that of a diamond single crystal.

Now we are in collaboration with world's leader sterling die technology U.S.A. We have Fully developed technology from U.S.A. and Europe, for export of our product to global market.

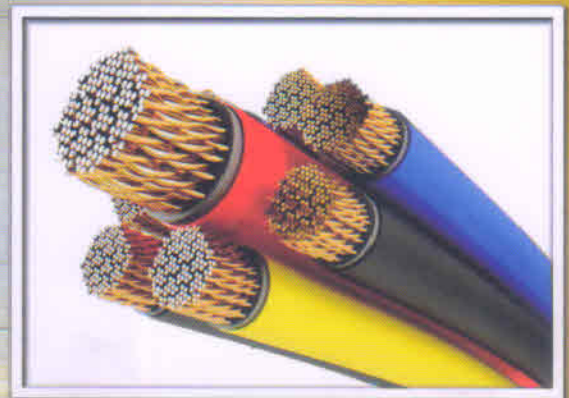


MAHALAXMI wire drawing dies are particularly recommended for use on Following Materials. From rod to Finish Size.

- Copper
- Aluminium
- Stainless Steel
- Alloy Steels
- Low Carbon Steel
- Tungsten.
- Molybdenum
- Tyre-cord (brass-Coated Steel)
- Nickel.

MAHALAXMI wire drawing dies have proved to be highly cost effective in many wire drawing operation. The consistent high performance obtained with the dies has had a significant impact on a number of factors that enter into the cost of wire drawing in less downtime required due to restringing worn dies, die maintenance costs are generally decreased, more wire is drawn due to less downtime, the number of recuts per die has been increased.

Together, all these factors, facilitated by the advent of **MAHALAXMI** wire dies, can represent a major cost savings in a wire drawing operation.



Copper Wire Cable

When Quality really counts,
You can count on **MAHALAXMI** wire drawing dies

While Synthetics Diamond Wire drawing dies can't last forever, We are doing everything, we can to give you dies that maintain higher wire quality over a longer service life.

As recutting service single crystal natural diamond, Poly crystalline diamond or tungsten carbide old dies perform with new die quality after being recut at our unit.



Synthetic Diamond Powder

We've been satisfying the needs of the wire industry for more than fifty five years. This is Experience that has made us a leader in the development of wire drawing die for better performance of wire drawing.



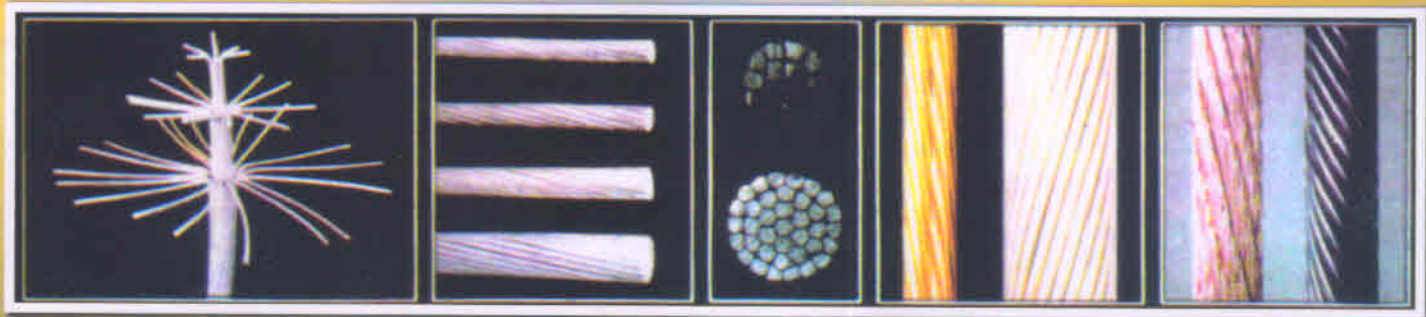
Synthetic wire drawing Dies/Single Crystal Diamond

MAHALAXMI wire drawing blanks are of Ultra-fine grain structure that you can't get in any other die. Cleavage faults are eliminated. The die wears longer, runs cooler and you get a consistently beautiful wire finish throughout the dies service life. Available in an extremely wide range of sizes for virtually any wire diameter.

Whether you are drawing wire fabricating dies **MAHALAXMI** can help you deliver a better product for less.



Laser Drilling System



Different Types of wires drawn from Dies.

TUNGSTEN CARBIDE SUPPORTED DIE BLANKS

Product Code	ADDM A Code	Total Blank Diameter (mm)	Diamond Diameter (mm)	Diamond Thickness (mm)	Max. Recommended hole size (mm)	Grain Size (μm)
T4015	D-12	8,12	4.0	1.5	1.0	5,10,15,25,50
T4023	D-15	8,12	4.0	2.3	1.8	5,10,15,25,50
T4029	D-18	8,12	4.0	2.9	2.3	5,10,15,25,50
T7040	D-21	13,65	7.0	4.0	3.5	5,10,15,25,50
T7053	D-24	13,65	7.0	5.3	4.6	5,10,15,25,50
T13086	D-27	24,13	13.0	8.6	6.1	10,15,25,50
T130116	D-30	24,13	13.0	11.6	7.6	10,15,25,50
T150120	D-31	24,13	13.0	12.0	8.0	25,50
T150150	D-33	26,80	13.0	15.0	11	25,50

For Hard Wire we recommend downward Hole Size.



CONVERSION TABLE



SWG	INCHES	MM	SWG	INCHES	MM	SWG	INCHES	MM	SWG	INCHES	MM
1.00	0.30000	7.620	17.25	0.05400	1.371	28.25	0.01450	0.368	39.25	0.00510	0.129
2.00	0.27600	7.010	17.50	0.05200	1.320	28.50	0.01420	0.360	39.50	0.00500	0.126
3.00	0.25200	6.401	17.75	0.05000	1.269	28.75	0.01390	0.352	39.75	0.00490	0.124
4.00	0.23200	5.893	18.00	0.04800	1.219	29.00	0.01360	0.345	40.00	0.00480	0.122
5.00	0.21200	5.385	18.25	0.04600	1.167	29.25	0.01330	0.337	40.25	0.00470	0.119
6.00	0.19200	4.877	18.50	0.04400	1.117	29.50	0.01300	0.329	40.50	0.00460	0.117
7.00	0.17600	4.470	18.75	0.04200	1.066	29.75	0.01270	0.322	40.75	0.00450	0.114
8.00	0.16000	4.064	19.00	0.04000	1.016	30.00	0.01240	0.315	41.00	0.00440	0.112
8.25	0.15600	3.962	19.25	0.03900	0.991	30.25	0.01220	0.310	41.25	0.00430	0.109
8.50	0.15200	3.861	19.50	0.03800	0.965	30.50	0.01200	0.305	41.50	0.00420	0.107
8.75	0.14800	3.760	19.75	0.03700	0.939	30.75	0.01180	0.300	41.75	0.00410	0.104
9.00	0.14400	3.658	20.00	0.03600	0.914	31.00	0.01160	0.295	42.00	0.00400	0.102
9.25	0.14000	3.556	20.25	0.03500	0.889	31.25	0.01140	0.290	42.25	0.00390	0.099
9.50	0.13600	3.454	20.50	0.03400	0.864	31.50	0.01120	0.285	42.50	0.00380	0.097
9.75	0.13200	3.353	20.75	0.03300	0.838	31.75	0.01100	0.279	42.75	0.00370	0.094
10.00	0.12800	3.251	21.00	0.03200	0.813	32.00	0.01080	0.274	43.00	0.00360	0.091
10.25	0.12500	3.175	21.25	0.03100	0.788	32.25	0.01060	0.269	43.25	0.00350	0.089
10.50	0.12200	3.094	21.50	0.03000	0.762	32.50	0.01040	0.264	43.50	0.00340	0.086
10.75	0.11900	3.023	21.75	0.02900	0.737	32.75	0.01020	0.259	43.75	0.00330	0.084
11.00	0.11600	2.946	22.00	0.02800	0.711	33.00	0.01000	0.254	44.00	0.00320	0.081
11.25	0.11600	2.871	22.25	0.02700	0.686	33.25	0.00980	0.249	44.25	0.00310	0.079
11.50	0.11000	2.794	22.50	0.02600	0.660	33.50	0.00960	0.244	44.50	0.00300	0.076
11.75	0.10700	2.718	22.75	0.02500	0.635	33.75	0.00940	0.239	44.75	0.00290	0.074
12.00	0.10400	2.642	23.00	0.02400	0.610	34.00	0.00920	0.234	45.00	0.00280	0.071
12.25	0.10100	2.566	23.25	0.02350	0.597	34.25	0.00900	0.229	45.25	0.00270	0.069
12.50	0.09600	2.490	23.50	0.02300	0.584	34.50	0.00880	0.224	45.50	0.00260	0.065
12.75	0.09500	2.413	23.75	0.02250	0.571	34.75	0.00860	0.218	45.75	0.00250	0.063
13.00	0.09200	2.337	24.00	0.02200	0.559	35.00	0.00840	0.213	46.00	0.00240	0.061
13.25	0.08900	2.261	24.25	0.02150	0.546	35.25	0.00820	0.208	46.25	0.00230	0.059
13.50	0.08600	2.185	24.50	0.02100	0.533	35.50	0.00800	0.203	46.50	0.00220	0.056
13.75	0.08300	2.108	24.75	0.02050	0.520	35.75	0.00780	0.198	46.75	0.00210	0.054
14.00	0.08000	2.032	25.00	0.02000	0.508	36.00	0.00760	0.193	47.00	0.00200	0.051
14.25	0.07800	1.982	25.25	0.01950	0.493	36.25	0.00740	0.188	47.25	0.00190	0.049
14.50	0.07600	1.932	25.50	0.01900	0.482	36.50	0.00720	0.183	47.50	0.00180	0.046
14.75	0.07400	1.879	25.75	0.01850	0.469	36.75	0.00700	0.178	47.75	0.00170	0.044
15.00	0.07200	1.829	26.00	0.01800	0.457	37.00	0.00680	0.173	48.00	0.00160	0.041
15.25	0.07000	1.778	26.25	0.01760	0.447	37.25	0.00660	0.168	48.25	0.00150	0.038
15.50	0.06800	1.727	26.50	0.01720	0.437	37.50	0.00640	0.163	48.50	0.00140	0.035
15.75	0.06600	1.676	26.75	0.01680	0.427	37.75	0.00620	0.157	48.75	0.00130	0.032
16.00	0.06400	1.626	27.00	0.01640	0.417	38.00	0.00600	0.152	49.00	0.00120	0.030
16.25	0.06200	1.575	27.25	0.01600	0.407	38.25	0.00580	0.147	49.25	0.00115	0.028
16.50	0.06000	1.524	27.50	0.01560	0.397	38.50	0.00560	0.142	49.50	0.00110	0.027
16.75	0.05800	1.473	27.75	0.01520	0.386	38.75	0.00540	0.137	49.75	0.00105	0.026
17.00	0.05600	1.422	28.00	0.01480	0.376	39.00	0.00520	0.132	50.00	0.00100	0.025

DIAMOND DIE SPECIFICATION

SCND STANDARD CASING SIZES

Size Range	Casing Size (in) D * T	Size Range (mm)	Casing Size (mm D*T)
.0163 and smaller	1" or 1-1/8" * 5/16"	0.1 and Smaller	25 * 6 or 8
.0164 - .041	1" or 1-1/8" * 3/8"	0.101 - 0.40	25 or 28 * 8
.042 and larger	1" or 1-1/8" * 1/2"	0.401 - 1.0	25 or 28 * 10
		1.01 and larger	25 or 28 * 12

* Special casing size available upon request

PCD STANDARD CASING SIZES

Blank Size	Casing Size (in) D * T	Casing Size (mm D*T)
D-6 thru D-12	1" or 1-1/8" * 3/8"	25 or 28 * 10
D-15 thru D-24	1" or 1-1/8" * 1/2"	25 or 28 * 12
D-27 thru D-30	1" or 1-1/8" * 7/8"	38 * 22
D-33	2" * 1-1/8"	51 * 28
D-36	3" * 2"	76 * 51

* Special casing size available upon request

TYPICAL DIE SPECIFICATION FOR VARIOUS WIRE MATERIALS

Wire Material	Degree of Blending	Single Crystal Diamond		Polycrystalline Diamond	
		Reduction Angle	Bearing Length	Reduction Angle	Bearing Length
Bare Copper	Well Blended	18° ± 2°	40% ± 10%	18°±2°	25% ± 10%
Aluminium	Well Blended	20° ± 2°	25% ± 10%	20°±2°	25% ± 10%
Tin or Silver Plated Copper	Very Well Blended	20° ± 2°	20% ± 10%	20°±2°	20% ± 10%
Stainless Steel	Slightly Blended	14° ± 2°	50% ± 10%	15°±2°	35% ± 10%
Tungsten	Slightly Blended	14° ± 2°	50% ± 10%	14°±2°	30% ± 10%
Brass or Copper Covered Steel	Slightly Blended	12° ± 2°	35% ± 10%	12°±2°	30% ± 10%

TYPICAL DIE MATERIAL & DIAMETERS BY WIRE TYPE

Wire Type	Die Size Range											
Stainless Steel	—————											
Tungsten	-----											
Brass Covered Steel	-----											
Copper Coated Steel	-----											
Bare Copper	-----											
Tinned Copper	-----											
Aluminium	-----											
INCHES	.0005	.001	.002	.004	.008	.016	.032	.064	.128	.256	.512	
MILLIMETER	0.0125	0.025	0.05	0.10	0.20	0.40	0.80	1.60	3.20	6.40	12.80	

TOTAL BORE DIAMETER TOLERANCE



NEW AND RECUT WIRE DRAWING DIES

Size Range (Inches)	Standard Hole Size Tolerance STD102	Standard Ovality Tolerance STD102	Min. "Tightest" Hole Size Tolerance STD301
.0006 or less	.000024	.000020	.000010
.00061 - .0008	.000024	.000020	.000012
.00081 - .0010	.000028	.000020	.000014
.00101 - .0020	.000036	.000020	.000016
.00201 - .0030	.000040	.000020	.000020
.00301 - .0040	.000050	.000030	.000030
.00401 - .0050	.000060	.000040	.000040
.00501 - .0080	.000060	.000040	.000040
.00801 - .0100	.000080	.000040	.000040
.01001 - .0160	.000080	.000040	.000050
.01601 - .0200	.000120	.000080	.000060
.02001 - .0300	.000120	.000080	.000080
.03001 - .0400	.000160	.000100	.000080
.04001 - .0600	.000260	.000100	.000100
.06001 - .0900	.000200	.000120	.000120
.09001 - .0930	.000240	.000200	.000200
.09301 - .1200	.000500	.000500	.000500
.12001 - .2400	.000500	.000500	.000500
.2401 - .3600	.000500	.000500	.000500
.3601 - .5000	.000500	.000500	.000500

NEW AND RECUT WIRE DRAWING DIES

Size Range (Millimeters)	Standard Hole Size Tolerance STD102	Standard Ovality Tolerance STD102	Min. "Tightest" Hole Size Tolerance STD301
0.015 or less	0.0006	0.0005	0.00025
0.0151 - 0.020	0.0006	0.0005	0.00030
0.0201 - 0.025	0.0007	0.0005	0.00035
0.0251 - 0.050	0.0009	0.0005	0.0004
0.0501 - 0.075	0.0010	0.0005	0.0005
0.0751 - 0.100	0.0012	0.0008	0.0008
0.101 - 0.125	0.0015	0.0010	0.0010
0.126 - 0.200	0.0015	0.0010	0.0010
0.201 - 0.250	0.0020	0.0010	0.0010
0.251 - 0.400	0.0020	0.0010	0.0012
0.401 - 0.500	0.0030	0.0020	0.0015
0.501 - 0.750	0.0030	0.0020	0.0020
0.751 - 1.000	0.0040	0.0025	0.0020
1.001 - 1.500	0.0040	0.0025	0.0025
1.501 - 2.250	0.0050	0.0030	0.0030
2.251 - 2.360	0.0050	0.0030	0.0030
2.361 - 3.000	0.0127	0.0127	0.0127
3.0001 - 6.000	0.0127	0.0127	0.0127
6.001 - 9.000	0.0127	0.0127	0.0127
9.001 - 12.000	0.0127	0.0127	0.0127

MANUFACTURING UNIT



Products & Services

Natural Diamond Die, Polycrystalline Diamond Die,
Monocrystalline Diamond Die, Tungsten Carbide Die,
Enamelling Die, Bunching Die, Shaving Die



Shree Mahalaxmi Die Industries, Road No. 1, Plot No. 7B/III, Near Monginis Bakery,
Udhna Udhyognagar, Surat-394210. Gujarat, India.

Ph.: 91 261 2270198, Mo.: 91 99131 60065, 93747 20380 / E-mail : mahalaxmidie@yahoo.co.in



Sterling Wire Die Technologies, 224, King Lear Lane, Morrisville, NC 27560
E-mail : sales@sterlingwire.com