

## Standard Die specifications for Hard wire & Soft Wire

The below are the generally used specification for different type of wires. However, depending on the material drawn, alloy content, drawing speed, some of the customers may specify their own specification and we have to strictly follow that.

Material	Soft Wire	Hard Wire
Entrance	$60^{\circ} \pm 10^{\circ}$	$60^{\circ} \pm 10^{\circ}$
Reduction angle	$16^{\circ} \pm 2^{\circ}$	$14^{\circ} \pm 2^{\circ}$
Reduction angle height	Approximately 3 times the bearing length depending on diamond height	
Bearing Length	25-40 %	40 - 60 %
Back relief angle	$16^{\circ} \pm 2^{\circ}$	$14^{\circ} \pm 2^{\circ}$
Back relief height	20 - 60% of bearing length depending on the material drawn and blank height	
Exit angle	$50^{\circ} \pm 10^{\circ}$	$50^{\circ} \pm 10^{\circ}$

**The Soft Wires includes :**

Copper wire, silver, nickel, Aluminum, Brass, Gold wire, etc.

**The Hard Wires includes:**

Stainless steel wire, low & High carbon, Copper plated steel wire, Galvanized steel wire, Brass plated steel wire, Nichrome wire, tungsten & moly wire and many alloy materials etc.