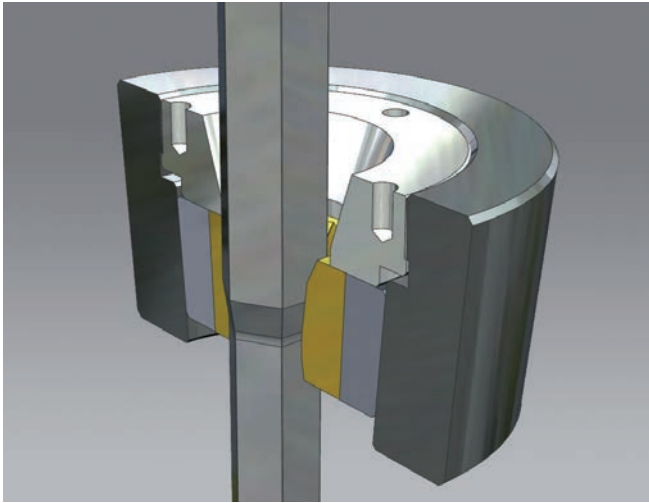


Patent Application
Pending



INNOVATION

MASTERDIE DRAWING DIE



MasterDie Drawing Die

The quality of CERATIZIT Tungsten Carbide in a new Flexible design

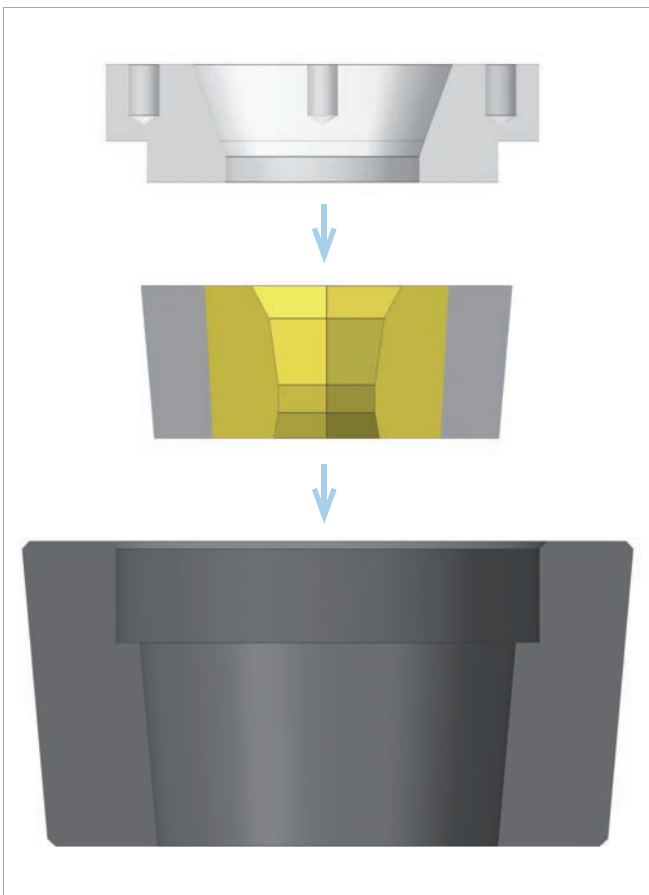
- Speed up your drawing process
- Slow down tools wear
- Optimize your tool stock

Make your Drawing Process more rentable:

Description of MasterDie Drawing Die: an exchangeable Wear Part made of a CVD coated* Tungsten Carbide insert shrunk into a high resistant Steel Sleeve. The Steel Casing and the Threaded Ring are re-usable elements. The Wear Part fits into the Steel Casing and is clamped by the Threaded Ring. The Wear Part can be easily removed and replaced with a new one by the customer.

Every Steel Casing & Threaded Ring can be used with every Wear Part having the same FORM (see next page).

*: A special CVD Coating branded MasterDie-CVD has been developed by CERATIZIT with the aim of improving the tool life during steel drawing (automatic steel, carbon steel, stainless steel, ...).



Re-usable Threaded Ring

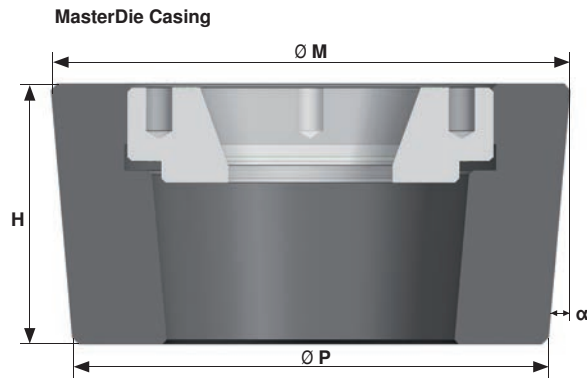
Wear Part:
MasterDie CVD Coated Tungsten Carbide shrunk into a high resistant Steel Sleeve




Re-usable Steel Casing

MasterDie Drawing Die – Form and dimension

Each MasterDie Wear Part having the same FORM can be fitted into the same MasterDie Casing.

MasterDie Wear Part

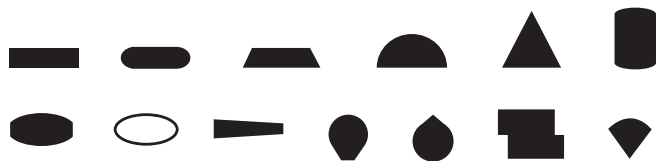


Form				Minimum dimensions required	
	Round Ø (mm)	Hexagonal SW (mm)	Square SW (mm)	ØM (mm)	H (mm)
MasterDie-1	2 ÷ 8	2 ÷ 8	2 ÷ 6	60	45
MasterDie-2	8,01 ÷ 13	8,01 ÷ 12	6,01 ÷ 10	72	45
MasterDie-3	13,01 ÷ 19	12,01 ÷ 17	10,01 ÷ 14	87	50
MasterDie-4	19,01 ÷ 25	17,01 ÷ 23	14,01 ÷ 18	103	55
MasterDie-5	25,01 ÷ 32	23,01 ÷ 29	18,01 ÷ 23	118	60
MasterDie-6	32,01 ÷ 40	29,01 ÷ 35	23,01 ÷ 29	133	65
MasterDie-7	40,01 ÷ 48	35,01 ÷ 41	29,01 ÷ 35	150	65
MasterDie-8	48,01 ÷ 56	41,01 ÷ 48	35,01 ÷ 41	165	70
MasterDie-9	56,01 ÷ 64	48,01 ÷ 56	41,01 ÷ 46	182	70
MasterDie-10	64,01 ÷ 72	56,01 ÷ 62	46,01 ÷ 50	200	75
MasterDie-11	72,01 ÷ 80	62,01 ÷ 69	50,01 ÷ 56	218	75
MasterDie-12	80,01 ÷ 88	69,01 ÷ 76	56,01 ÷ 62	238	80

Other Shapes can also be produced.

Please submit your request to CERATIZIT Engineering and you receive a feasibility study.

MasterDie Casing are customized on customer request. Customer has to supply the dimensions of the steel casing (see above picture) taking in consideration that for each MasterDie FORM there are “Minimum dimensions” (see Table) to be respected.



Assembly instruction

1. Place the MasterDie Wear Part into the MasterDie steel casing.
2. Close the MasterDie threaded ring by means of a spanner.





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