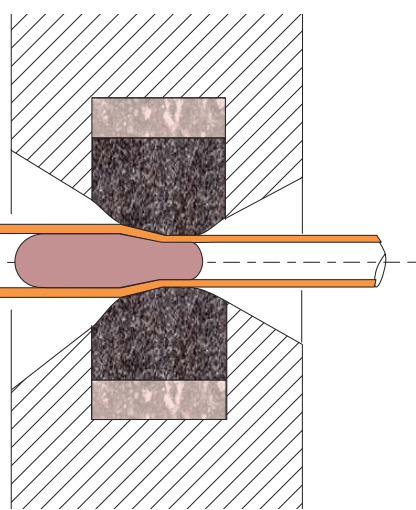


Tubing dies (with or without core plug / mandrel)



Die size (mm)	PCD blanks : Diamond size (Ø x t)											
	5.2 x 2.5 5.2 x 3.5	7 x 4	7 x 5.3	9 x 7	13 x 7 13 x 9 13 x 12	15 x 12 15 x 15	16 x 16	18.5 x 13.5 18.5 x 15.5 15.8 x 17.5 18.5 x 18.5	25 x 18 25 x 20	30 x 20 30 x 22	40 x 25	45 x 27
2.0 - 3.0	*				*	*		*	*	*		
3.0 - 3.5												
3.5 - 4.5												
4.5 - 5.5												
5.5 - 7.0												
7.0 - 8.0												
8.0 - 10												
10 - 15												
15 - 20												
20 - 27												
27 - 32												

Ø = blank diameter
h = blank thickness

Please, enquire for larger Ø

Chart based on the following specifications :
Reduction Angle: 20° to 30°
Bearing Length 0.25 x Ø

Blank choice is dependent on the process parameters.

* Depend on tubing criteria (Inlet material, shape, etc ...)