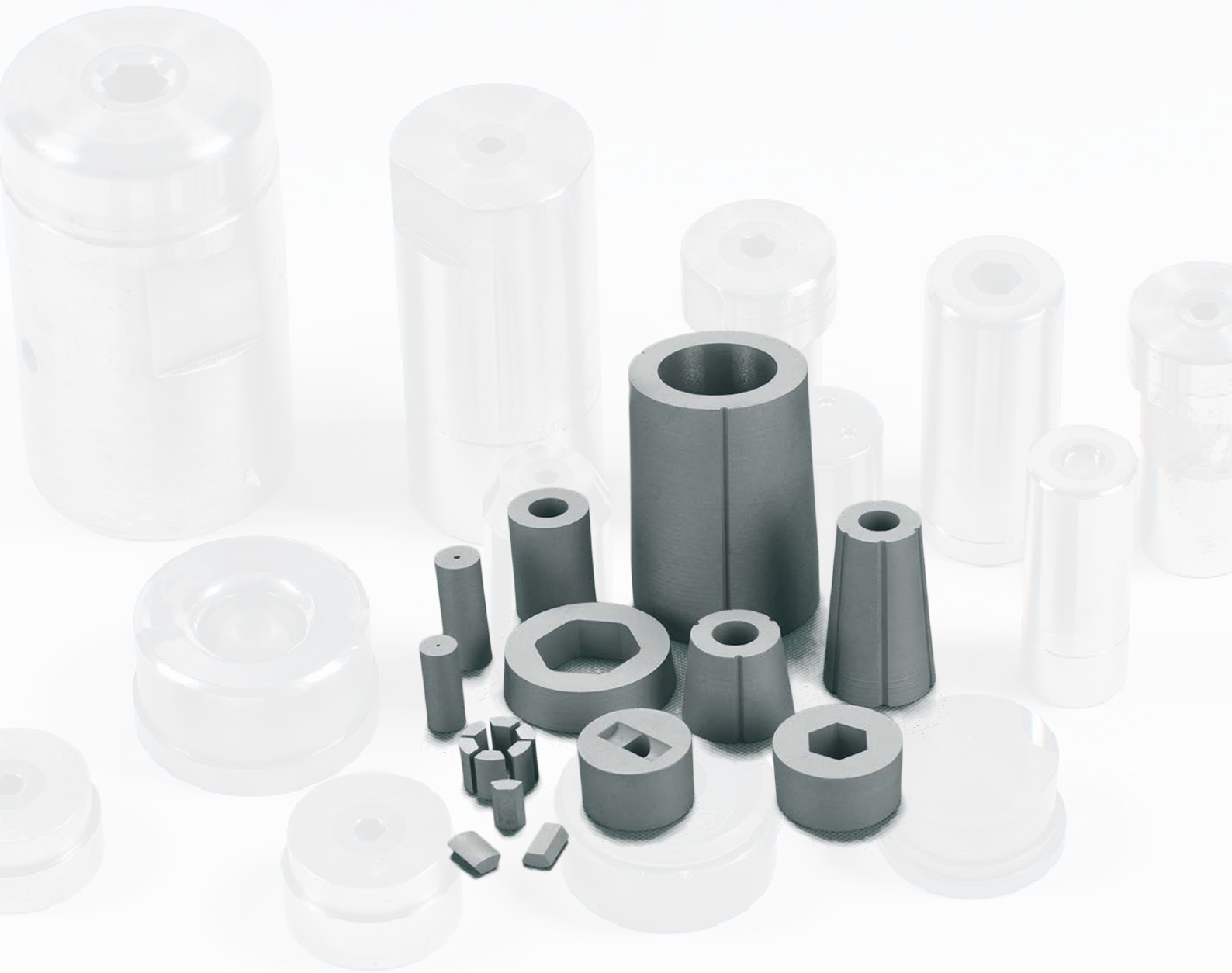


Tungsten Carbide Cold Heading Dies



Cemented carbide cold heading dies, dies blanks

Cold Forming Processes Fastner die blanks

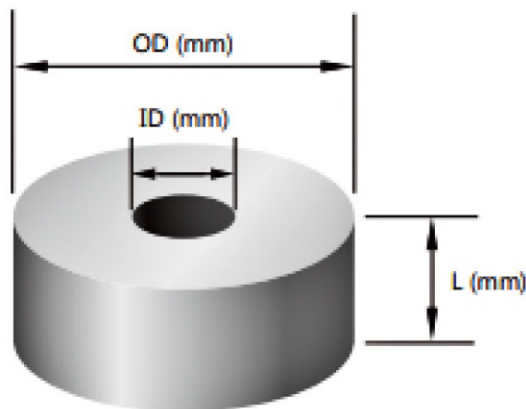
Fastner die blanks

Yatech provide long wearing, dependable cemented carbide cold heading die blanks and cold heading dies that meet industry and customer requirements, are used in the cold heading process in fastener manufacturing industries. We partner with our customers to improve performance and develop solutions for their cold heading dies applications.

Advantage

- Dependable cemented carbide for heading and nut forming.
- Long wearing cemented carbide grades that meet industry requirements for extrusion applications
- Higher yields resulting from quality cemented carbides
- Higher output with tailor-made tolerance options.

SIZES



Outside Diameter
(ΦD): 10 to 50mm
Length
(L): 10 to 140mm
Inside Diameter
(Φd): 2 to 24mm

TOLERANCE OUTER DIAMETER

• D(mm)	Length (mm)					
	<19	20 - 35	35 - 50	55 - 80	90 - 120	>140
10 - 14	+0.4/+1.0	+0.4/+1.1	+0.4/+1.1	+0.4/+1.2	-	-
15 - 18	-	+0.4/+1.1	+0.4/+1.2	+0.4/+1.3	-	-
19 - 24	-	+0.4/+1.3	+0.4/+1.3	+0.4/+1.4	+0.5/+1.6	-
25 - 28	-	+0.4/+1.4	+0.4/+1.5	+0.4/+1.5	+0.5/+1.7	-
29 - 40	-	+0.4/+1.5	+0.4/+1.6	+0.4/+1.6	+0.5/+1.8	+0.5/+1.9
41 - 50	-	-	+0.5/+2.0	+0.5/+2.0	+0.5/+2.1	+0.6/+2.2

*E.G: Finished Goods OD x L50 x ID2.0 mm OD(Min.)= 20.4 ~ OD(Max.)= 21.3 mm

TOLERANCE INNER DIAMETER

• d(mm)	Length(mm)					
	<19	20 - 30	31 - 50	51 - 80	81 - 120	>140
0 - 6	-0.3/-0.7	-0.3/-0.8	-0.3/-0.8	-0.4/-1.0	-	-
6 - 10	-	-0.3/-0.9	-0.3/-1.0	-0.4/-1.1	-0.4/-1.2	-
10 - 14	-	-0.4/-1.1	-0.4/-1.1	-0.4/-1.2	-0.4/-1.3	-
14 - 18	-	-0.4/-1.1	-0.4/-1.2	-0.4/-1.3	-0.4/-1.4	-0.5/-1.9
18 - 24	-	-	-0.4/-1.3	-0.4/-1.4	-0.4/-1.6	-0.6/-2.2

*E.G: Finished Goods OD 20 x L50xID3.5 mm OD(Min.) = 2.7 ~ ID(Max.)= 3.2 mm

TOLERANCE LENGTH

Length(mm)	• D(mm)			
	10 - 18	20 - 28	32 - 50	50 - 70
<15	+0.4/+1.1	-	-	
16-25	+0.4/+1.2	-	-	
26-30	+0.4/+1.3	+0.4/+1.4	+0.4/+1.5	
31-40	+0.4/+1.4	+0.4/+1.5	+0.4/+1.6	
41-50	+0.4/+1.5	+0.5/+1.9	+0.5/+2.0	
51-60	+0.5/+1.8	+0.5/+2.3	+0.5/+2.3	
61-80	+0.5/+2.2	+0.5/+2.7	+0.5/+2.7	
81-100	+0.5/+2.6	+0.5/+3.1	+0.5/+3.1	
101-120	-	+0.6/+3.7	+0.6/+3.7	
>140	-	-	+0.6/+4.2	

*E.G: Finished Goods OD 20 x L50 x ID3.5 mm L(Min.)= 50.5 ~ L(Max.)= 51.9 mm

Additional sizes, tolerances, cemented carbide grades, and quantities (Tests) are available upon request.

Grade

WC Grain Size	Grade	Co %	Density g/cm ³	Hardness HRA	T.R.S GPa	Applications
Medium	CG5	12.0	14.30	88.3	3300	High toughness cold heading dies
	CG6	14.0	14.12	87.3	3140	
Coarse	CA18	18.0	13.75	85.1	2940	Screw mold with aperture below $\Phi 20$
	CA24	24.0	13.25	82.5	2650	Screw mold $\Phi 20 - \Phi 50$
	CT15	15.0	13.80	86.0	2700	Stainless steel screw die with aperture below $< \Phi 2$
	CT20	20.0	13.60	84.5	2660	Stainless steel screw die with aperture above $> \Phi 2$
	CA20	20.0	13.55	84.1	2740	Warm/hot forging dies
	CA22	22.0	13.40	82.5	2350	
	CA25	25.0	13.13	81.6	2160	





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