



	α	B (% of ϕ)
Copper	16° - 18°	25-30%
Tinned copper	18° - 20°	20-25%
Copper alloys	14° - 16°	30-40%
Aluminium	18° - 20°	15-20%
Aluminium alloys	14° - 16°	20-30%
Silver	18° - 20°	20-25%
Gold	18° - 20°	20-25%
Tungsten	12° - 14°	30-40%
Molybdenum	12° - 14°	30-40%
Stainless steel	14° - 16°	30-35%
High-carbon steel	10° - 12°	40%
Medium-carbon steel	12° - 14°	35%
Low-carbon steel	14° - 16°	30%

Reduction angle and bearing length in this table are the most widely used parameters and are given for information only. Please note the exact die geometry depends on the inlet wire diameter as well as on the specific drawing process involved.