



Precision Straightener Selection Chart

Size	Series	2 Plane Part No.	4 Plane Part No.
.006" to .012" 0.15mm to 0.30mm	#00	1000-002	1000-004
.010" to .025" 0.15mm to 0.62mm	#0	1000-012	1000-014
.015" to .035" 0.37mm to 0.90mm	#01	1001-002	1001-004
.030" to .065" 0.76mm to 1/65mm	#02	1002-002	1002-004
.060" to .110" 1.5mm to 2.80mm	#03	1003-002	1003-004
.100" to .187" 2.54mm to 4.75mm	#04	2 Versions Call TAK	2 Versions Call TAK
.150" to .250" 3.81mm to 6.35mm	#05	2 Versions Call TAK	2 Versions Call TAK



General Rules of Thumb:

- If the size of the material is close to the high range of a straightener and the material is hard it is better to use the next larger straightener.
- If the material surface condition is important consider using radius or polished bearings.
- If the environment is extremely dirty consider using sealed bearings.
- If the ratio of height to width of strip is greater than 3 to 1, camber cannot be corrected well or sometimes not at all.
- A 2 plane configuration is typically employed for removing cast. If the wire has a tensile value over 200ksi or has a helix in it, a 4 plane configuration will be required.
- Other factors such as back tension, lubrication, and wire entrance & exit angles can all effect straightener performance.
- Other shapes such as Half round, flat, Octagon, Hex, Diamond, etc. can be straightened using special shaped bearings with either a 2, 3, or 4 plane straightener.