



HIGH PRECISION TRUMPF STYLE TOOLING

Trumpf Style
Tooling Innovations



Strength. Performance. Innovation.

REDUCE TOOLING COSTS WITH WILSON 2-4-1®

Innovative design and high quality manufacturing converge in the Wilson 2-4-1 tooling system to deliver twice the grind life. The Wilson 2-4-1 tooling system includes dies that incorporate a die holder, die insert and shim pack and punches engineered with a unique high precision spacer design that together increase grind life to an unprecedented .236 inches (6mm).

Greater Versatility.

Wilson 2-4-1 dies require no die adapters. Die inserts only need to be replaced when changing shape, dimension or clearance, reducing your costs and increasing versatility.

More Hits Between Sharpenings.

Wilson 2-4-1 punches and dies are engineered with high-speed steel to allow more hits between tool sharpenings and reduce downtime. Wilson's exclusive Optima® coating is also available on all punches for maximum wear resistance.

No Setting Errors.

With the Wilson 2-4-1 system, keyed punches allow you to load directly into the punch press to eliminate setting errors.

Fast Deliveries.

Wilson Tool guarantees fast deliveries on 2-4-1 tooling for Trumpf®, Pullmax, Boschert, Euromac and Haco Omes punch presses, saving you time and increasing your productivity.



WILSON 2-4-1 ■
Twice the life, twice the value. ■



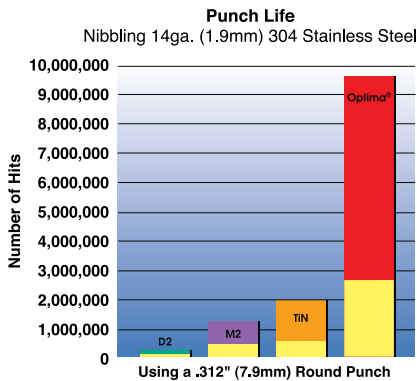
Improve Wear Resistance with Optima®.

Every Wilson Trumpf Style Punch is available with Wilson's exclusive Optima® coating. Developed by Wilson engineers, Optima provides a surface hardness, wear resistance and lubricity unmatched by any other coated or uncoated turret punch press tooling. The result is a longer tool life, more hits between sharpenings, reduced galling, better performance and less downtime.

Optima® coating provides:

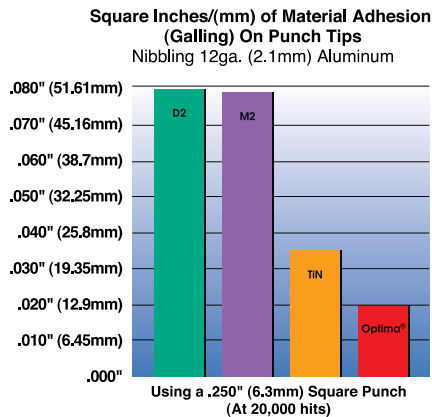
- Longer tool life
- Increased wear resistance
- More hits between sharpenings
- Reduced adhesion (galling)
- Reduced slug pulling
- Reduced corner breakdown
- Improved special tooling performance
- Lower overall tooling costs

Punch Life

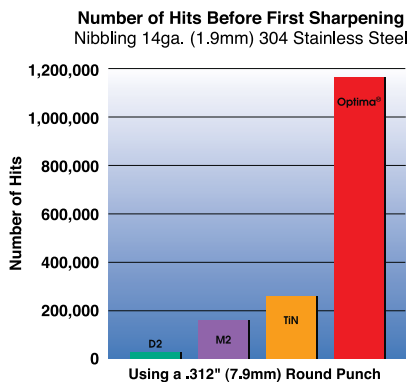


The yellow area indicates actual results achieved through three tool sharpenings of .010" (0.25mm) each. The complete graph indicates projected results with a total of .236" (6mm) removed for sharpening.

Material Adhesion



Number of Hits



Tip Wear

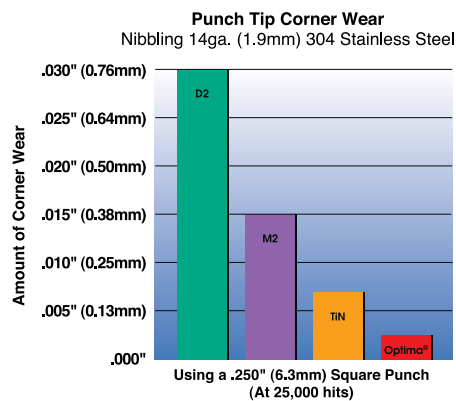


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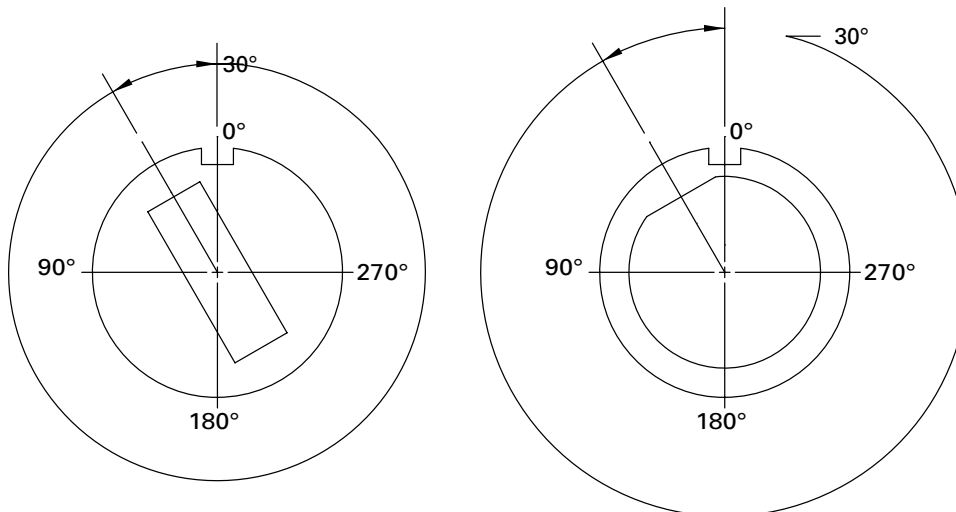


MACHINE GROUPS

A	B	C	D	E	
CN 700	CN 901E	CN 1200S	TRUMATIC	SUNIMAT 400	
CN 900	CN 902	CN 1200A	20	TRUMATIC	TRUMATIC
CN 701	CS 75	CS 15	20A	150K	202K
CN 901	CS 75.2	CS 20	202M	151K	225K
		CS 20A		152K	235K
		MP 25		180K	300K
		MP 25D		180.2K	300LK
				180KD	300PK
				180LK	400K
				180.2LK	

F	G	H	I	S
TRUMATIC	TRUMATIC	TRUMATIC	TRUMATIC	MINIMATIC
150W	20AW	500R	2000R	100
152W	202W	200R	2010R	TRUMATIC
180W	300W	190R	2020R	120R
180.2W	300LW	600L	3000-1300R	160R
180R	300PW		3000-1600R	
180LW	300TOP		5000R	
180.2LW	400W		6000R	
ELX/SWIFT			1000R	
185				
240				
240R				
250				
260R				

KEYING FOR NON-ROTATIONAL MACHINES



PUNCH & DIE HOLDERS

WILSON 2•4•1 ■TM
Twice the life, twice the value. ■

Cheese Head Screw

M3 x 12mm (for 0-40)
 Cat. No. 25215

M3 x 7mm (for 40.01-76.2)
 Cat. No. 24150

Punch Collar Key

Cat. No. 25113

Retaining Ring

15.1mm x 1.0mm
 Cat. No. 24424

Socket Head Cap Screw

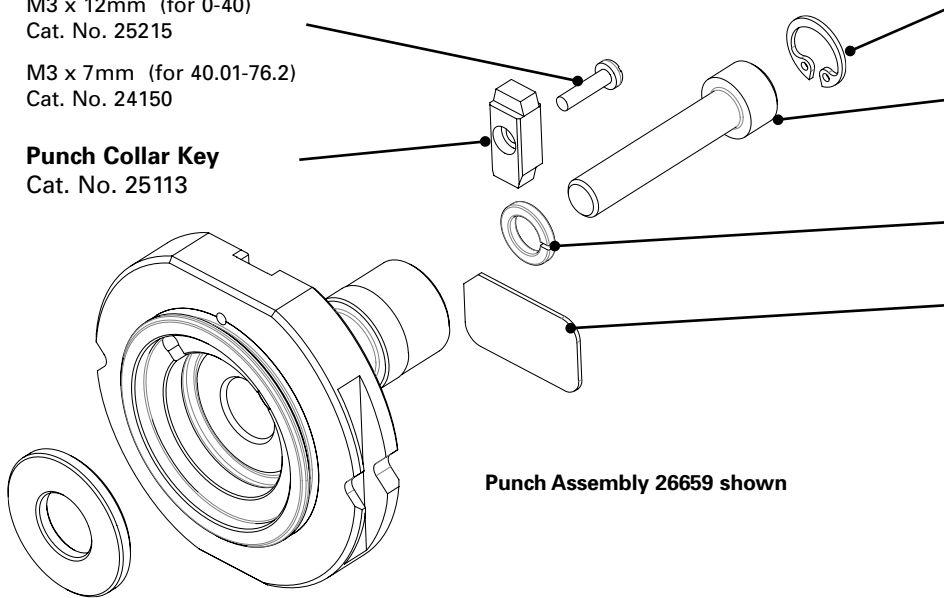
M8 x 40mm
 Cat. No. 30161

Lockwasher M8

Cat. No. 974100

Magnetic I.D. Label

Cat. No. 26657



Punch Assembly 26659 shown

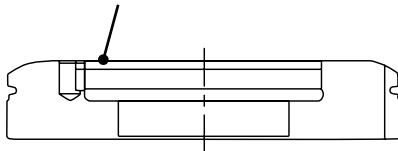
2•4•1 PUNCH HOLDERS

Description	Cat. No.	Price
Punch Holder Assembly* 0 – 1.575" (0 – 40mm)	26659	
Precision Ground Spacer 0 – 1.575" (0 – 40mm)	25806	
Punch Holder Assembly* 1.576 – 3.000" (40.01 – 76.20mm)	26660	
Precision Ground Spacer 1.576 – 3.000" (40.01 – 76.20mm)	25807	

* Each Punch Holder Assembly is shipped with a Precision Ground Spacer.



Socket Set Screw (2 Req.)
 (M6 x 10mm)
 Cat. No. 6269



241 URETHANE STRIPPERS

Description	Cat. No.	Price RD	Price SHP
Push on for flat (0-30mm 'A' Dim)	26661		
Push on for whisper/long (0-30mm 'A' Dim)	26649		
Push on for flat (30.01-40mm 'A' Dim)	26662		
Push on for whisper/long (30.01-40mm 'A' Dim)	26652		

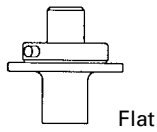
2•4•1 DIE HOLDERS

Description	Cat. No.	Price
Die Holder Assembly** 0 – 1.575" (0 – 40.00mm)	25986	
Die Holder Assembly** 1.576 – 2.205" (40.01 – 56.00mm)	25987	
Die Holder Shim Pack 0 – 1.575" (0 – 40.00mm)	25983	
Die Holder Shim Pack 1.576 – 2.205" (40.01 – 56.00mm)	25984	

** Each Die Holder Assembly is shipped with a Shim Pack.

ROUND

WILSON 2·4·1™
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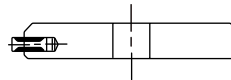
ROUND PUNCH

Diameter	Flat		Whisper Shear		Long**		Optima™ Add-on
	Cat. No.	Price	Cat. No.	Price	Cat. No.	Price	
.093 – 1.181" (2.36 – 30.00mm)	25768		25769		25770		
1.182 – 1.575" (30.01 – 40.00mm)	25774		25775		25776		
1.576 – 2.205" (40.01 – 56.00mm)	25780		25781		25782		
2.206 – 2.598" (56.01 – 66.00mm)	25786		25787		25788		
2.599 – 3.000" (66.01 – 76.20mm)	25792		25793		25794		

**For Group I machines. Not available with shear.

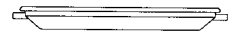
ROUND DIE INSERTS

Diameter	Cat. No.	Price
0 – 1.575" (0 – 40.00mm)	25980	
1.576 – 2.205" (40.01 – 56.00mm)	25982	



ROUND STRIPPER

Description	Cat. No.	Price
Group H/I	25358	
Keyed	25006	



Stripper Pin
 Cat. No. 25179

Add Ons

Special Shears	Add ons for Rounds		Add ons for Shapes	
Inverted Rooftop/Single Concave	Small Diameter	Punch	Die	Small Width
Size I \$24.25	.031 – .061" (0.79 – 1.56mm)			Size I .031 – .039" (0.79 – 1.00mm)
Size II 27.25	.062 – .092" (1.57 – 2.34mm)			.040 – .092" (1.01 – 2.34mm)
Double Valley/Double Concave	Clearance < .004 (0.10mm)			Size II .031 – .039" (0.79 – 1.00mm)
Size I \$33.75	Size I			.040 – .092" (1.01 – 2.34mm)
Size II 33.75	Size II			Clearance < .004 (0.10mm)
				Size I
				Size II



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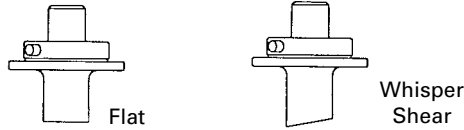
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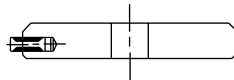
SHAPE

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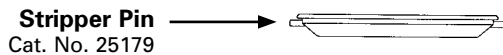


SHAPE PUNCH							
Dimension	Flat		Whisper Shear		Long**		Optima™ Add-on
	Cat. No.	Price	Cat. No.	Price	Cat. No.	Price	
.093 – 1.181" (2.36 – 30.00mm)	25771		25772		25773		
1.182 – 1.575" (30.01 – 40.00mm)	25777		25778		25779		
1.576 – 2.205" (40.01 – 56.00mm)	25783		25784		25785		
2.206 – 2.598" (56.01 – 66.00mm)	25789		25790		25791		
2.599 – 3.000" (66.01 – 76.20mm)	25795		25796		25797		











**For Group I machines. Not available with shear.



SHAPE DIE INSERTS		
Dimension	Cat. No.	Price
0 – 1.575" (0 – 40.00mm)	25979	
1.576 – 2.205" (40.01 – 56.00mm)	25981	



SHAPE STRIPPER		
Description	Cat. No.	Price
Group H/I	25359	
Keyed	25028	

Radius or 45° Chamfer 4 Corners	Standard Shapes
Punches Radius or Chamfer Size .001 - .062 (0.02 - 1.57mm) .063 - .250 (1.58 - 6.35mm) Greater than .250 (6.35mm)	    
Dies Radius or Chamfer Size Any size	    
	Note: For non-rotational keying, see page 3.

MULTI-TOOL 4-STATION

FOR TRUMATIC 240R/260R AND GROUP H MACHINES

Note: Max Material

- .125 (3.2mm) Mild steel & Aluminum
- .079 (2mm) Stainless steel

COMPLETE PUNCH AND DIE ASSEMBLY WITH ALIGNMENT TOOL*		
Description	Cat. No.	Price
Trumatic 240R/260R	25888	
Group H	25886	



PUNCH ASSEMBLY*		
Description	Cat. No.	Price
Trumatic 240R/260R	25891	
Group H	25884	
MT4 Alignment Tool	25893	

DIE ASSEMBLY*		
Description	Cat. No.	Price
Trumatic 240R/260R & Group H	25866	

*Note: Price does not include inserts.

MULTI-TOOL 4-STATION PUNCH			
Description	Cat. No.	Price	Optima™ Add-on
Round Punch	25151		
Shape Punch	25152		



MULTI-TOOL 4-STATION DIE		
Description	Cat. No.	Price
Round Die	25153	
Shape Die	25154	
MT4 Die Shim Pack	25389	



Maximum Punch size:
.630"
(16mm)

Note: All punches and dies will be made for Position 1 Angle 90° unless stated otherwise. Round punches Optima™ coated as standard.

Add Ons					
Add ons for Rounds			Add ons for Shapes		
Small Diameter .031 – .061" (0.79 – 1.56mm) .062 – .092" (1.57 – 2.34mm) Clearance < .004 (0.10mm)	Die	Small Width Size I .031 – .039" (0.79 – 1.00mm) .040 – .092" (1.01 – 2.34mm) Size II .031 – .039" (0.79 – 1.00mm) .040 – .092" (1.01 – 2.34mm) Clearance < .004 (0.10mm)			Punch
		Die		Die	

Note: Add \$ ____ to round or shape punch for extra straight before radius, extra back taper, or no back taper.



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salesdesk@wilsontool.com

FOR TRUMATIC 240R/260R AND GROUP H MACHINES

Note: Max Material

- .125 (3.2mm) Mild steel & Aluminum
- .079 (2mm) Stainless steel

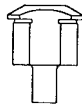


COMPLETE PUNCH AND DIE ASSEMBLY WITH ALIGNMENT TOOL*		
Description	Cat. No.	Price
Trumatic 240R/260R	25889	
Group H	25887	

PUNCH ASSEMBLY*		
Description	Cat. No.	Price
Trumatic 240R/260R	25892	
Group H	25885	
MT6 Alignment Tool	25894	

DIE ASSEMBLY*		
Description	Cat. No.	Price
Trumatic 240R/260R & Group H	25863	

*Note: Price does not include inserts.



Maximum
Punch size:
.413"
(10.50mm)

MULTI-TOOL 6-STATION PUNCH			
Description	Cat. No.	Price	Optima™ Add-on
Round Punch	25147		
Shape Punch	25148		

MULTI-TOOL 6-STATION DIE		
Description	Cat. No.	Price
Round Die	25149	
Shape Die	25150	
MT6 Die Shim Pack	25388	

Note: All punches and dies will be made for Position 1 Angle 90° unless stated otherwise. Round punches Optima™ coated as standard

Radius or 45° Chamfer 4 Corners		Standard Shapes									
Punches		SD Single-D	LD Long-D	ET Equilateral Triangle	SQ Square	HX Hexagon					
Radius or Chamfer Size	Total Add On										
.001 - .062 (0.02 - 1.57mm)		DD Double-D	QD Quad-D	OB Obround	RT Rectangle	OT Octagon					
.063 - .250 (1.58 - 6.35mm)											
Greater than .250 (6.35mm)											
Dies											
Radius or Chamfer Size	Total Add On										
Any size											

Note: For non-rotational keying, see page 3.

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MULTI-TOOL 5-STATION

Note: Max Material

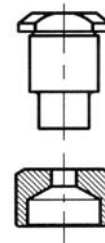
- .177 (4.5mm) Mild steel & Aluminum
- .118 (3mm) Stainless steel

5-STATION ASSEMBLY UNITS		
Description	Cat. No.	Price
Upper Unit Assembly	25957	
Lower Unit Assembly	25958	
Stripper With 17.2mm Diameter Holes	25959	
Fitted Stripper (For thin mat'l only 18 ga. or less)	25960	



MULTI-TOOL 5-STATION PUNCH			
Description	Cat. No.	Price	Optima™ Add-on
Round Punch	25735		
Shape Punch	25736		

MULTI-TOOL 5-STATION DIE		
Description	Cat. No.	Price
Round Die	25737	
Shape Die	25738	
MT5 Die Shim Pack	26003	



Maximum
Punch size:
.630" (16mm)

Note: All punches and dies will be made for Position 1 Angle 90° unless stated otherwise.
Round punches Optima™ coated as standard.

Add Ons						
Add ons for Rounds			Add ons for Shapes			
Small Diameter .031 – .061" (0.79 – 1.56mm) .062 – .092" (1.57 – 2.34mm) Clearance < .004 (0.10mm)	Punch	Die	Small Width Size I .031 – .039" (0.79 – 1.00mm) .040 – .092" (1.01 – 2.34mm) Size II .031 – .039" (0.79 – 1.00mm) .040 – .092" (1.01 – 2.34mm) Clearance < .004 (0.10mm)		Punch	Die
Note: Add \$ ____ to round or shape punch for extra straight before radius, extra back taper, or no back taper.						

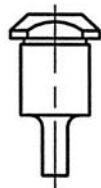


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Maximum
Punch size:
.413"
(10.5mm)

Note: Max Material

- .177 (4.5mm) Mild steel & Aluminum
- .118 (3mm) Stainless steel

10-STATION ASSEMBLY UNITS		
Description	Cat. No.	Price
Upper Unit Assembly	25967	
Die Holder Assembly Individual Die Design	25985	
Stripper With 11.7mm Diameter Holes	25969	
Fitted Stripper (For thin mat'l only 18 ga. or less)	25970	

MULTI-TOOL 10-STATION PUNCH			
Description	Cat. No.	Price	Optima™ Add-on
Round Punch	25809		
Shape Punch	25810		

MULTI-TOOL 10-STATION DIE		
Description	Cat. No.	Price
Round Die	25996	
Shape Die	25997	
MT10 Die Shim Pack	25995	

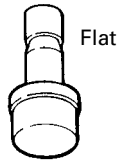
Note: All punches and dies will be made for Position 1 Angle 90° unless stated otherwise.
Round punches Optima™ coated as standard.

TRUMPF ORIGINAL DIE DESIGN		
Description	Cat. No.	Price
Lower Unit Assembly (no die plate)	25968	
Die Plate	25808	

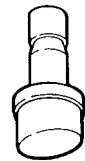
Radius or 45° Chamfer 4 Corners		Standard Shapes									
Punches											
Radius or Chamfer Size	Total Add On										
.001 - .062 (0.02 - 1.57mm)											
.063 - .250 (1.58 - 6.35mm)											
Greater than .250 (6.35mm)											
Dies											
Radius or Chamfer Size	Total Add On										
Any size											
		SD Single-D	LD Long-D	ET Equilateral Triangle	SQ Square	HX Hexagon					
		DD Double-D	QD Quad-D	OB Obround	RT Rectangle	OT Octagon					

STANDARD TOOLS

ROUND SIZE 0, I, II



Flat



Whisper Shear

ROUND PUNCH

Size	Diameter	Flat		Whisper Shear		Long**		Optima™ Add-on
		Cat. No.	Price	Cat. No.	Price	Cat. No.	Price	
0'	.031 – .236" (0.8 – 6.00mm)	25008		–		25740		
0'	.237 – .413" (6.01 – 10.50mm)	25009		–		25744		
I	.031 – 1.181" (0.80 – 30.00mm)	25004		25069		25748		
II	1.182 – 1.496** (30.01 – 38.00mm*)	25035		25071		–		
II	1.182 – 1.575" (30.01 – 40.00mm)	25042		25071		25752		
II	1.576 – 2.000" (40.01 – 50.80mm)	25043		25072		25756		
II	2.001 – 3.000" (50.81 – 76.20)	25002		25073		25760		

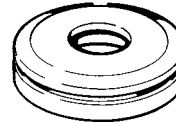
†Not recommended for punching stainless steel.

*For Group S machines.

**For Group I machines. Not available with shear.

ROUND DIE

Size	Diameter	Cat. No.	Price
I	Up to 1.260" (32.00mm)	25005	
I	Up to 1.528** (38.80mm*)	25055	
II	1.261 – 3.031" (32.01 – 77.00mm)	25024	



*For Group S machines.

ROUND STRIPPER

Description	Cat. No.	Price
Keyed	25006	
Group 'H'*/I	25358	
Group 'S'	25032	
Non-Keyed	25136	



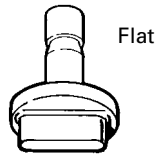
Stripper Pin
Cat. No. 25179

Note: For size III tooling, contact our sales desk.

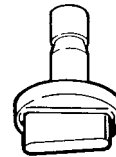
Add Ons

Special Shears	Add ons for Rounds			Add ons for Shapes		
Inverted Rooftop/Single Concave Size I Size II	Small Diameter .031 – .061" (0.79 – 1.56mm)	Punch	Die	Small Width Size I .031 – .039" (0.79 – 1.00mm) .040 – .092" (1.01 – 2.34mm)	Punch	Die
Double Valley/Double Concave Size I Size II	Clearance < .004 (0.10mm) Size I Size II			Size II .031 – .039" (0.79 – 1.00mm) .040 – .092" (1.01 – 2.34mm)		
Note: Add _____ to round or shape punch for extra straight before radius, extra back taper, or no back taper.						

STANDARD SHAPES SIZE 0, I, II



Flat



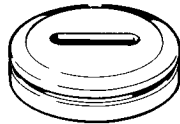
Whisper Shear

STANDARD SHAPE PUNCH								
Size	Dimension	Flat		Whisper Shear		Long**		Optima™ Add-on
		Cat. No.	Price	Cat. No.	Price	Cat. No.	Price	
0†	.031 – .236" (0.8 – 6.00mm)	25022		–		25743		
0†	.237 – .413" (6.01 – 10.50mm)	25023		–		25747		
I	.031 – 1.181" (0.80 – 30.00mm)	25026		25063		25751		
II	1.182 – 1.496"* (30.01 – 38.00mm*)	25031		25065		–		
II	1.182 – 1.575" (30.01 – 40.00mm)	25039		25065		25755		
II	1.576 – 2.000" (40.01 – 50.80mm)	25040		25066		25759		
II	2.001 – 3.000" (50.81 – 76.20mm)	25001		25067		25763		

†Not recommended for punching stainless steel.

*For Group S machines.

**For Group I machines. Not available with shear.



STANDARD SHAPE DIE			
Size	Dimension	Cat. No.	Price
I	Up to 1.260" (32.00mm)	25027	
I	Up to 1.528"* (38.80mm*)	25044	
II	1.261 – 3.008" (32.01 – 76.40mm)	25000	

*For Group S machines.

Stripper Pin
Cat. No. 25179

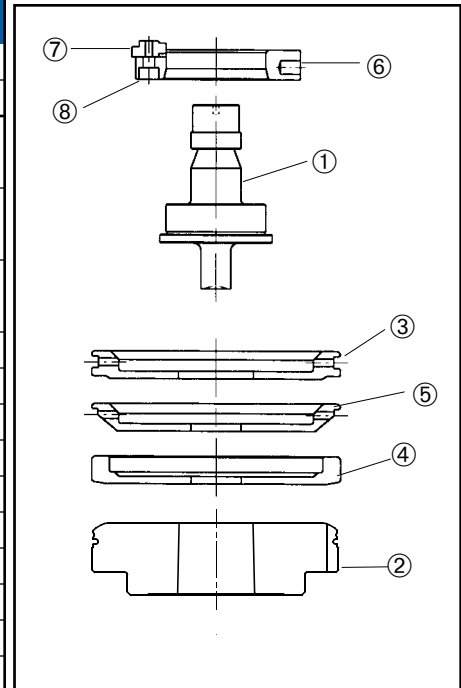


STANDARD SHAPE STRIPPER		
Description	Cat. No.	Price
Keyed	25028	
Group 'H'/I	25359	
Group 'S'	25030	
Non-Keyed	25137	

Note: For size III tooling, contact our sales desk.

Radius or 45° Chamfer 4 Corners		Standard Shapes									
Punches											
Radius or Chamfer Size	Total Add On	SD Single-D	LD Long-D	ET Equilateral Triangle	SQ Square	HX Hexagon					
.001 - .062 (0.02 - 1.57mm)											
.063 - .250 (1.58 - 6.35mm)		DD Double-D	QD Quad-D	OB Obround	RT Rectangle	OT Octagon					
Greater than .250 (6.35mm)											
Dies											
Radius or Chamfer Size	Total Add On										
Any size		Note: For non-rotational keying, see page 3.									

SHAPE PUNCH				
Description	Round		Shape	
	Cat. No.	Price	Cat. No.	Price
1. Heavy Duty flat punch .394 – 1.575"(10 – 40mm)	25140		25141	
1. Heavy Duty whisper punch .394 – 1.575"(10 – 40mm)	25322		25321	
1. Heavy Duty punch (Rooftop) 1.575 – 3.000"(40 – 76.2mm)	25407		25406	
2. Heavy Duty Die	25180		25162	
3. Stripper, Keyed	25006		25028	
4. Stripper, Non-keyed	25136		25137	
5. Stripper Group H	25358		25359	
6. Heavy Duty system collar	25138		25138	
7. Spare collar key	25142		25142	
8. Key locating screw	25215		25215	
Collar clamping screw (not shown)	25216		25216	
Die shim pack (not shown)	25182		25182	
Optima™ add-on for punches	N/A		N/A	



FEATURES

The Heavy Duty system is designed to withstand the higher tonnage associated with punching and nibbling thicker materials. The punch is strengthened by having a large shoulder, enabling it to withstand the higher forces involved. It also has extra back taper as standard, reducing the galling and pick-up often associated with thicker materials. Optima™ coating on the punch will also greatly improve performance. The die is strengthened by a step on the bottom making the effective thickness of the die greater.

DESIGN CRITERIA

- Minimum punch dia .394" (10.00mm) (Below this use standard size 1 punch).
- Maximum die 'A' dimension 2.716" (69mm).
- Uses Heavy Duty system collar.
- Has extra back taper as standard.
- .039" (1.00mm) radius on corners will increase the life of the punch and die.
- Rooftop or whisper shear will reduce the tonnage significantly as long as the depth of shear is at least half the thickness of the material.
- Heavy Duty punch to be used on material .250" (6.35mm) thick and above or where punching force is over 22.5 tons.
- Heavy Duty die to be used where punching force is over 20 tons.
- Uses standard strippers.
- Tools for thicker plate often exceed the machine tonnage. Ask the sales desk to check this for you.

INFORMATION NEEDED

- Size and shape required
- Material thickness and type
- Machine model



Keyed collar fitted to punch

KEYED COLLARS		
Description	Cat. No.	Price
Size 2 Collar 0° - 45° - 90° - 180°	25317	
KEYED PUNCHES		
Dimension	Cat. No.	Price
up to 2.380" (60.5mm), flat	25376	
2.380 – 3.000" (60.5 – 76.2mm), flat	25575	
up to 2.380" (60.5mm), whisper	25576	
2.380 – 3.000" (60.5 – 76.2mm), whisper	25577	
Optima™ Add On	N/A	

FEATURES

Because of the rotation feature of today's machines, tools often remain in the holder for longer periods of time without being checked. With a keyed punch and collar, a positive key location between the punch and collar results in cost savings that are realized by less scrap and longer tool life now that punch movement has been eliminated. The positioning is 100% reliable and repeatable.

The inherent operational margins for error in the Quick Set System increase your risk for time consuming and costly problems. The Wilson keyed collar provides 100% accurate alignment every time.

This time-saver works by simply placing the collar on the punch and tightening one screw.

BENEFITS

- Fixed slots for greater accuracy and consistency.
- Reduced downtime. No need to use Quick Set.
- Much faster than Quick Set allowing the operator to carry out further tasks.
- Inherent accuracy reduces the reliance required on the operator.
- Consequent scrap rate reduction. The punch cannot turn at all during operation.

ROTATION MACHINES

The Wilson Tool Keyed Collar has been specifically designed for Trumpf rotation machines. It enables the tool to be set at either 0° or 90° without the use of Quick Set. This keyed collar is designed for use with Wilson Tool Trumpf style punches which have dowel pins attached.

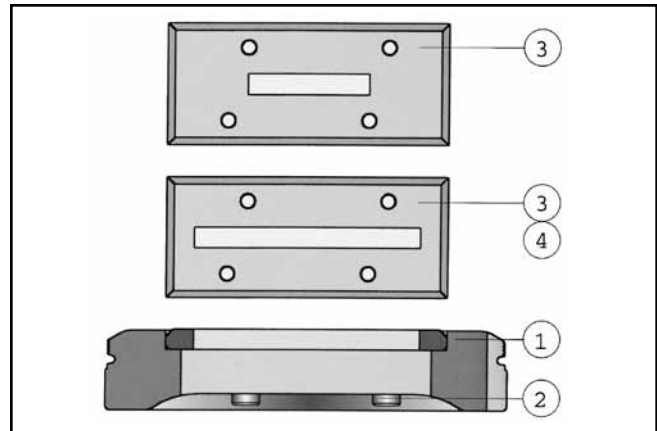
NON-ROTATION MACHINES

A second version of the keyed collar is also available for non-rotation machines. This one has an additional two slots set at 0°, 45°, 90° and 135°.

PARTING TOOL DIE ASSEMBLY
lengths up to 2.250" (57.15mm)
widths of .200" (5.08mm) and .250" (6.35mm)

Description	Cat. No.	Price
1. Complete Assembly without Blade	25464	
2. Blade Fixing Screw	25443	
3. Blade, maximum length 2.250" (57.15mm)	25463	
4. Shim Pack (not shown)	25439	

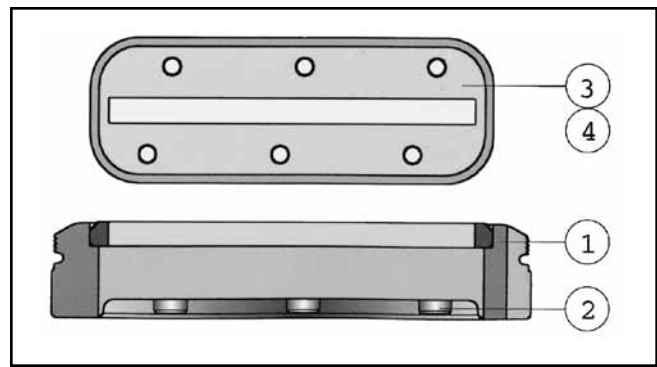
The blade holder is designed to accept the interchangeable rectangular die blades, and also any special shapes with maximum length of 2.250" (57.15mm).



PARTING TOOL DIE ASSEMBLY
lengths up to 3.000" (76.20mm)
with widths of .200" (5.08mm) and .250" (6.35mm)

Description	Cat. No.	Price
1. Complete Assembly without Blade	25466	
2. Blade Fixing Screw	25443	
3. Blade, maximum length 3.000" (76.20mm)	25465	
4. Shim Pack (not shown)	25441	

The blade holder is designed to accept die blades, with maximum length of 3.000" (76.20mm).



DESIGN CRITERIA

- Special sizes and shapes available. Must fit within ranges as specified.
- Maximum material thickness is .118" (3.00mm).
- Blades can be reground by .039" (1.00mm) max.
- Must be held flat for regrinding and coolant must be used.
- To ensure the screws do not come loose, reassemble using Loctite.

INFORMATION NEEDED

- Conventional rectangle size or special size and shape.
- Material type and thickness.
- Machine model.

WITH INTEGRAL COLLAR



The parting tool punches and dies can be used as a more cost effective slitting method. Instead of replacing the entire punch and die, only new blades need to be re-ordered. There are two fixed collar options available, one at 0° and one at 90°. The fixed collar enables quicker set up times and greater accuracy.

The blades are available in the following tool sizes: Length up to 3.000" (76.20mm) and widths available .200" (5.08mm) and .250" (6.35mm). (Not standard to North America - 5mm width available)

Special shapes are available to suit your application (e.g. special inverted diamond blades for microjointing).

** Standard for Trumpf machines*

QUICK SET PARTING TOOL PUNCHES

Description	Cat. No.	Price
Complete Assy without Blade 0° (.200")	25613	
Complete Assy without Blade 90° (.200") *	25614	
Complete Assy without Blade 0° (.250")	25611	
Complete Assy without Blade 90° (.250") *	25612	
Location Pin	970416	
Blade Locking Screw	25345	
0 - 1.181" (30.00mm) x .200" (5.08mm) Blade	25605	
0 - 1.181" (30.00mm) x .250" (6.35mm) Blade	25606	
1.181" (30.00mm) - 2.250" (57.15mm) x .200" (5.08mm) Blade	25607	
1.181" (30.00mm) - 2.250" (57.15mm) x .250" (6.35mm) Blade	25608	
2.250" (57.15mm) - 3.000" (76.2mm) x .200" (5.08mm) Blade	25609	
2.250" (57.15mm) - 3.000" (76.2mm) x .250" (6.35mm) Blade	25610	
Optima™ Coating	N/A	

METRIC - NOT STANDARD TO NORTH AMERICA

Description	Cat. No.	Price
Complete Assy without Blade 0°	25600	
Complete Assy without Blade 90°	25602	
Location Pin	970416	
Blade Locking Screw	25345	
56 x 5mm RT Blade with 0.5mm radius	25346	
30 x 5mm RT Blade with 0.5mm radius	25347	
76.2 x 5mm RT Blade with 0.5mm radius	25414	
0 - 30 x 5mm Blade (Special)	25447	
30 - 56 x 5mm Blade (Special)	25448	
56 - 76.2 x 5mm Blade (Special)	25449	
Optima™ Coating	N/A	

FEATURES

The parting tool punch holder is designed to accept interchangeable punch blades up to a maximum length of 3.000" (76.20mm), with widths of .200" (5.08mm) and .250" (6.35mm).

The blades have a regrind life of .118" (3.00mm) and the assembly is limited to use in up to .118" (3.00mm) material. Blades are supplied with rooftop shear as standard to reduce punching force and noise.

The Parting Punch Assembly is permanently set at 0° or 90° eliminating any risk of blade misalignment.

DESIGN CRITERIA

- Maximum material thickness is .118" (3.00mm).
- Used with standard stripper.
- Blades supplied only with rooftop shear.
- Must be reground in vibration free fixture with coolant.
- Special sizes and shapes available. Must fit within ranges as specified.

INFORMATION NEEDED

- Conventional rectangle size or special size and shape.
- Material type and thickness.
- Machine model.
- Optima™ coating option.

Local
Tel: 651-286-6001
Fax: 651-286-5959

Toll Free U.S.A. & Canada
Tel: 800-328-9646
Fax: 800-222-0002

Toll Free Mexico
Tel: 001-800-741-2510
Fax: 001-800-544-2096

Website & Email
www.wilsontool.com
salesdesk@wilsontool.com



TOOLING CABINET, GRINDING FIXTURE

TOOLING CABINET		
Description	Cat. No.	Price
Trumpf Cartridge Cabinet	972669	
Standard Trumpf Tooling Cabinet	971092	
Options		
Plastic Drawer Liners	90002	
Mobile Base	90003	
Maple Top	90004	
Cart Handle (1)	90005	
Ribbed Rubber Mat	90006	

971092 STANDARD 8-DRAWER CONFIGURATION:

- 7 Drawers with 12 6 x 8" (152 x 203mm) compartments and 3-1/8" (79mm) depth (usable height).
- 1 Drawer with 16 6 x 6" (152 x 152mm) compartments and 7-1/16" (179mm) depth (usable height).
- Cabinet includes: ribbed rubber mat and lock with two keys.
- Dimensions: 42" (107cm) high x 28" (71cm) wide x 29" (74cm) deep.
- Tool cabinets are shipped Motor Freight-collect.

972669 CONFIGURATION:

- 3 Drawers 100 mm deep (12 compartments each)
- 4 Drawers 150 mm deep (open layout)
- Able to hold cartridges

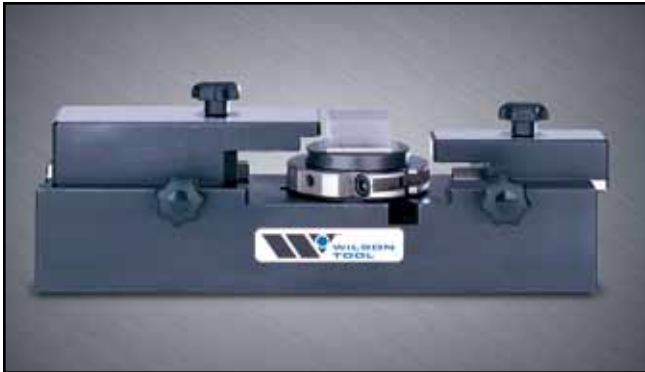


Note: Cabinet #971092 pictured. Actual color and drawer arrangement will vary slightly from photo.

GRINDING FIXTURE & COMPONENTS		
Description	Cat. No.	Price
Grinding Fixture (includes instructions)	6034	
Size 1 & 2 Punch Holder	6089	
Size 1 Die Holder	25365	
Size 2 Die Holder	25366	
MT4 Punch Holder	25302	
MT4 Die Holder	25304	
MT6 Punch Holder	25303	
MT6 Die Holder	25305	
MT5 Punch Holder	25935	
MT5 Die Holder	25936	
MT10 Punch Holder	26004	
MT10 Die Holder	26021	

**SHEAR GRINDING FIXTURE**

- Easy to adjust angle setting for shear grinding.
- Can be used with your existing surface grinder.
- Easy to use instruction sheet with grinding tips.



ALIGNMENT FIXTURE		
Description	Cat. No.	Price
Alignment Fixture	24186	

FEATURES AND BENEFITS

- Simplified, economical design.
- Durable yet portable fixture.
- Precision-made body with very few wearable parts.
- Angle settings of 0°-45°-90°.
- Easy-to-use regrind length chart included.
- Extremely accurate.
- Ergonomically designed.
- Versatile. The fixture can take all types of Trumpf-style collars: Size I, Size II, Minimatic-style, Heavy Duty, Manual, plus forming tools that do not have integral collars. Can be used for flat and whisper-style punches.
- Variety. Suitable for Trumpf, Pullmax, Omes, Euromac, Kunz and Boschert machines.



TRUMPF CARTRIDGE & DIE PLATE		
Description	Cat. No.	Price
Trumpf Cartridge	26222	
Trumpf Cartridge for ToolMaster System	26331	
Trumpf Die Plate	26215	
Cartridge Magnetic Pad	26235	
Cartridge Magnetic Pad (5 pack)	26259	

FEATURES AND BENEFITS

- Designed to enhance punch press productivity
- Lightweight, durable alternative to plastic or steel cartridges
- Constructed of 6061 T6 aluminum

WILSON PUNCH & DIE GRINDER

MACHINE & CONSUMABLES PRICING		
Description	Cat. No.	Price
230V 3 Phase 30 Amp grinder	6854	
230V 3 Phase 30 Amp grinder - Enclosed	6938	
460V 3 Phase 20 Amp grinder	6855	
460V 3 Phase 20 Amp grinder - Enclosed	6939	
1/2 gallon coolant mix	6856	
5 gallon coolant mix	6857	
Coolant filter pack (50 sheets)	6858	
6" replacement CBN wheel	6859	
Production coolant filtration system	6860	
Replacement filter roll for filtration system	6861	

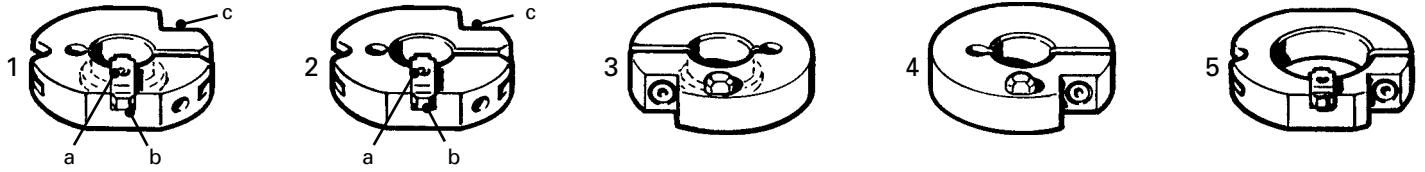
**WILSON PUNCH & DIE MINI GRINDER**

Machine & Consumables Pricing		
Description	Cat. No.	Price
DCM Mini PDG grinder	6950	
1/2 gallon coolant mix*	6856	
5 gallon coolant mix*	6857	
Coolant filter pack*	6858	
6" replacement CBN wheel*	6859	
DCM Mini shear grind sine plate	6951	

* These items are identical to Wilson Tool Grinder.



ALIGNMENT COLLARS/PUNCH CHUCKS, DIE & STRIPPER ADAPTERS, DIE SHIMS



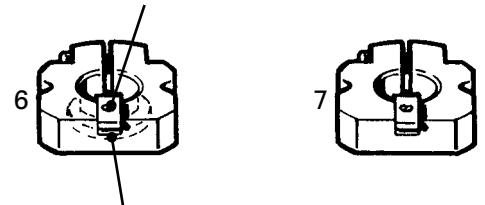
a.
Screw (M3 x 12)
Cat. No. 25215

b.
Locating Key
Cat. No. 25019

c.
Adjustment Bolt
(M6 x 35mm)
Cat. No. 970453

M14 Set Screw
Cat. No. 25215

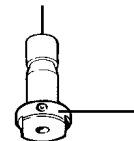
ALIGNMENT COLLARS			
Size	Description	Cat. No.	Price
I	1. Auto-tool change machine groups E/F/G/H/I	25018	
II to III	2. Auto-tool change machine groups E/F/G/H/I	25139	
I	3. Manual tool change machine groups A/B/C/D	25197	
II to III	4. Manual tool change machine groups A/B/C/D	25198	
I to II	5. For heavy duty punch	25138	
I	6. For machine group S	25186	
II to III	7. For machine group S	25188	



Locating Key
Cat. No. 25209

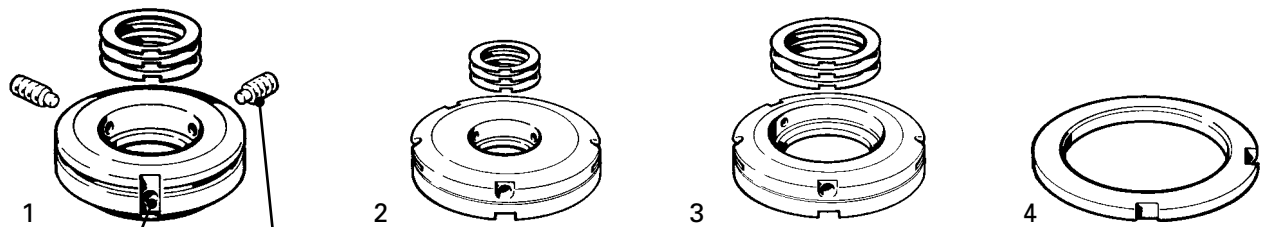
PUNCH CHUCKS			
Size	Diameter	Cat. No.	Price
0"	.000 – .236" (0 – 6.00mm)	25010	
0"	.237 – .413" (6.01–10.5mm)	25021	

M6 Set Screw
Cat. No. 25212



M6 Set Screw
Cat. No. 25213

†Not recommended for punching stainless steel.



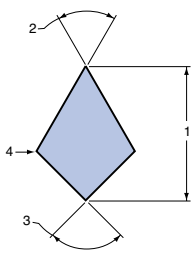
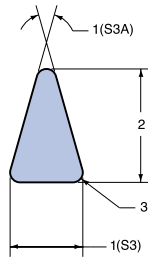
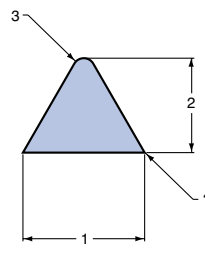
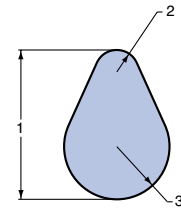
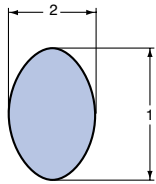
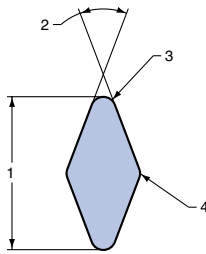
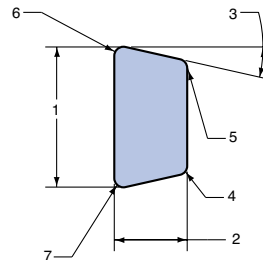
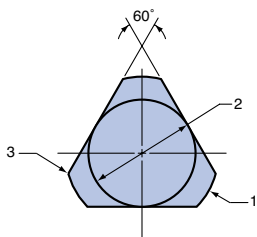
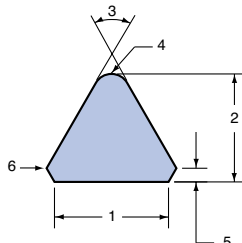
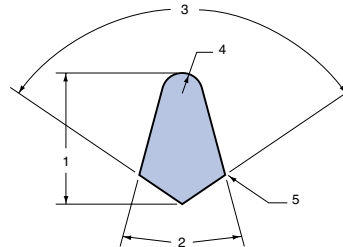
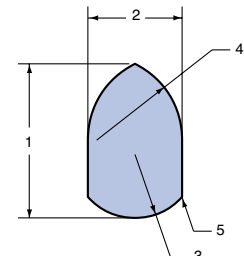
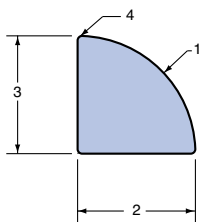
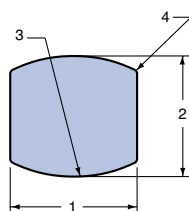
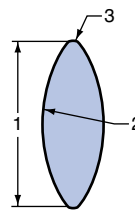
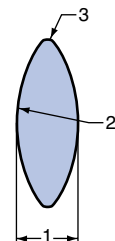
Screw (M8 x 12mm)
Cat. No. 970398

Dowel Pin (M8 x 12mm)
Cat. No. 6717

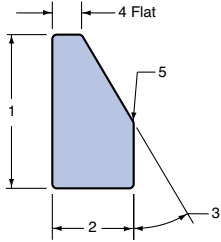
DIE AND STRIPPER ADAPTERS, DIE SHIMS			
Size	Description	Cat. No.	Price
I to II	1. Die Adapter, machine groups F/H/I	25165	
I to III	2. Die Adapter, machine groups E & G	25168	
II to III	3. Die Adapter, machine groups E & G	25167	
II to III	4. Stripper Adapter, machine group G	25155	
I	Shim Pack for size I Dies*	25181	
II	Shim Pack for size II Dies*	25182	

*Includes 1 each of .5 and .3 shims and 2 each of .1 mm thick shims

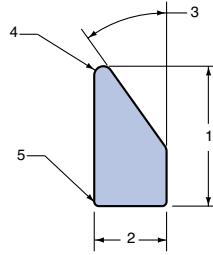
Note: Special Considerations May Alter Price and Lead Time

**S1****S3 -S3A****S4****S7****S8****S9****S23****S50****S51****S59****S65****S69****S81****S95L****S95W**

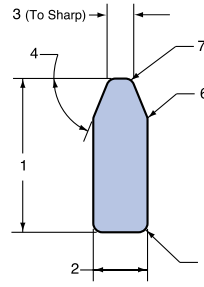
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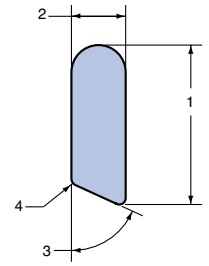
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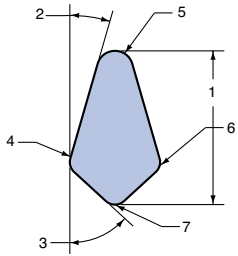
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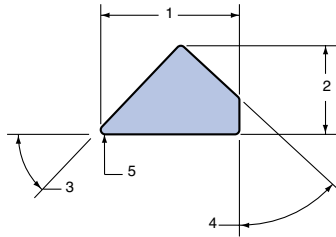
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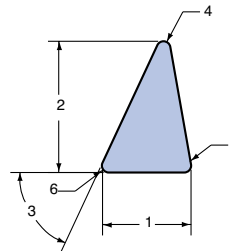
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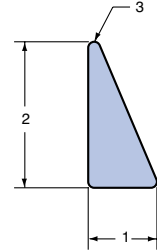
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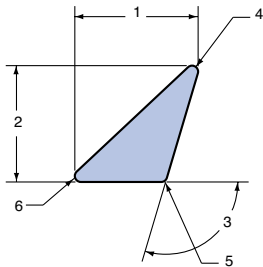
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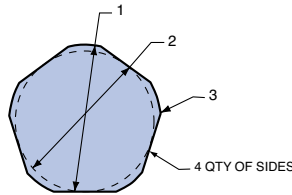
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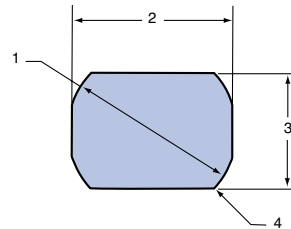
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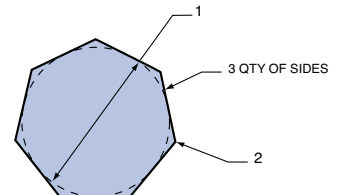
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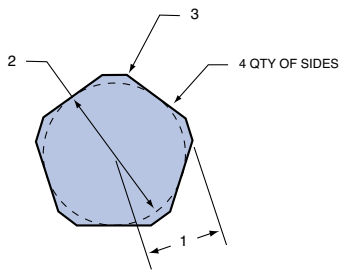
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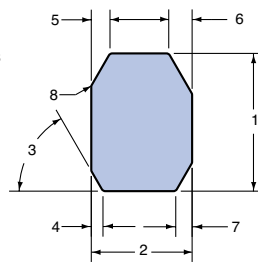
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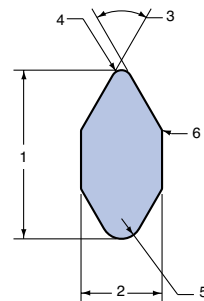
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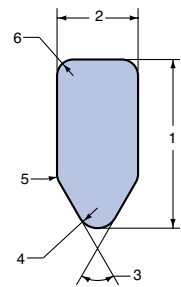
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S161



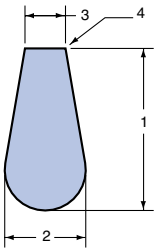
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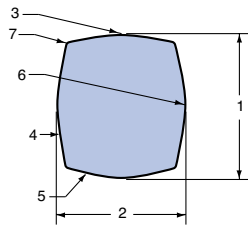
S163

SPECIAL SHAPES

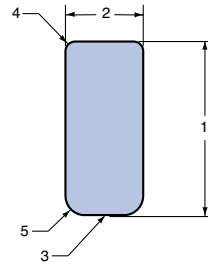
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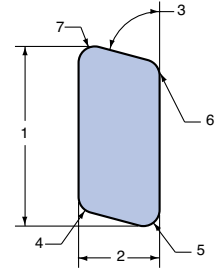
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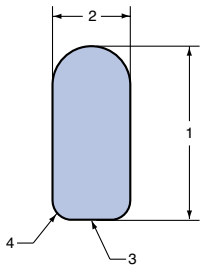
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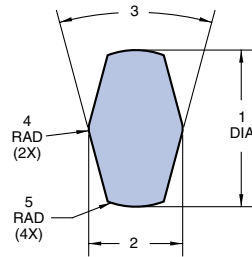
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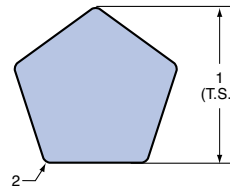
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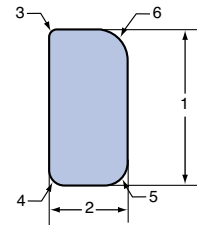
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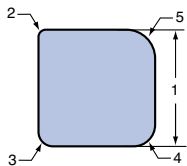
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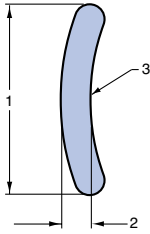


RTF

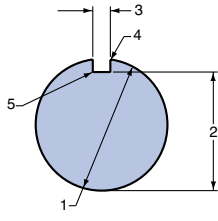


SQF

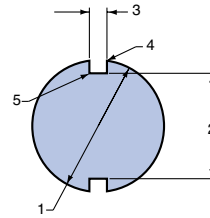
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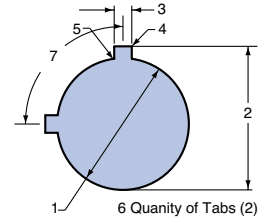
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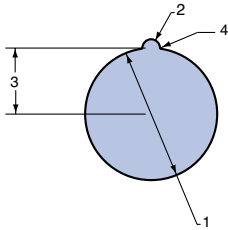
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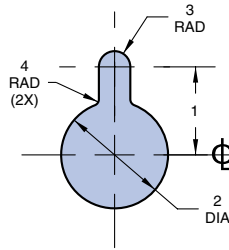
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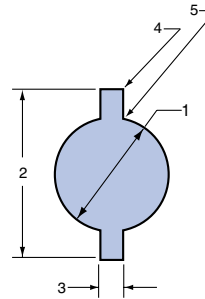
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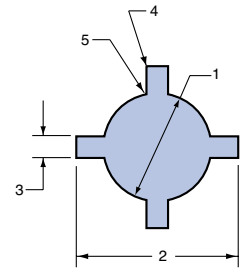
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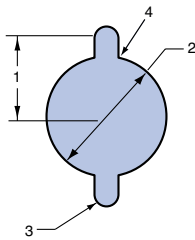
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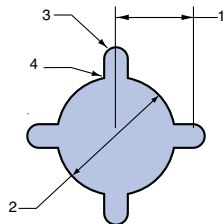
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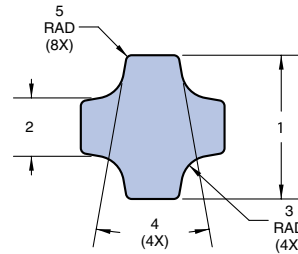
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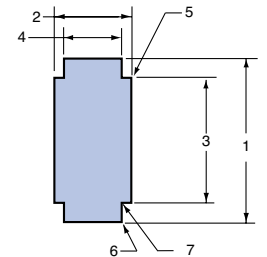
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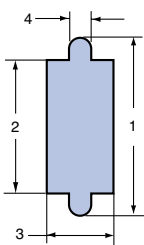
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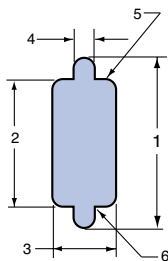
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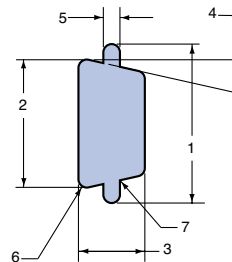
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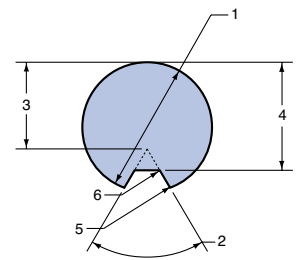
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S22



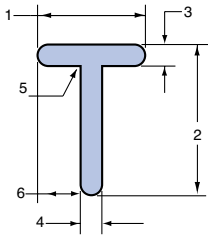
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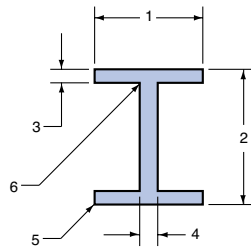
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SPECIAL SHAPES

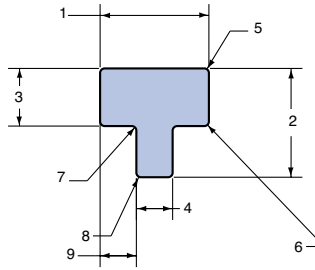
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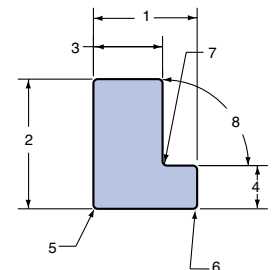
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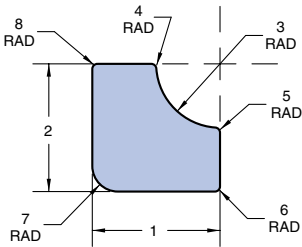
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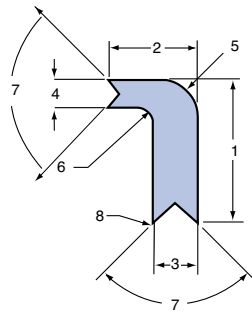
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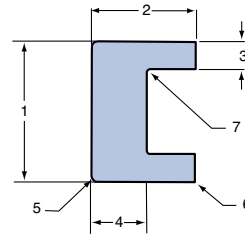
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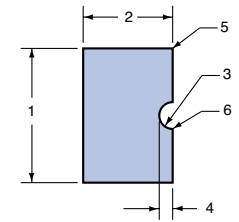
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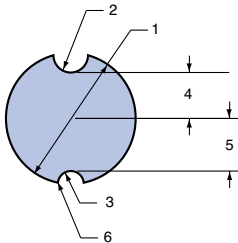
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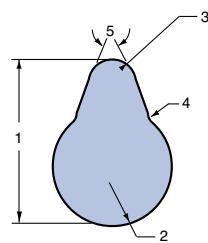
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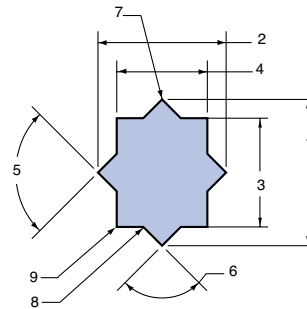
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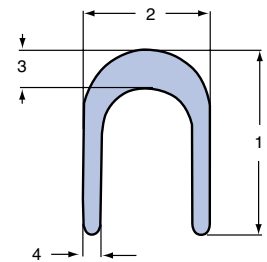
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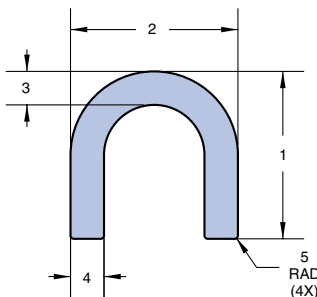
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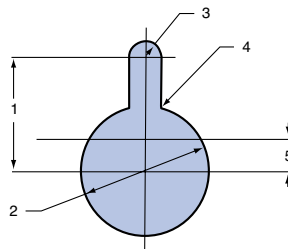
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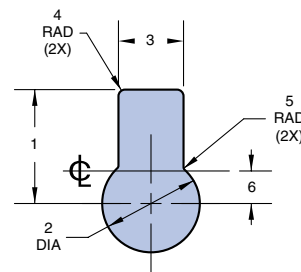
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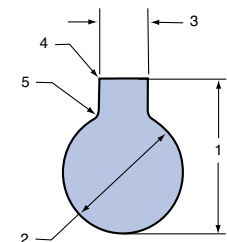
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S56

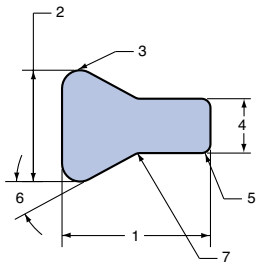


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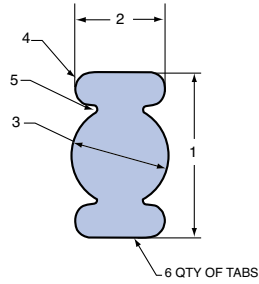


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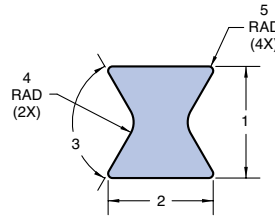
GROUP "B"



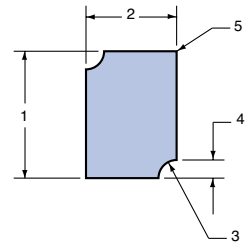
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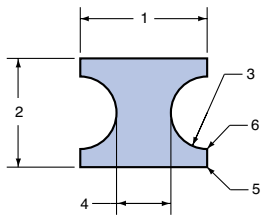
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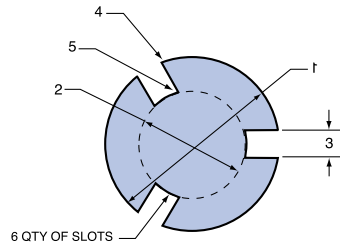
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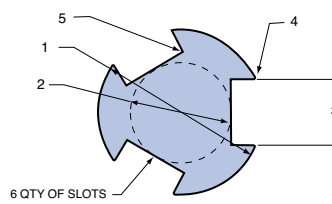
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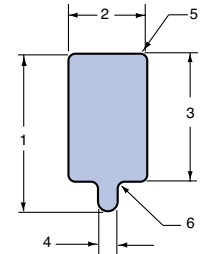
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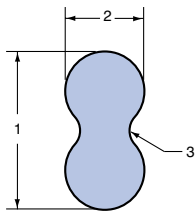
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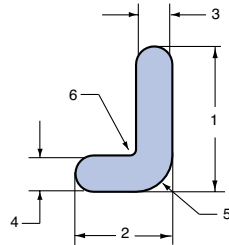
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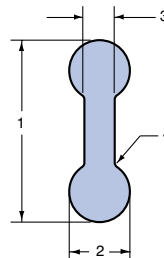
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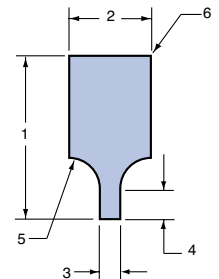
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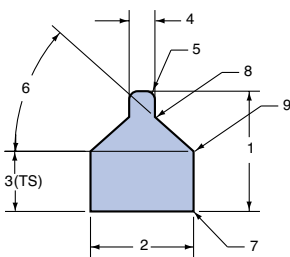
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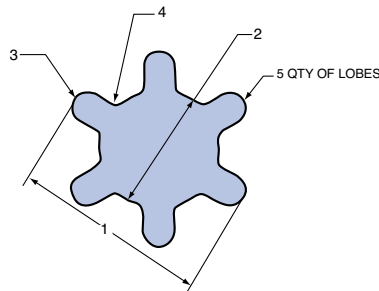
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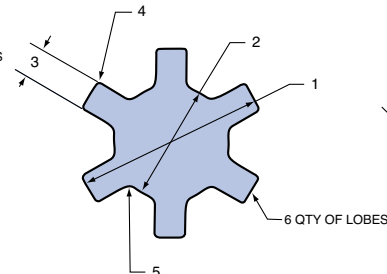
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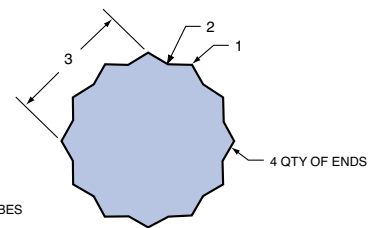
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S115



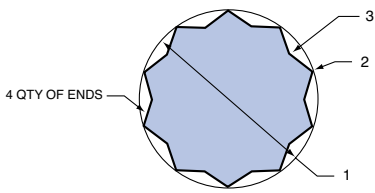
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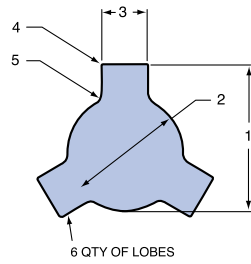
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SPECIAL SHAPES

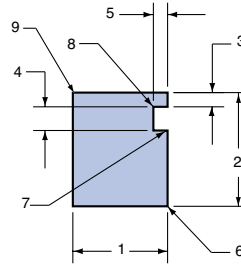
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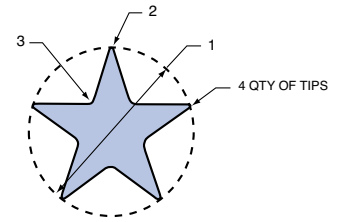
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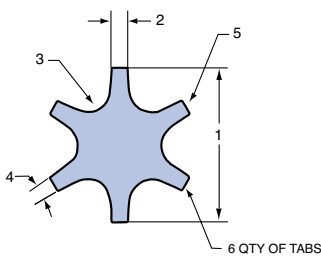
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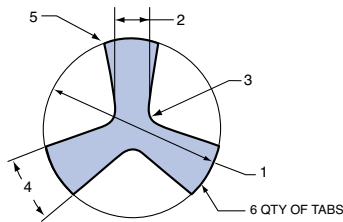
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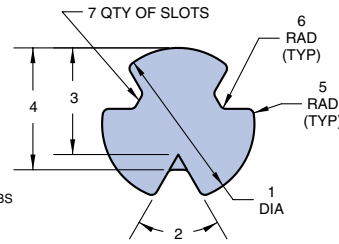
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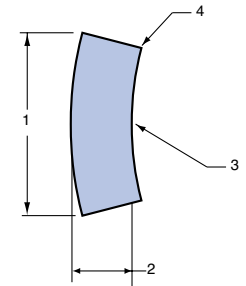
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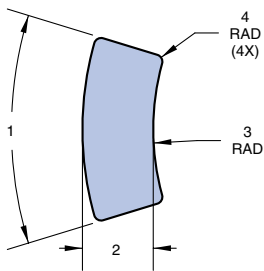
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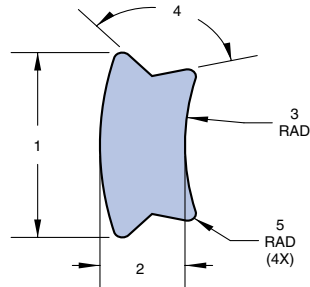
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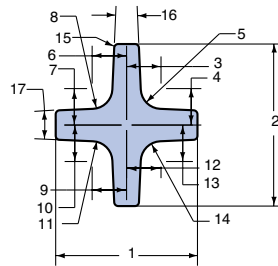
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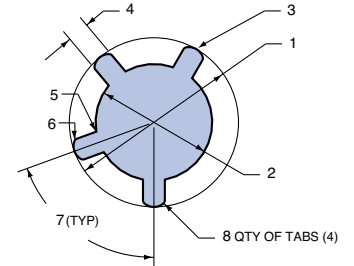
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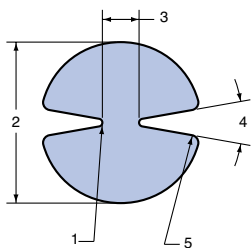
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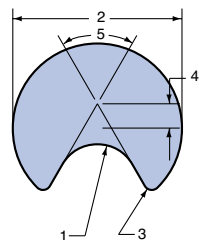
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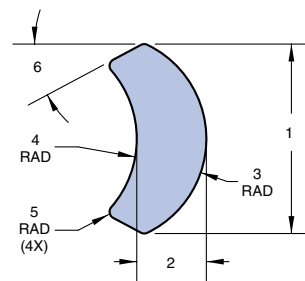
S169



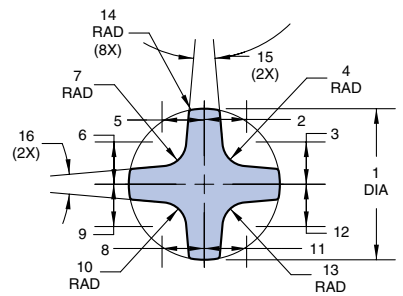
S171



S172

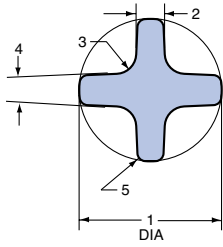


S174

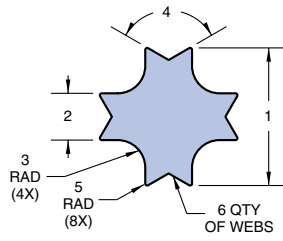


S176

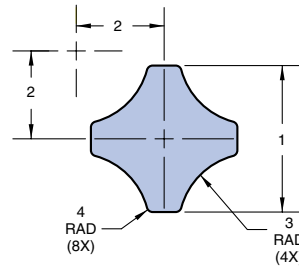
GROUP "B"



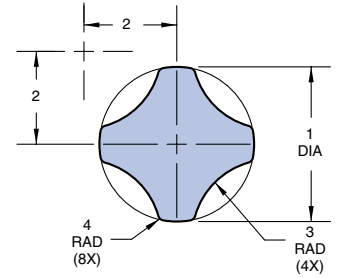
S177



S179



S19A



S19B

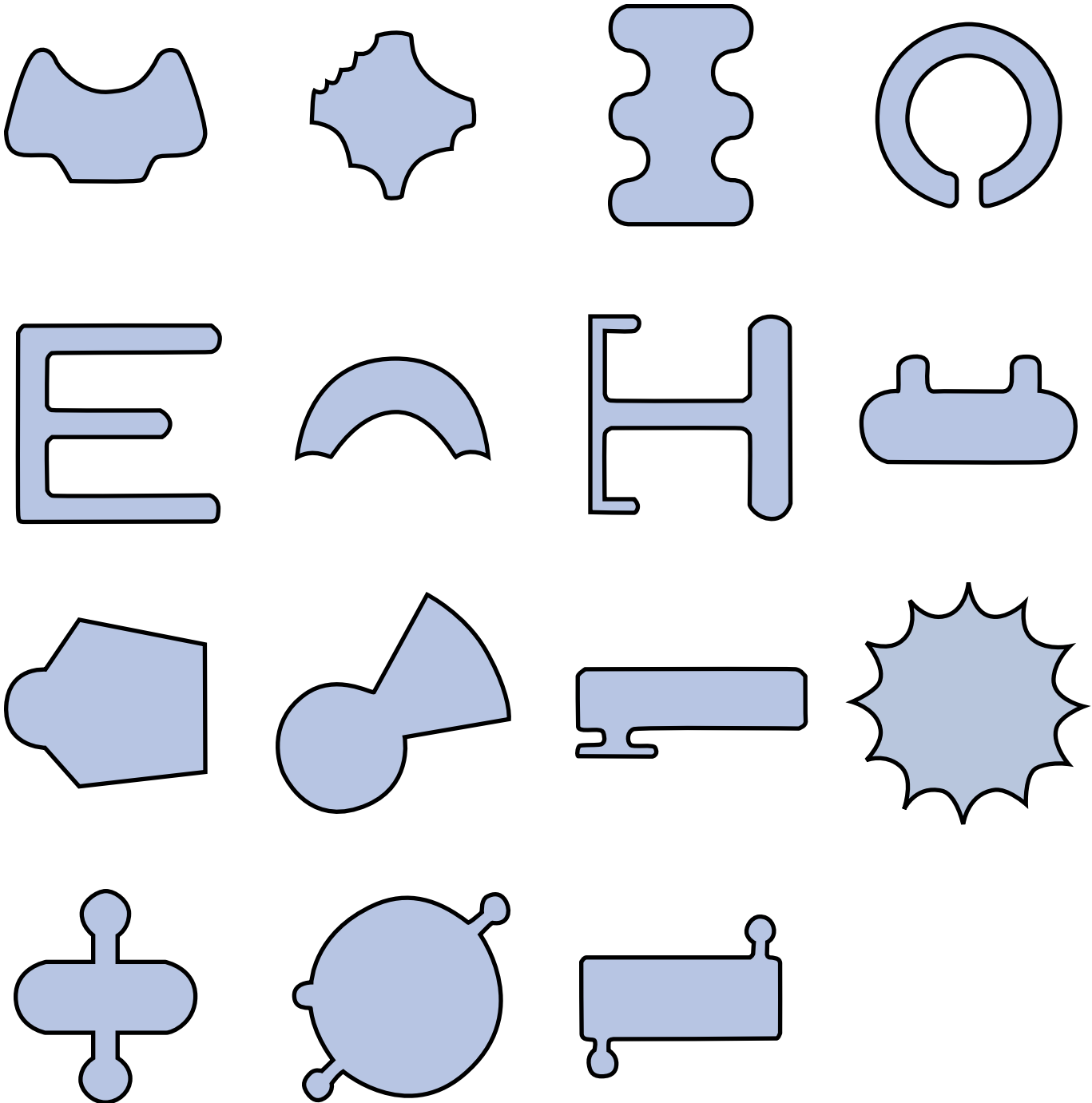
S19

4-Way Radius Tools - Standard Sizes

RADIUS		DIM. 1		DIM. 2		DIM. 3	
.062	(1.58mm)	.500	(1.58mm)	.250	(6.35mm)	.062	(1.58mm)
.094	(2.39mm)	.625	(2.39mm)	.250	(6.35mm)	.094	(2.39mm)
.125	(3.18mm)	.625	(3.18mm)	.250	(6.35mm)	.125	(3.18mm)
.156	(3.96mm)	.750	(3.96mm)	.250	(6.35mm)	.156	(3.96mm)
.188	(4.78mm)	.750	(4.78mm)	.250	(6.35mm)	.188	(4.78mm)
.250	(6.35mm)	.875	(6.35mm)	.250	(6.35mm)	.250	(6.35mm)
.312	(7.93mm)	1.000	(7.93mm)	.250	(6.35mm)	.312	(7.93mm)
.375	(9.53mm)	1.125	(9.53mm)	.250	(6.35mm)	.375	(9.53mm)
.500	(12.7mm)	1.250	(12.7mm)	.250	(6.35mm)	.500	(12.7mm)

SPECIAL SHAPES

GROUP "C"



LARGE DIAMETER HOLE PUNCHING

Machines with Rotation

When a hole larger than the capacity of the machine is required, Rotation machine users have three options. All three options give good quality holes, virtually free from any scallop marks associated with a nibbled hole using a round punch.

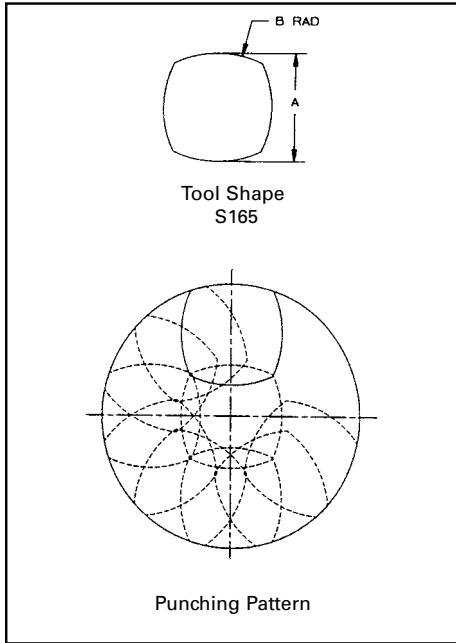


FIGURE 1

Figure 1: This tool is designed so that all the scrap material is removed through the die, thus eliminating the need to stop the machine to remove waste material. You may have FOUR different radii with this tool.

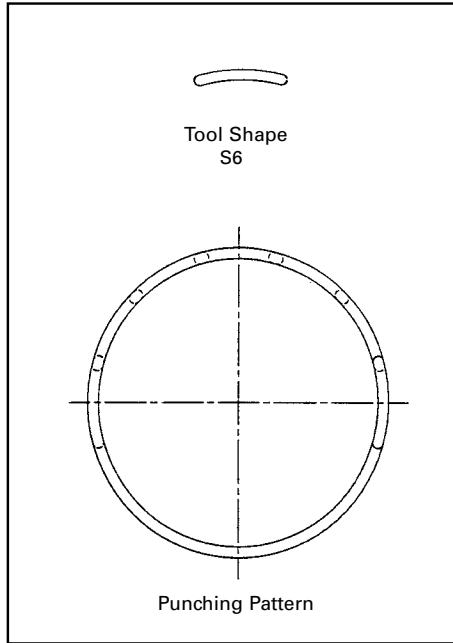


FIGURE 2

Figure 2: This type of tool is used by slitting around the diameter required and removing the material at the center. The advantages with this design are that fewer hits are required, you may punch round blanks, using the inside radius or round holes, using the outside (or both).

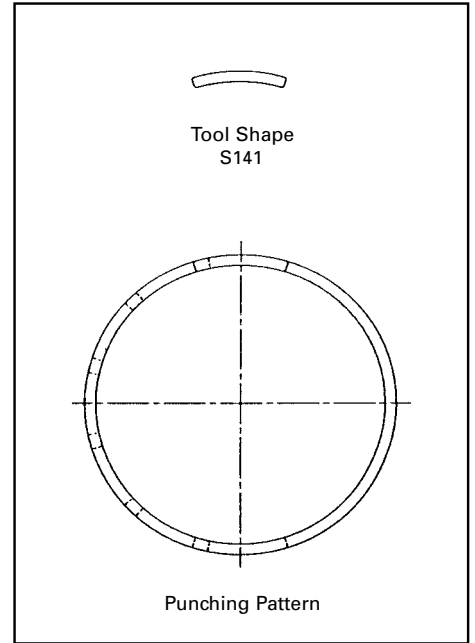


FIGURE 3

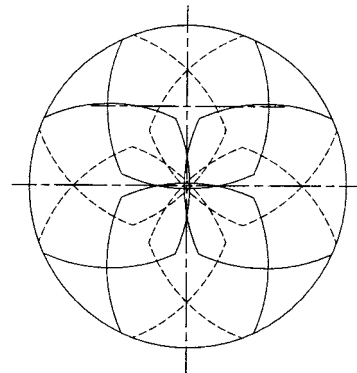
Figure 3: This design is for use as Figure 2, but with square ends, half circles etc., may be produced.

Non-Rotation Machines

When trying to punch a larger hole than the diameter of the largest station in the machine, our recommendation is a four-sided punch as shown below. The tool is designed so that each of the four faces are equivalent to 1/8 of the circle desired. The circle is then obtained by using the two punches, one keyed at 0° and the other at 45°, and making the four hits with each punch (see punching pattern). Your hole is obtained with the minimum number of hits and no scalloping. As an extra bonus the tool is designed so that no material is left to be removed from the center of the circle.

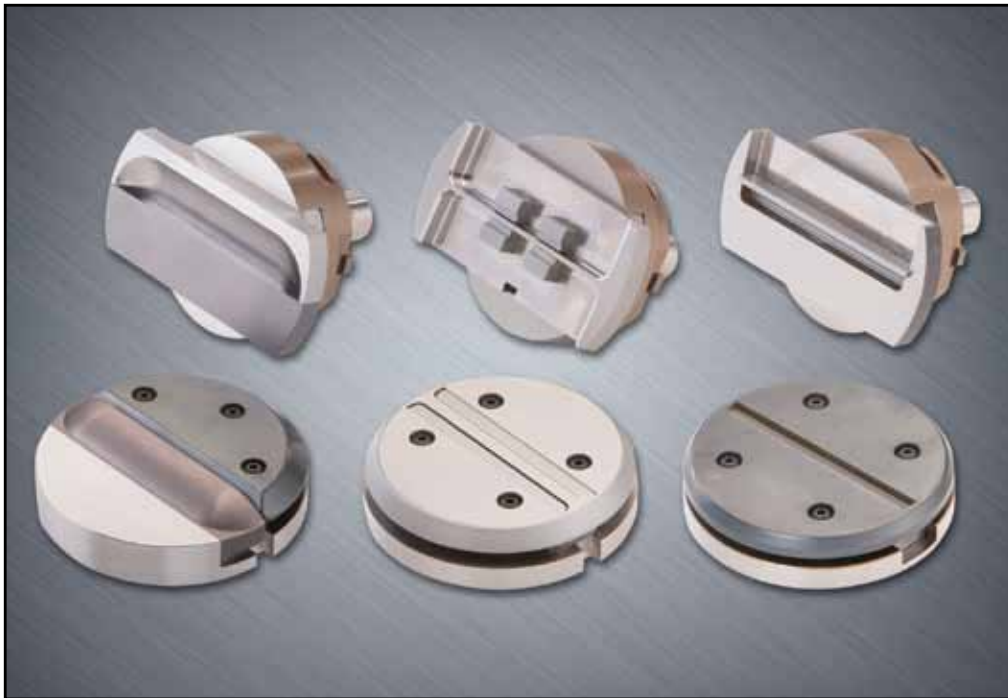


TOOL SHAPE



PUNCHING PATTERN

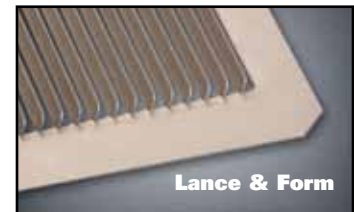
A-PLUS



Louver



Card Guide



Lance & Form

FEATURES

Maximize your "A" dimension with the A-Plus Series of tooling from Wilson Tool. This line of Trumpf-style special tools extends the range of forming in the A-dimension, allowing for longer and larger forms. A-Plus offers a full additional 1.0" [25.4mm] or more in your forming applications.

A-Plus Series tooling is available for most Trumpf Group I machines. Machine specifications subject to change. Trumpf-style A-Plus series tooling requires a modified cartridge.

DESIGN CRITERIA

Louver

- Max. width is 4.0" [101.6mm].
- Built-in stripping in lower unit for trouble free sheet travel and simple programming.
- Replaceable forming unit in the die.

Card Guide

- Max. width is 3.4" [86.4mm].

Lance & Form

- Max. width is 3.5" [88.9mm].
- Can be used in many applications, such as for airflow, decoration, location markers shear tabs, wire harnesses and clip attachments.

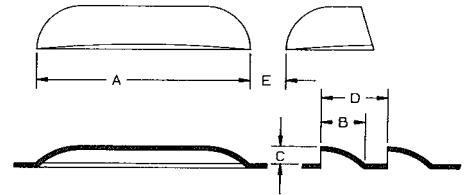
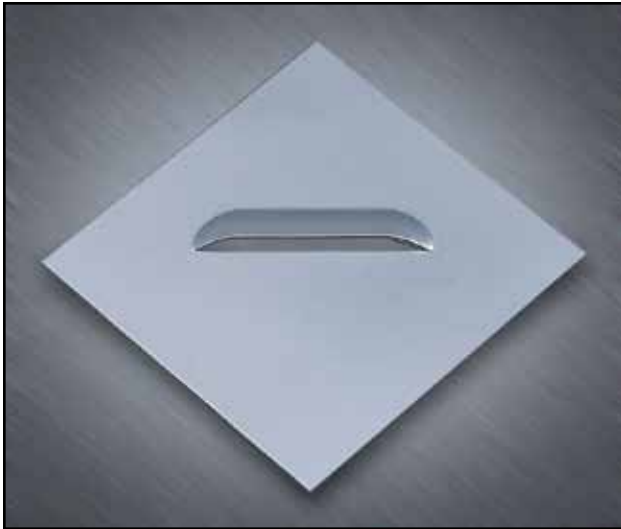
INFORMATION NEEDED

- Machine and model number
- Material thickness and type



DESCRIPTION	CAT. NO.	PRICE
A-Plus Cartridge	26296	
A-Plus cartridge for ToolMaster system	26356	

LOUVERS



REPLACEMENT PARTS		
Tool Type	Description	Cat. No.
Size II	Cutting Blade	N/A
Size II	Forming Insert	N/A

Standard sizes have Optima™ cutting and forming inserts.

FEATURES

This Wilson Tool designed louver has built-in stripping in the lower unit for trouble free sheet travel and simple programming. It also has a replaceable cutting blade in the upper unit and a replaceable forming unit in the lower unit. This enables cost effective refurbishment.

For A-Plus tooling, see pg. 31

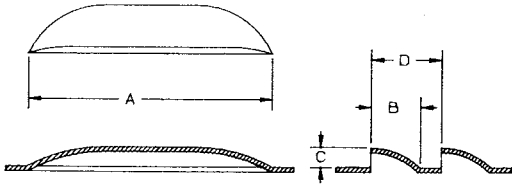
DESIGN CRITERIA

- Max. width louver on our standard design is .750" (19.00mm). Special wide louvers are available (POA)
- The higher the form the more noticeable the "drawing back" of the material will occur in the middle of the louver.
- Multiple hits with a single hit louver to produce a longer louver cannot be done. Bad distortion of the louver occurs. See progressive style.
- Max. material thickness for single hit louvers for our standard design is .118" (3.00mm) mild steel. Louvers for thicker material are available (P.O.A.).
- Stainless steel may cause a burr on the top edge of the louver. We can compensate for this but in some cases it cannot be eliminated completely.
- Sharpening is best left to the factory unless you have a tool and die shop with form grinding equipment. Our turn around time is within four days.

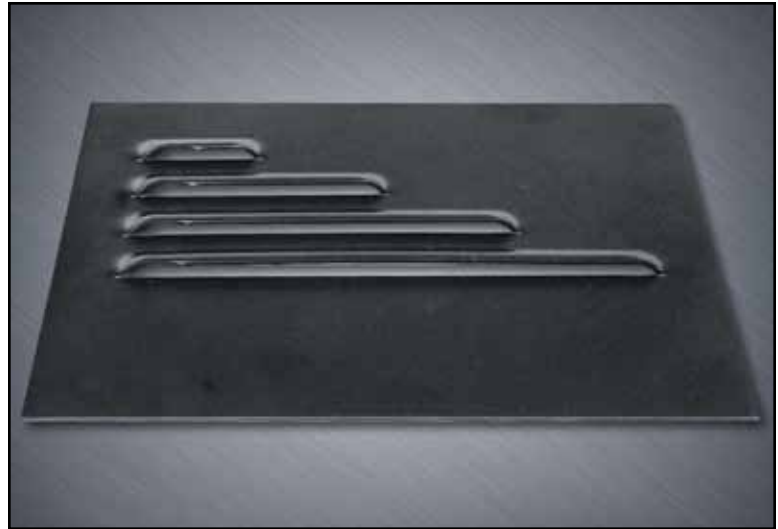
INFORMATION NEEDED

- Machine and model number
- Material thickness and type
- Form-up or Form-down (consult sales desk for form-down)
- A, B, C, D and E dimensions

FORM-UP PROGRESSIVE LOUVERS



"A" Dimension programmable to any length.



REPLACEMENT PARTS

Tool Type	Description	Cat. No.
Size II	Cutting Blade	N/A
Size II	Forming Insert	N/A

Standard sizes have Optima™ cutting and forming inserts.

STANDARD SIZE

Tool Type	Description			Cat. No.
	B	C	D	
Size II	.472" (12.00mm)	.197" (5.00mm)	.787" (20.00mm)	26200

Note: Sizes listed above are Wilson Tool standard sizes.

FEATURES

Now you can produce a louver of any length. This Wilson Tool designed louver has a replaceable cutting blade in the upper unit and a replaceable form insert in the lower unit for cost effective refurbishment.

DESIGN CRITERIA

- Progressive louvers cannot be put back to back. The minimum web between louvers must be 2 material thicknesses. The closer the louvers the greater the distortion.
- The ends of the progressive louver blend out into the sheet.
- Maximum material thickness for aluminum or mild steel is .118" (3.00mm).
- Maximum material thickness for stainless steel is .098" (2.50mm).
- Minimum increment moves are recommended.
- For non-standard sizes consult the sales desk for pricing.

INFORMATION NEEDED

- Machine and model number
- Material thickness and type
- B, C and D dimensions

LOGO TOOL



The logo has found many uses from making a company's name on a part for vendor identification or cosmetics to particular symbols.

Review your current application and you may find many unique uses for these tools. Logo tools give your product a nice distinctive touch.

FEATURES

Wilson Tool offers a wide variety of logo tools to meet your manufacturing needs. Logo tools can enhance product value, aid in part marking and eliminate costly secondary operations involved in labeling, painting or otherwise marking parts.

Logo tools are available as either form-up or form-down. The form-up tools are designed self stripping to prevent sheet marking and tool wear. Stamped logos can be used in a variety of material types and thicknesses. Emboss logos are material specific.

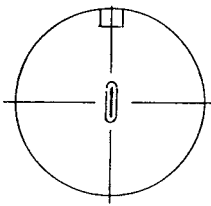
CONSIDERATIONS

- Thin materials may polish on the back side when stamped or embossed.
- Some logos may be limited in detail or size if land inches are too great.

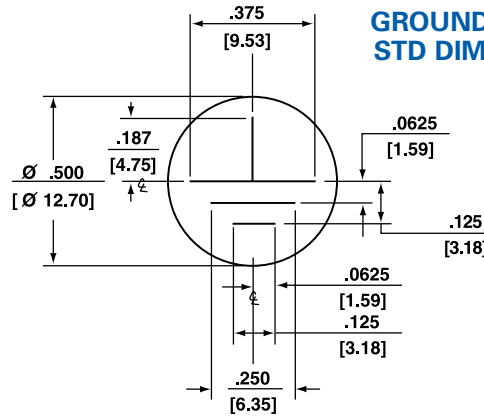
INFORMATION NEEDED

- Machine and model number
- Material thickness and type
- Camera ready artwork or a dxf file

DASH TOOL/GROUND SYMBOL

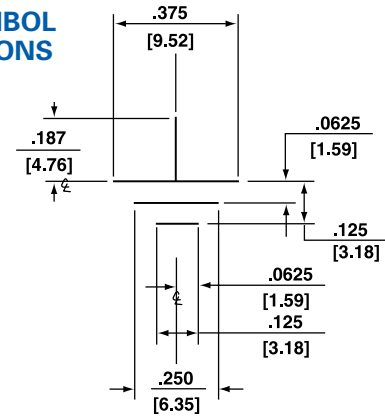


(Fig. 1)



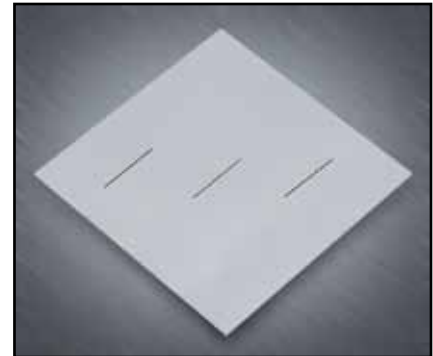
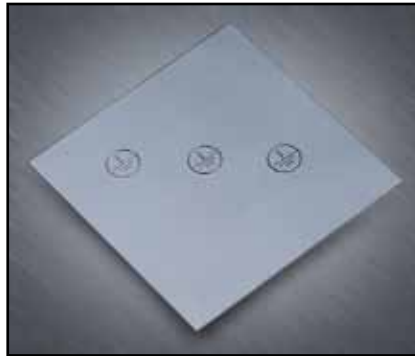
(Fig. 2)

GROUND SYMBOL STD DIMENSIONS



(Fig. 3)

DASH TOOL	
Tool Type	Size I
GROUND SYMBOL	
Tool Type	Size I W/Circle
	Size 1 W/O Circle



DASH TOOL

When you have varying applications of letter stamping, you may want to consider a dash tool for greater flexibility in programming your own letter or number sizes. A tool similar to Figure 1 may be indexed to either 0°, 45°, 90° or 135° and with some sharp programming will give you every digitized number and letter of the alphabet. For example:

1 2 3 or A B C

This tool is especially useful in applications where the number or letter of the part being marked is constantly changing or progressive.

With rotation machines, only one tool is necessary.

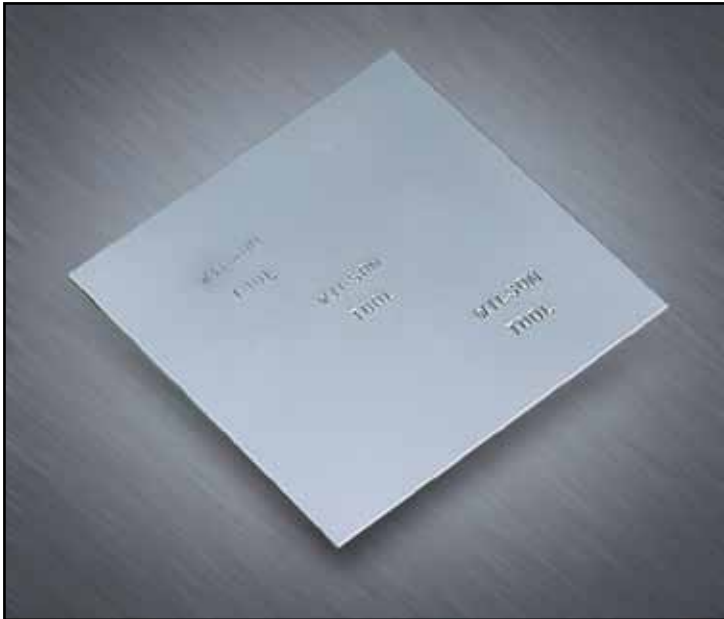
GROUND SYMBOL

The ground symbol is a widely used marking symbol in the electrical industry. It is both seen with a circle around the symbol and without (See Fig. 2 and Fig. 3).

INFORMATION NEEDED

- Machine and model number
- Material thickness and type
- Length of dash
- Size of ground symbol (std or non-std size)
- Form-Up or Form-Down

LETTER STAMP



LETTER/NUMBER STAMP TOOL		
Tool Type	Description	Cat. No.
Size II	Form-Down Letter Stamp 1 Row	26059
Size II	Form-Down Letter Stamp 2 Rows	26060
Size II	Form-Up Letter Stamp 1 Row	26061
Size II	Form-Up Letter Stamp 2 Rows	26062

Note: Multiple rows available upon request.

FEATURES

Marking material with letters or numbers is simple with Wilson Tool designed stamping or forming tools. We can make virtually any design required, the only limitation is on size and depth which affects the tonnage required of the machine. There are two types of tools available.

COINED STAMPING TOOL

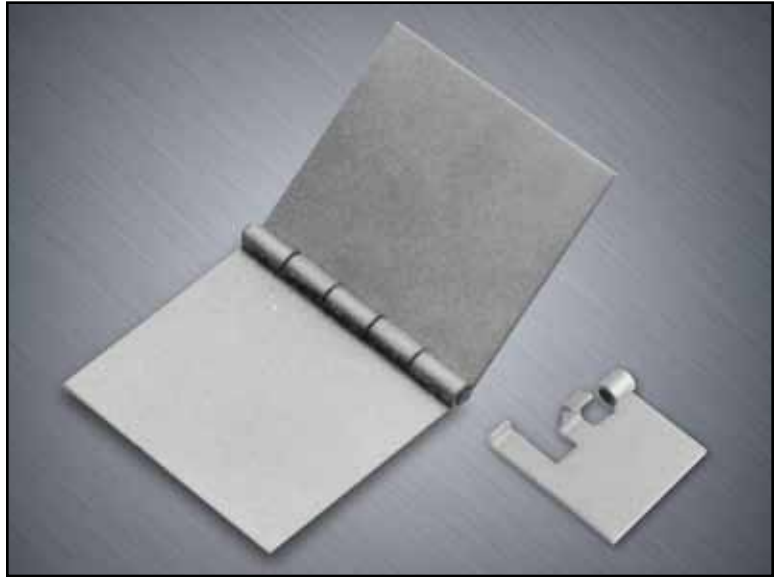
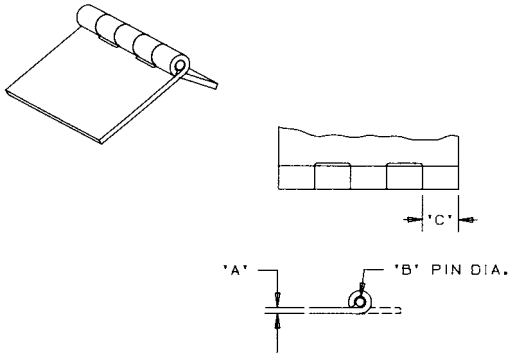
The stamp tool forms the number or letter within the material thickness only. In a typical form-down tool, the die is a solid blank (no hole) to act as an anvil. This type of tool is ideal for part numbers, etc.

INFORMATION NEEDED

- Machine and model number
- Material thickness
- Form-Up or Form-Down
- Layout or Artwork

NO. OF CHARACTERS POSSIBLE IN SINGLE/DOUBLE ROW LETTERSTAMP TOOL

CHARACTER SIZE	1/16	3/32	1/18	3/16	1/4	3/8
	1.58mm	2.38mm	3.17mm	4.76mm	6.35mm	9.52mm
MAX CHARACTER/ROW	37	23	18	12	9	6

FORM-UP HINGE TOOL

FORM-UP HINGE TOOL		
Tool Type	Description	Cat. No.
Size II	First tool (2 hits/Form)	25116
Size II	Second tool (1 hit/Curl)	25117

FEATURES

The "HingeTool" is a tool that eliminates costly hardware, fitting and lineup assembly. The "HingeTool" allows you to fabricate complete panels with their own integrated hinges. It consists of a set of two tools. The first tool makes two hits and the second tool, one hit. The net result is a fully curled "knuckle." Currently, our standard design is for a .125" (3.17mm) pin in .063" (1.60mm) material. Don't let this stop you. Call or fax us with your particular requirements. If you would like to see a sample of this technology, please let us know and we will arrange it.

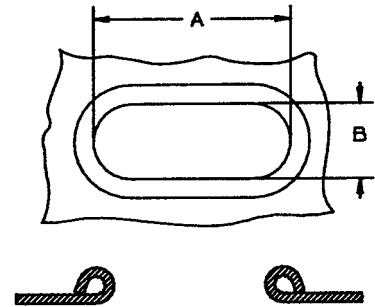
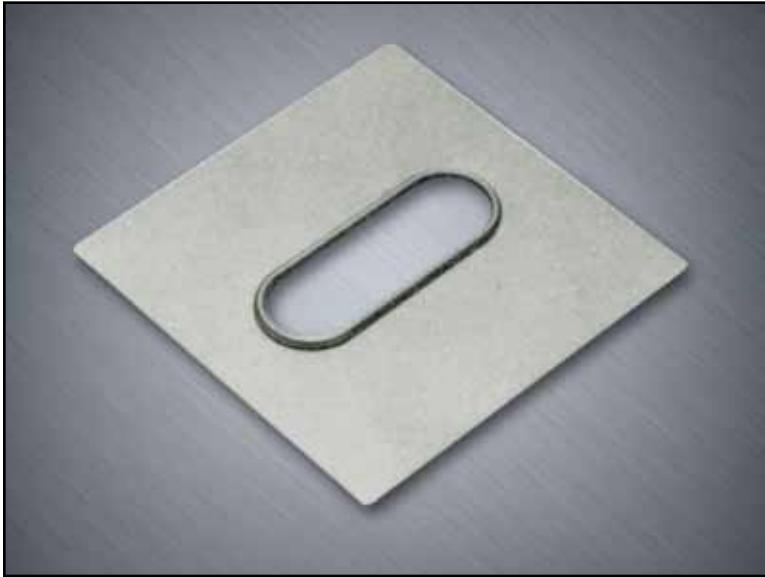
DESIGN CRITERIA

- Hinge tools do not work in .079" (2.00mm) stainless or thicker.
- Operating instructions will be sent with tools when shipped.
- Maximum material and pin size may vary according to machine. Consult sales desk for limitations.
- Offset hinge tools available, price on application.
- Pre-punch varies when producing hinge in middle of sheet.

INFORMATION NEEDED

- Machine and model number
- Material thickness and type
- Drawing required of application
- Pin size and tolerance
- Knuckle size
- Location of hinge on sheet required (edge or middle)

FORM-UP HAND HOLD TOOL



FORM-UP HAND HOLD TOOL		
Tool Type	Description	Cat. No.
Size II	Extrusion (2nd hit)	N/A
Size II	Rollover (3rd hit)	N/A

For prepunch operation use standard round or shape set price from applicable standards catalog (1st hit).

FEATURES

The hand hold or curling tool can be used in many applications. Rolling the material over creates a virtually burr-free opening, which lends itself nicely to hand holds, wire feed openings, grommets, and other special applications. There are three operations necessary to achieve the finished outcome. **FIRST**, a pre-punch hole is needed to create an opening. **SECOND**, an extrusion of material upward. **THIRD**, to curl the extruded opening downward. The amount of curl can be controlled by adjusting the length of punch. The hand hold/curling tool was developed to reduce costly secondary operations and handling.

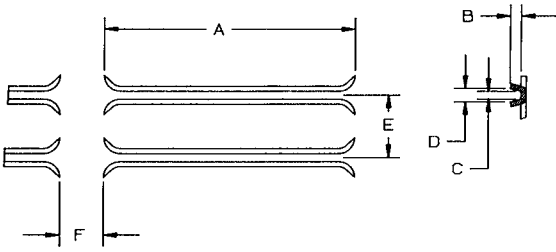
DESIGN CRITERIA

- Consult sales desk for size limitations.
- Pre-punch hole determined by Wilson Tool.
- For diameters or widths under .630" (16.00mm), tearing may occur.

INFORMATION NEEDED

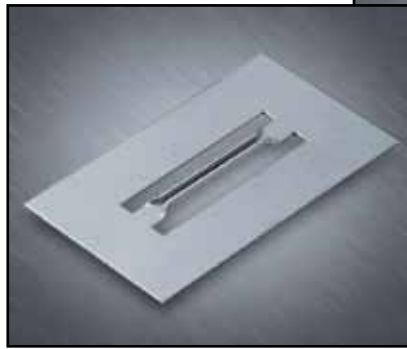
- Machine and model number
- Material thickness and type
- Drawing required of application

FORM-UP CARD GUIDES



FORM-UP CARD TOOL

Tool Type	Description	Cat. No.
Size II	Max 2.756mm	25119



FEATURES

Wilson Tool card guides are the result of years of development and engineering design changes. They are the finest card guide tools in the world. Card guide tools may appear an expensive investment on the face of it, but vast savings can be made over other methods of inserting guides, such as plastic inserts. Taking all the costs of extra material handling involved with secondary operations into account, these are very cost effective tools.

DESIGN CRITERIA

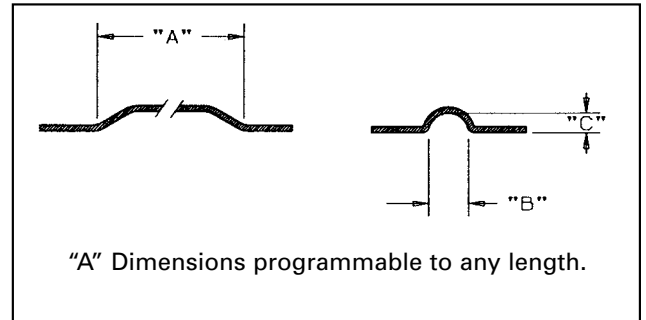
- There is a minimum height limitation on all card guides. Card guides with a height of less than .091" (2.30mm) from top of sheet to top of form will have a tendency to twist (one side will form higher than the other).
- Multiple hits to make a longer card guide will cause distortion.
- Wilson Tool will estimate the web of material to be formed.

INFORMATION NEEDED

- Machine and model number
- Material thickness and type
- Drawing of card guide desired and center-to-center location
- Pre-punch Shape: rectangle, obround or rectangle with radius corners

Notes: For A-Plus tooling, see page 31.

PROGRESSIVE RIBS



PROGRESSIVE RIBS	
Tool Type	Description
Size II	Size as order

FEATURES

This tool provides you with the ability to make high quality stiffening ribs right on the punch press. Thus eliminating the time and cost of secondary operations.

DESIGN CRITERIA

- "B" dimension must be a minimum of 2 times the "C" dimension.
- Maximum material thickness in mild steel is .098" (2.50mm) and stainless steel is .079" (2.00mm).
- Minimum incremental moves are recommended.
- Progressive ribs are made for a specific material thickness.
- A slight deformation will occur on the first hit.
- Ends of the rib flow back down into the material (not a distinct radius).

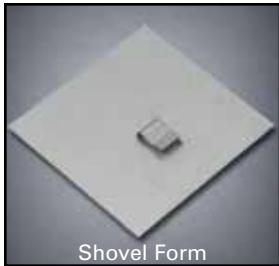
INFORMATION NEEDED

- Machine and model number
- Material thickness and type
- B and C dimensions

LANCE AND FORMS — FORM-UP

VARIATIONS

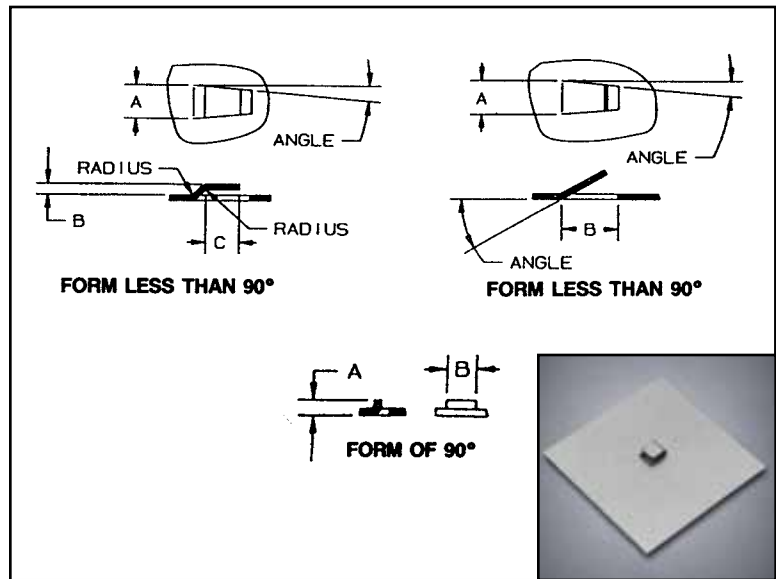
Special bend Lance and Forms (prices on application)



Shovel Form



Extra Bend



LANCE & FORM LESS THAN 90°	
Tool Type	Cat. No.
Size II	25133
LANCE & FORM OF 90°	
Tool Type	Cat. No.
Size I	N/A
Size II	25463

FEATURES

Lance and Forms are used in many applications such as for air flow, decoration, card guides, location markers, shear tabs, wire harnesses, clip attachments, and are very useful tools.

DESIGN CRITERIA

- Consult sales desk for size and height restrictions per station.
- In some cases, you must pre-punch around the tab on Lance and Forms of 90° when punching aluminum.
- Lance and Forms are made for a particular material thickness. Never run thicker material or damage will occur. You can adjust the tool to run lighter material but the form will change.
- Consult sales desk for special shape Lance and Forms.
- Lance and Forms of 90° must form a minimum of 2 material thicknesses overall.
- Maximum material thickness for Lance and Forms is .118" (3.00mm). Consult sales desk for special applications.
- On Lance and Forms of less than 90°, taper of 5° per side should be added to aid in stripping.
- Form-down Lance and Forms are not recommended for N/C machines.

INFORMATION NEEDED

- Machine and model number
- Material thickness and type
- Complete drawings of the lance and form showing length, width, height, material thickness and type, angles, and other forms (if any) near lance so proper relief can be built into the tool.

Notes: For A-Plus tooling, see page 31.



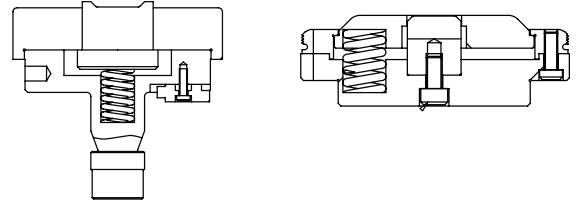
Local
Tel: 651-286-6001
Fax: 651-286-5959

Toll Free U.S.A. & Canada
Tel: 800-328-9646
Fax: 800-222-0002

Toll Free Mexico
Tel: 001-800-741-2510
Fax: 001-800-544-2096

Website & Email
www.wilsontool.com
salesdesk@wilsontool.com

FORM-UP BRIDGE TYPE LANCE AND FORMS



WITH STRIPPING		
Tool Type	Cat. No.	Cat. No.
	Size I	Size II
Single Bridge	25146	25114
Double Bridge	N/A	25075
WITHOUT STRIPPING IN UPPER UNIT*		
Tool Type	Cat. No.	Cat. No.
	Size I	Size II
Single Bridge	N/A	25196

*Must be pre-punched

FEATURES

The bridge type lance and form has a multitude of uses such as shear stops, locators, dividers, card guides, ventilation, wire conduit or for wire tie downs. When being used as a shear stop it does have the advantage of having a higher form so that it is easier to pick up gauging on.

The Wilson design gives a positive form which ensures a high quality part.

DESIGN CRITERIA

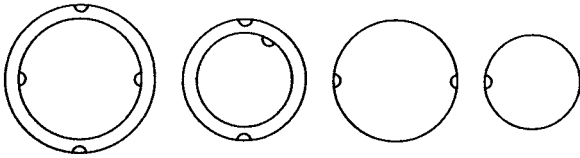
- Bridge Lance Forms are made for a specific material thickness. You can punch thinner material (the form will change) but never thicker material.
- The width of the bridge should be 1-1/2 times the material thickness in mild steel and aluminum and 2 times material thickness in stainless steel to warranty the tool.
- Special lead in available, please consult sales desk.

INFORMATION NEEDED

- Machine and model number
- Material thickness and type
- Station size
- Length, width, height and form of bridge



TRUMPF STYLE DIE PLATE SYSTEM		
25968	10 Station Lower Unit Assembly (No Die Plate)	
25808	10 Station Die Plate	

ELECTRICAL KNOCKOUTS**RECOMMENDED TAB LOCATIONS****SINGLE ELECTRICAL KNOCKOUTS (EKO'S)**

Tool Type	Description	Cat. No.
Size II	Round EKO	25111
Size II	Shaped EKO	25189

DOUBLE ELECTRICAL KNOCKOUTS (EKO'S)

Tool Type	Description	Cat. No.
Size II	Round EKO	25172

FEATURES

Wilson Tool's Electrical Knockout (EKO) design has full stripping in both upper and lower units, just where it is needed to produce good quality, reliable knockouts.

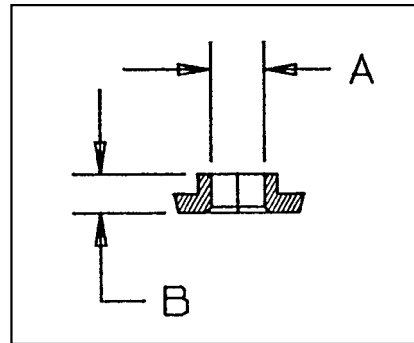
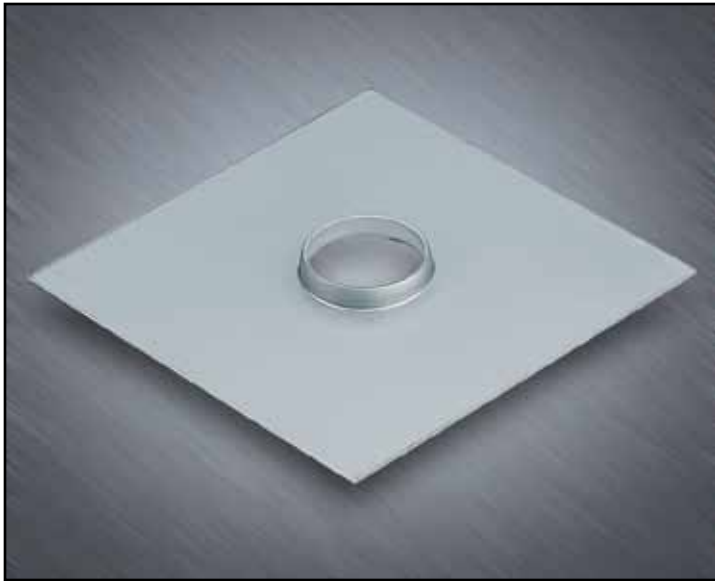
DESIGN CRITERIA

- EKO's are made to form one material thickness. You can get a good looking EKO with a 2 gauge range. Too much clearance will cause a burr.
- If you have a stripping problem, check height adjustment to be sure you are not over or under stroking.
- Consult Sales Desk for maximum sizes.

INFORMATION NEEDED

- Machine and model number
- Material thickness and type
- Form-up or form-down
- Pipe size or actual diameter
- Specify Standard or Special tab location and size

EXTRUSION TOOLS



FORM-UP EXTRUSION		
Tool Type	Description	Cat. No.
Size II	Extrusion (Assembly)	25144
Size II	Replacement Insert	N/A

FEATURES

Extrusion tools are used in a broad spectrum of applications from self tapping screws to cooling tube holders to air flow applications. Depending on the height of the form, the material, and many other factors, the success and design of the tools can vary.

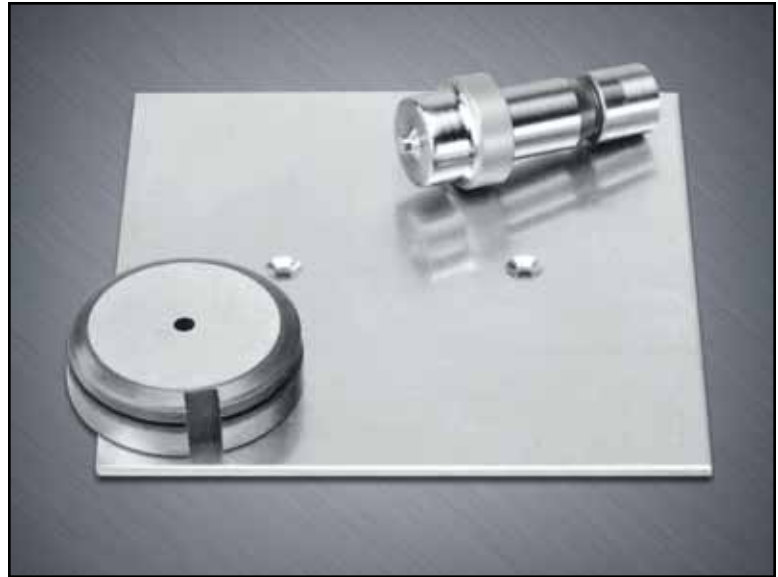
DESIGN CRITERIA

- Consult Sales Desk for size and height restrictions.
- All extrusions must form a minimum of two material thicknesses overall.
- All form-up extrusions must be pre-punched.
- The pre-punched hole controls the height.
- Extrusions are made for a specific material thickness and type.
- Tolerance required on I.D. Greater than .236" (6.0mm) "A" dimension.
- Never use thicker material than the extrusion was designed for.

INFORMATION NEEDED

- Machine and model number
- Material thickness and type
- Form-up or form-down
- I.D. and height or screw size and type (e.g. self tapping)

COINING COUNTERSINK/COUNTERBORE TOOLS FORM DOWN (SOLID STYLE)

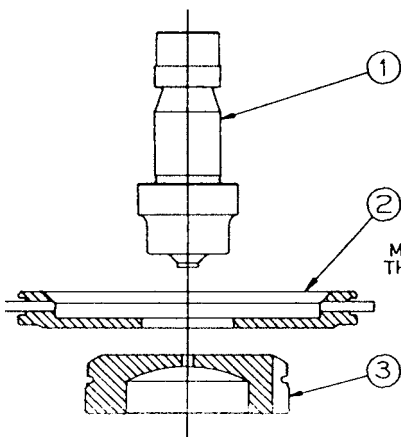


FORM DOWN	
Description	Cat. No.
Coining Tool (solid style punch)	25115
Counterbore tool (solid style punch)	25323

FEATURES

A Coining operation on the punch press is a money-saving operation which eliminates a secondary operation. In the case of countersinking, the time saved in punching versus drilling is substantial and results in a superior product.

COINING

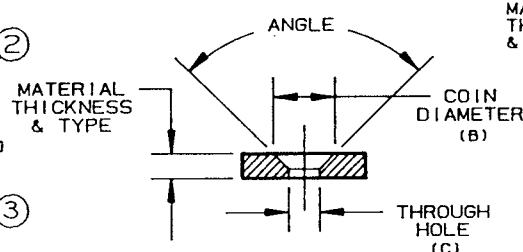


DESIGN CRITERIA

- Recommended for CSK coining above .125" (3.17mm) material thickness.
- All C/Bore coining must be Solid Style.
- Formula for estimated pre-punch of CSK coining: $B - [(B - C) \times .75] = \text{Pre-punch}$.
- Formula for estimated pre-punch of C/Bore coining:

$$\frac{(A \times B) + (C \times D)}{Z} = \text{Pre-punch}$$
- Aluminum will leave more of a burr on the bottom of the sheet than mild steel or stainless steel.

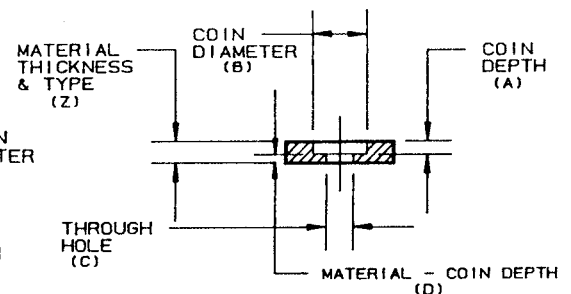
COUNTERSINK



INFORMATION NEEDED

- Machine and model number
- Material thickness and type
- Angle, coin diameter, coin depth or through hole, or screw size and head type
- With or without pilot

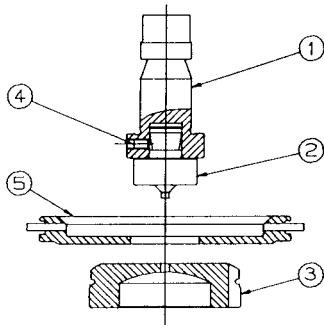
COUNTERBORE



COINING FORM-UP/FORM-DOWN (INSERT STYLE)

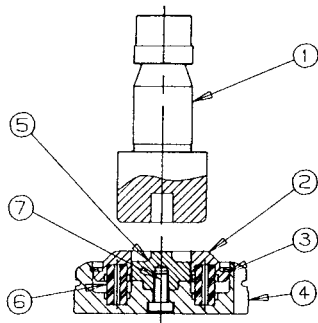
FORM-DOWN

Cat. No. 25331



FORM-UP

Cat. No. 25565



FORM-DOWN

Description

1. Insert Holder
2. Insert (with pilot)
Insert (without pilot)
3. Round Die
4. Screw (2 required)
5. Round Stripper
6. Complete Tool

FORM-UP

Description

1. Punch
2. Die Cap
3. Retaining Ring
4. Die Base
5. Insert (with pilot)
Insert (without pilot)
6. Springs
7. Screw
8. Complete Tool

FEATURES

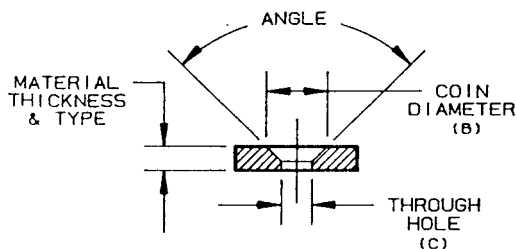
A Coining operation on the punch press is a money-saving operation which eliminates a secondary operation. In the case of countersinking, the time saved in punching versus drilling is substantial, as well as resulting in a superior product.

DESIGN CRITERIA

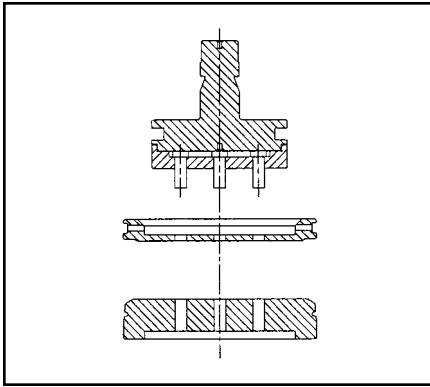
- .125" (3.17mm) maximum material thickness.
- Coining tool must always be pre-punched.
- Formula for estimated pre-punch hole size: $B - [(B - C) \times .75] = \text{Pre-punch}$.
- Aluminum will leave more of a burr on the bottom of the sheet than mild steel or stainless steel.

INFORMATION NEEDED

- Machine and model number
- Material thickness and type
- Angle, coin diameter and through hole, or screw size and head type
- With or without pilot
- Form-Up or Form-Down

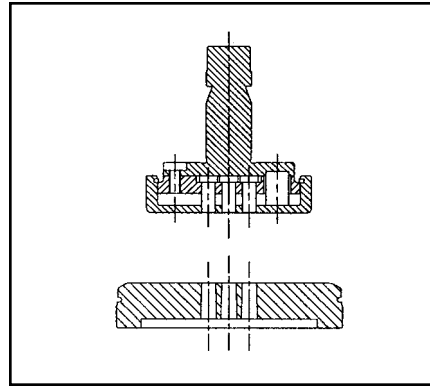


CLUSTER TOOL



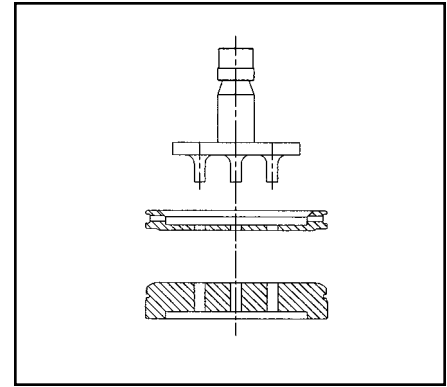
INSERT STYLE STANDARD STRIPPING

In this cluster design the punch tips are replaceable. This enables punch tips to be replaced economically. It also utilizes a standard stripper, which allows faster punching speeds in operation.



INSERT STYLE SELF STRIPPING

This is recommended for thin materials. The design is similar to the standard stripping style, utilizing insert punches for economic replacement, but with its close stripping system mounted directly onto the punch, it is ideally suited to be used with thin materials which pose problems with stripping.



SOLID PUNCH STYLE

This style is least popular even though it may be least expensive. If damage to one or more punch tips does occur, a complete replacement cluster punch must be supplied, rather than a single insert as with the insert styles.

FEATURES

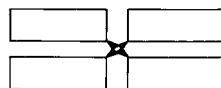
Clusters can be designed with as few as two holes or as many as 120 holes or more, depending on your application and design. Clusters are often the most cost efficient method to produce perforations or other repetitive applications.

The cluster will save on machine punching time and tool maintenance time. When punching a particular pattern of holes that require extremely close center tolerances, the cluster tool is the best choice. Putting these holes in the same cluster will eliminate the machine tolerancing of hole-to-hole punching.

Wilson Tool designs these clusters with the customer in mind. As you may notice in the different styles of clusters offered, we usually prefer to use replaceable inserts so that the operational costs of the tool are reduced for you. These clusters are precision machined and ground, not just milled.

LIMITATIONS

- Round holes must have a web between holes of .118 or 2 times material thickness, whichever is greater, to warranty the die.
- Long and narrow shapes must have a web between holes:
Up to .492" (12.50mm) length – .118" (3mm) min or 2 times material thickness, whichever is greater
.493" (12.50mm) to 1.000" (25.40mm) length – .157" (4mm) min or 2 times material, whichever is greater
1.001" (25.42mm) to 2.000" (50.80mm) length – .256" (6.50mm) min or 2 times material, whichever is greater
2.001" (51mm) – up length – .315" (8mm) min or 2 times material, whichever is greater



Cross-Stress

Note: Cannot follow above guidelines for warranty. Warranty to be determined per application.

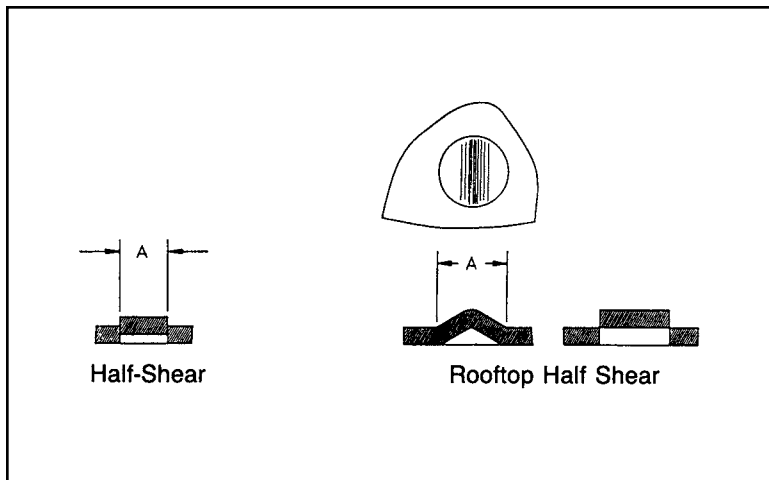
INFORMATION NEEDED

- Number of holes
- Straight or staggered pattern
- Center to center dimensions
- Material thickness and type
- Style desired
- Machine and model number

SHARPENING

- Small quill punches need to be supported while grinding. If not supported the vibrations caused by grinding will break the quills. Use rubberbands or a piece of punched plastic sheet to retard vibration.
- Always grind shaped punches the long way. Use vibration control methods.

HALF SHEAR AND ROOFTOP HALF SHEAR



FORM-UP HALF SHEAR	
Tool Type	Description
Size I	Half Shear
Size II	Half Shear
Size I to II	Rooftop Half Shear

FEATURES

The standard half shear, which is easy to use, allows you to put in shear buttons and spot welding locations to the accuracy of your punch press. Because of the round design it is an excellent locator for angular shearing.

The rooftop half shear is sometimes preferred because of its increased protrusion from the metal. This aids in picking up the locator on the sheet. The disadvantage to the shear stop is that you cannot use them for angular shearing.

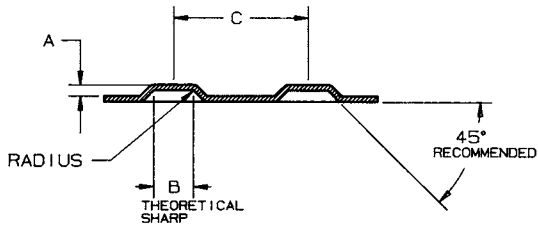
DESIGN CRITERIA

- Half shears work best in thicker material (more material to grab the button).
- On material thickness less than .047" (1.20mm) it is recommended a holding tab be put on the half shear to hold the button (similar to electrical knockout).
- Never punch material thicker than the tool was designed for.
- Group S machines require Size I half shear.

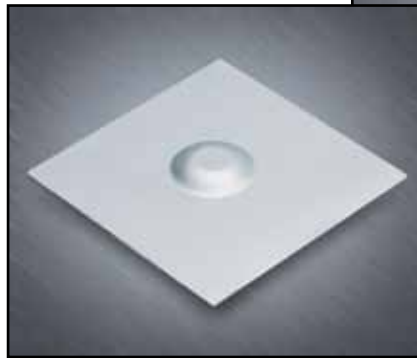
INFORMATION NEEDED

- Machine and model number
- Material thickness and type (or range)
- Diameter or shape (on top of sheet)

FORM-UP EMBOSS FORMING TOOLS



Specify C Dimension if more than one form exists on sheet



FORM-UP EMBOSS

Tool Type	Description	Cat. No.
Size I	With Stripping	25176
Size I	Without Stripping	25194
Size II	With Stripping	25195
Size II	Without Stripping	25143

FEATURES

These emboss style forming tools are useful for stand offs, spacers, large countersinks, and locking for nuts. With our variety of expertise in design, we can tailor the correct tool for your application.

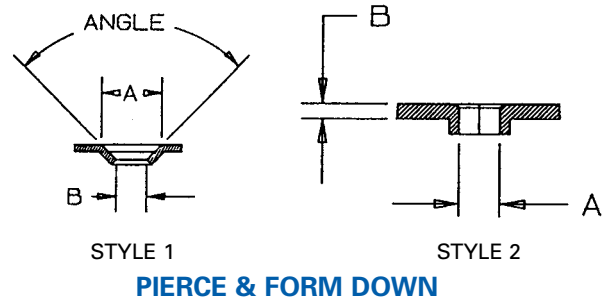
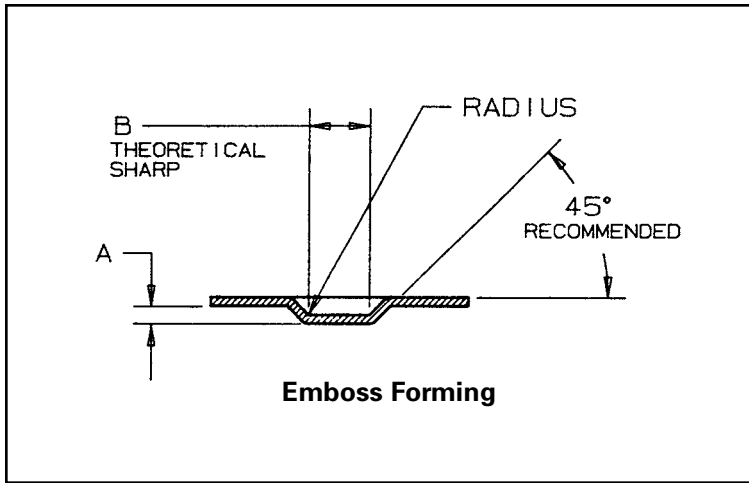
DESIGN CRITERIA

- Keep forming tools as far from clamps and pierced holes as possible.
- If you are having stripping problems or your form is not coming out, make sure you are "bottoming out."
- A ring mark around the form indicates stroking too deep.
- A 45° angle is recommended on forming tools.
- For maximum size in different stations consult sales desk.
- Never punch material thicker than the tool was designed for.

INFORMATION NEEDED

- Machine and model number
- Material thickness
- Drawing if possible
- Full dimensioning (height, dia. or shape, angle, radius, thru hole, etc.)
- Dimensions preferred to a theoretical sharp

FORM-DOWN FORMING TOOLS



FORM-DOWN EMBOSS		
Tool Type	Description	Cat. No.
Size I	Without Stripping	
Size II	Without Stripping	25174
Size II	With Stripping	25191

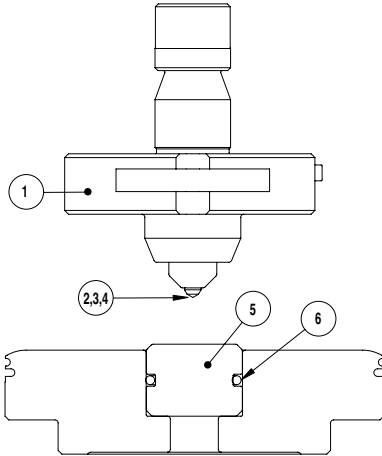
DESIGN CRITERIA

- May be possible to pierce and form in one operation (consult Sales Desk with your application).

INFORMATION NEEDED

- Machine and model number
- Material thickness
- Drawing if possible
- Full dimensioning of form
- Dimensions preferred to a theoretical sharp

MULTI-SCRIBE



TRUMPF SIZE 2 MULTI-SCRIBE

Description	Cat. No.	Price
1 Trumpf Multi-Scribe Kit (includes all inserts)	26210	
2 Carbide Insert	13563	
3 120° Diamond Insert	13564	
4 150° Diamond Insert	13565	
5 Plastic Scribe Die Insert	12689	
6 O-Ring (1" O.D. X 3/32)	2282	

FEATURES

The Wilson Multi-Scribe™ sheet marking tool is ideal for an unlimited range of sheet marking applications. Multi-Scribe can be used for both sheet scribing and dot-matrix marking on a wide range of materials, eliminating the need to change tools every time you need to make a different mark.

A long-lasting diamond tip and variable scribe depth ensures the accuracy of marks from logos to serial numbers. The unique design also allows for consistent mark depth even when surface variations occur

The Wilson Multi-Scribe will not deform the material or mark the underside of the sheet.

DESIGN CRITERIA

- The tool uses spring loaded diamond tip inserts to create scribe, or drag mark on the sheet (120° or 150°).
- An optional carbide insert is available to be used as a dot-matrix tool for sheet metal.
- Spring selection will vary depending on your application, ram adjustment, marking speed and the type of material to be marked.

INFORMATION NEEDED

- Machine and model number
- Material thickness



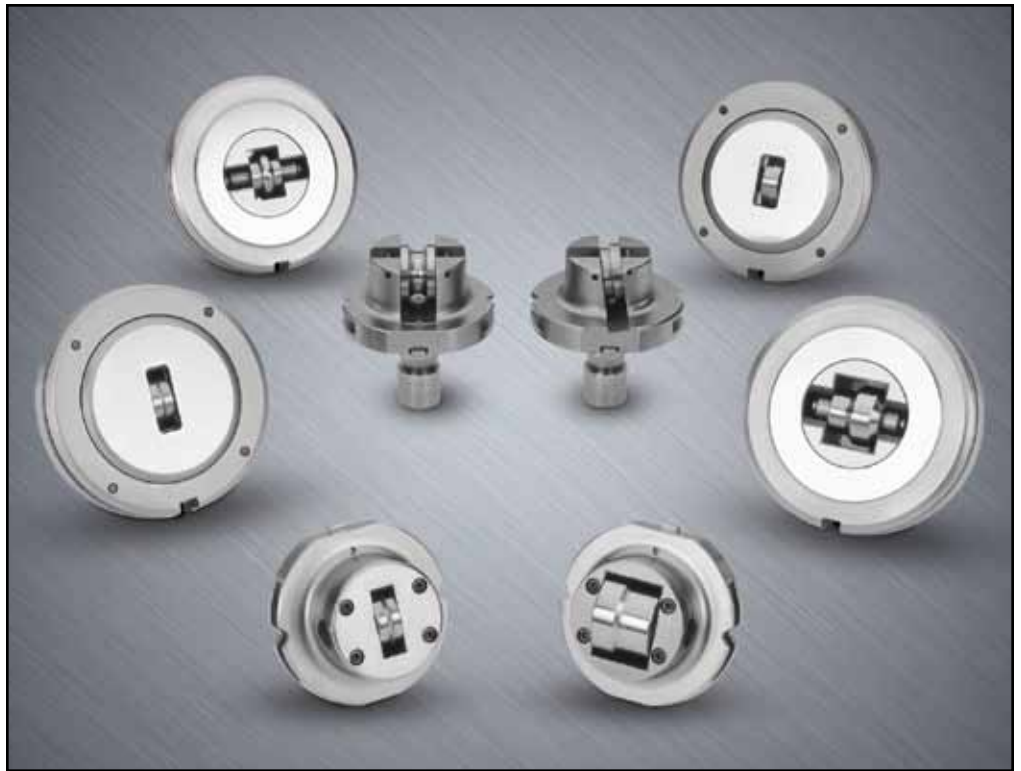
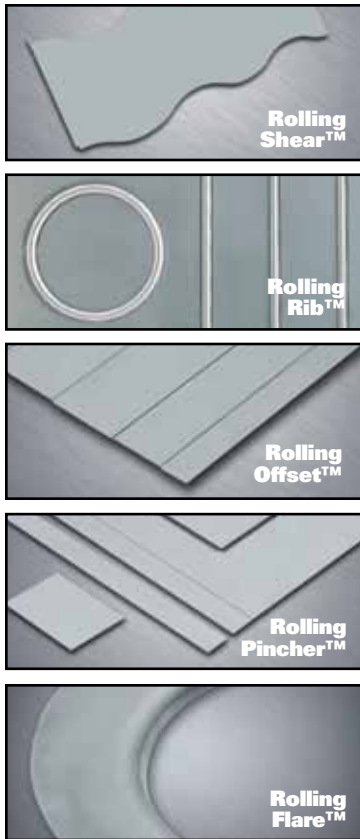
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salesdesk@wilsontool.com

WILSON WHEEL® FAMILY



FEATURES

The Wilson Wheel family of products offers fabricators flexible, high-speed production of flares, slits, ribs and offsets on a wide range of materials with virtually no burrs or nibble marks.

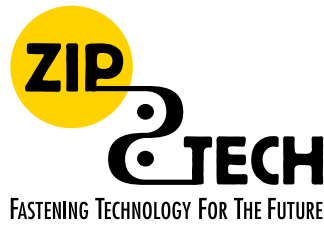
DESIGN CRITERIA

- A programmable ram is required to use these wheel tools.
- Consult the sales desk for machine specific requirements.
- Consult sales desk for minimum radius of each tool.
- Can be used on Pullmax machines and some others - please consult sales desk.

INFORMATION NEEDED

- Machine model
- Material thickness and type

ZIP-TECH™ SPECIAL LANCE & FORM TOOLS



ZIP-TECH		
Tool Type	Description	Cat. No.
Size II	Zip-Tech Tool P&D Assy Complete Set	N/A
Size II	Zip-Tech Punch Assy (no holder) with Die Assy	N/A

FEATURES

Wilson Tool knows that welding and grinding operations along with spot welding and other fastening methods are time consuming and labor intensive.

With the Zip-Tech lance and form from Wilson Tool, fabricators can create snaps that join the metal parts together in an instant.

DESIGN CRITERIA

- Two special tools are required. One is a simple "T" shape to punch around the full radius tabs. The second is a special Lance and Form/Up with Half-Shear Down (see above). Both tools need to be used with a Rotation machine.
- A standard round tool is also required .080 Diameter (2.04mm).
- The special Lance Tool is material specific. A separate tool is needed for each material thickness.
- Consult Sales Desk for limitations.
- The holding strength of this fastening method can be difficult to determine and depends on the condition of the tool and the machine. It is similar to the same strength that you would have in a spot weld.

INFORMATION NEEDED

- Machine model
- Material thickness and type

ORDER

Minimum order is \$50.00.

CREDIT REQUIREMENTS

All orders are subject to approval by our Credit Department. If you are a new account, please furnish us with your tax exempt status, a bank reference, three current supplier references and/or your current D&B rating with your first order. A credit limit will be imposed on new accounts until credit has been established.

PAYMENT TERMS

Terms are net 10 days. Catalog prices are subject to change without notice.

FREIGHT

Orders are shipped F.O.B. from our manufacturing facility. (International Shipments are Incoterms: Ex Works).

ORDER CANCELLATION

In the event an order is cancelled, an additional charge will be assessed to cover the cost of labor and material.

RETURNED MATERIAL

A handling/restocking fee will be applied to all standard products returned for credit. A return authorization number and shipping instructions must be obtained in advance before an item can be returned.

CLAIMS

All claims or product shortages must be made within 30 days of the invoice date.

PRECISION TOOLING. UNBEATABLE PERFORMANCE.

For more than 40 years, Wilson Tool International® has provided industry-leading tooling solutions that enhance the performance of sheet metal fabricators and stampers worldwide.

The three divisions of Wilson Tool – Punching, Press Brake, and Stamping – represent the most comprehensive line of tooling systems and accessories available. Our ability to consistently provide innovative, high quality products that outlast and outperform the competition is why the world's most successful fabricators rely upon Wilson Tool tooling systems.

A knowledgeable global sales force, multilingual customer support staff, same-day shipping and extensive distribution network are just a few of the benefits that keep our customers coming back time and again.



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