

REDUCE UNWANTED SHEET MARKING

Wilson Tool International offers numerous solutions to help press brake operators reduce or eliminate sheet marking during bending operations. Urethane dies, holders, pads and drapes form a protective barrier that impedes the metal-on-metal scraping that often happens during bending. The protective fabric drape is a lightweight and flexible alternative to urethane that also provides a barrier to prevent scratching. V-series dies use a rotating action that causes much less friction than typical V dies, resulting in reduced part marking.

Urethane products available from Wilson Tool include:

- **Urethane Dies**

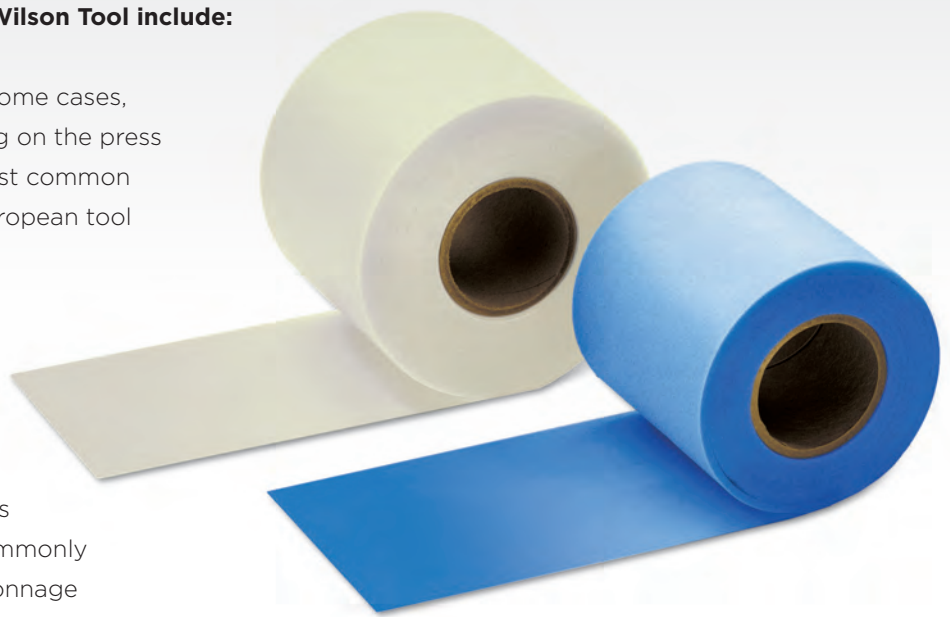
These dies greatly reduce and, in some cases, completely eliminate sheet marking on the press brake. They are available in the most common profiles from the American and European tool style collections.

- **Urethane Holders and Pads**

Wilson Tool's urethane holders are manufactured from 6061-T6 aluminum and hold a pad of urethane for mark free and radius bending. Two pad hardness options are available: Blue/90A is most commonly used and Red/80A helps reduce tonnage in the application by approximately 20%.

- **Protective Coverings**

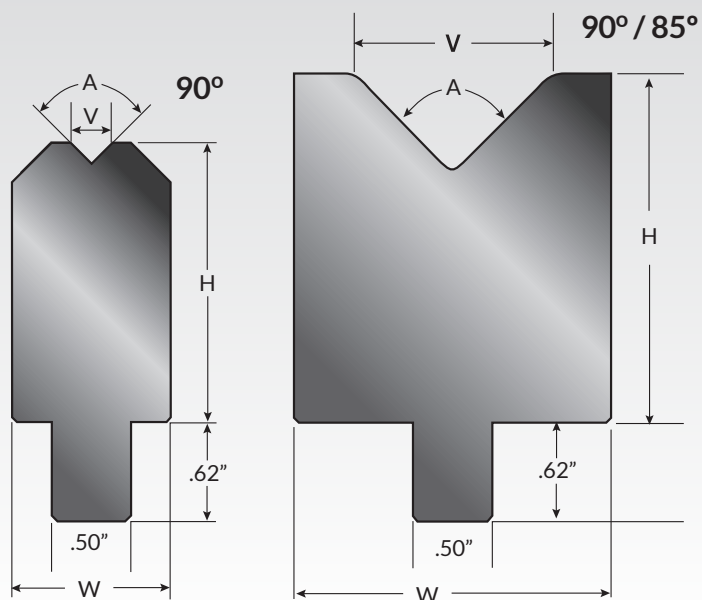
Urethane drapes provide a protective layer across the top of your standard dies to virtually eliminate sheet marking. Our standard roll of urethane is offered in two thicknesses (.015" and .030") to fit your application. Our high density urethane offering is .022" thick, lasting significantly longer than standard urethane.



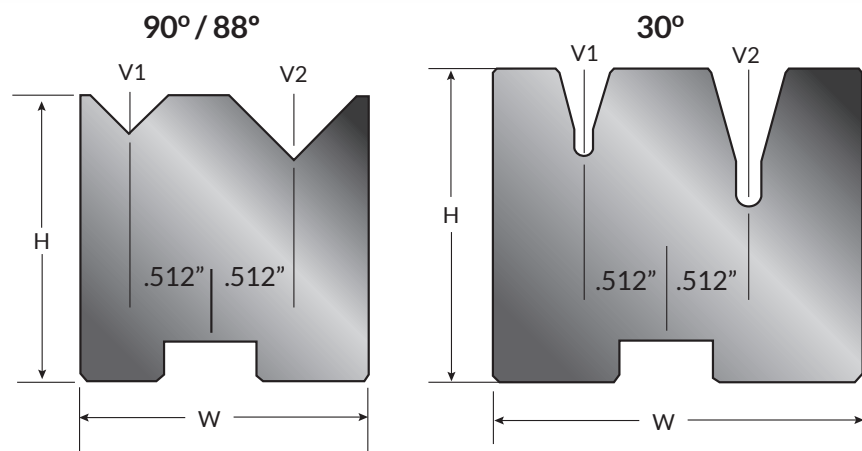
URETHANE DRAPES			
CAT. NO.	DESCRIPTION	DIMENSIONS	COLOR
42530	Standard	.015" [.4mm] x 6" [152mm]	White
42531	Standard	.03" [.8mm] x 6" [152mm]	White
42532	High Density	.022" [.6mm] x 6" [152mm]	Blue

See the back page for Wilson Tool's easy to use Protective Fabric Drape option.

URETHANE DIES



AMERICAN STYLE DIE					
CAT. NO.	ANGLE	V	H	W	LENGTHS
50031u	90°	.25"	1.75"	1.25"	48" 96"
50032u		.37"	1.75"	1.25"	
50033u		.50"	1.75"	1.25"	
50034u		.62"	1.75"	1.75"	
50035u		.75"	1.75"	1.75"	
50036u		.87"	1.87"	1.75"	
50037u		1.0"	1.87"	1.75"	
50018u	85°	2.0"	2.25"	3.00"	
50020u	30°	.25"	1.75"	1.25"	
50021u		.37"	1.75"	1.25"	
50022u		.50"	1.75"	1.25"	
50023u		.62"	1.87"	1.75"	

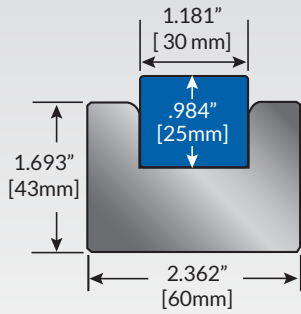


When selecting a V-opening, a minimum of 10x material thickness should be chosen when working with mild steel with a tensile strength of 60,000 PSI.

All dies have standard European die slots: 15.05mm [.61"] wide x 6.5mm [.26"] deep.

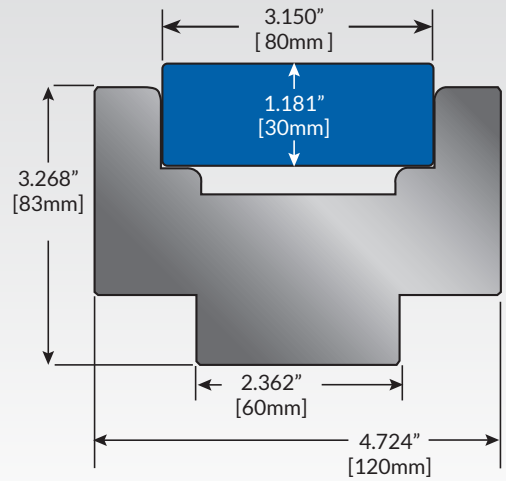
EUROPEAN STYLE QUICK CHANGE 2V DIE							
CAT. NO.	ANGLE	V1	V2	H	W	LENGTHS	
						S	L
4201UE	90°	6mm [.24"]	10mm [.39"]	46mm [1.81"]	50mm [1.96"]	415mm [16.3"]	835mm [32.8"]
42002UE		8mm [.32"]	12mm [.47"]		50mm [1.96"]		
42004UE	88°	14mm [.55"]	18mm [.71"]		60mm [2.36"]		
42005UE		12mm [.47"]	20mm [.79"]		60mm [2.36"]		
42006UE		16mm [.63"]	25mm [.98"]	60mm [2.36"]			
42021UE	30°	8mm [.32"]	12mm [.47"]	50mm [1.96"]	60mm [2.36"]		

URETHANE HOLDERS AND PADS

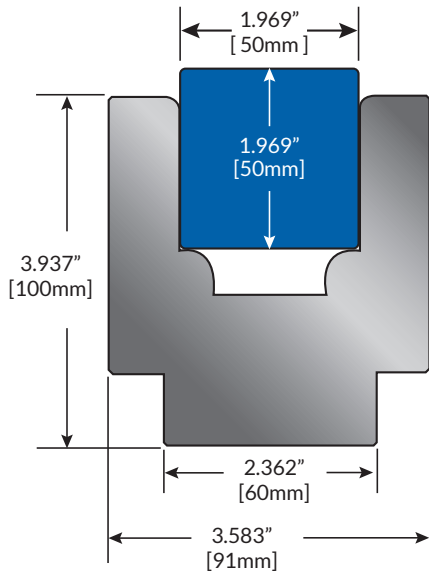


CAT. NO.	DESCRIPTION
42501	Urethane Holder L & S
42511	Urethane Pad 80A/Red
42521	Urethane Pad 90A/Blue

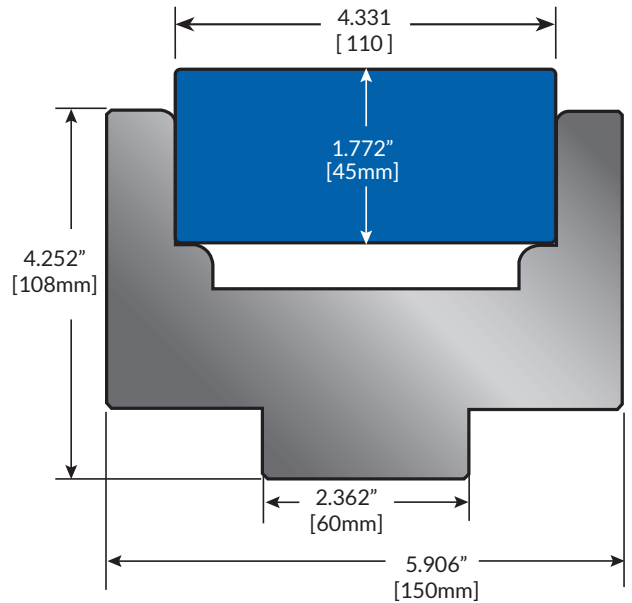
Note: All urethane die holders are machined from 6061-T6 aluminum. Urethane holders may require die holder #43040. Check height against machine stroke prior to ordering.



CAT. NO.	DESCRIPTION
42503	Urethane Holder L & S
42513	Urethane Pad 80A/Red
42523	Urethane Pad 90A/Blue



CAT. NO.	DESCRIPTION
42502	Urethane Holder L & S
42512	Urethane Pad 80A/Red
42522	Urethane Pad 90A/Blue



CAT. NO.	DESCRIPTION
42504	Urethane Holder L & S
42514	Urethane Pad 80A/Red
42524	Urethane Pad 90A/Blue

V-SERIES DIES

Wilson Tool International's V-Series press brake dies incorporate rotating inserts to decrease friction and to enable better performance on tough-to-bend applications with holes and cut outs close to the bend line. The Wilson V-Series is available for virtually all major styles of press brake tooling.

Reduced Friction

Wilson Tool V-Series dies include built-in blades that rotate so there is minimal lateral movement between the sheet and the die. This reduction in movement decreases the friction between the die and the sheet which helps to minimize sheet marking.



PROTECTIVE FABRIC DRAPE

Long-life, Coated Fabric

This fabric drape forms a protective barrier between the sheet metal and the die shoulders during the bending process.

- **Durable** — highly resistant to fraying, cutting and splitting, ensuring many hours of mark-free parts.
- **Requires less frequent repositioning** than other traditional methods.
- **Bending angle consistency** — because of its reduced thickness and resistance to degrading, the repeatability of the bend angle remains consistent.
- **Ease of use** — being only 0.3mm [.012"] thick, the fabric is easy to position on the die and requires no complicated holding fixtures.

PROTECTIVE FABRIC DRAPE	
CAT. NO.	DESCRIPTION
55335	12.5m [41'] length x 120mm [4.7"] width
55337	12.5m [41'] length x 240mm [9.5"] width
987041	3/8" x 1/2" Cylinder Magnet



For more information, visit wilsontool.com, call our tooling technicians at 800-445-4518 or contact your Sales Engineer.

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