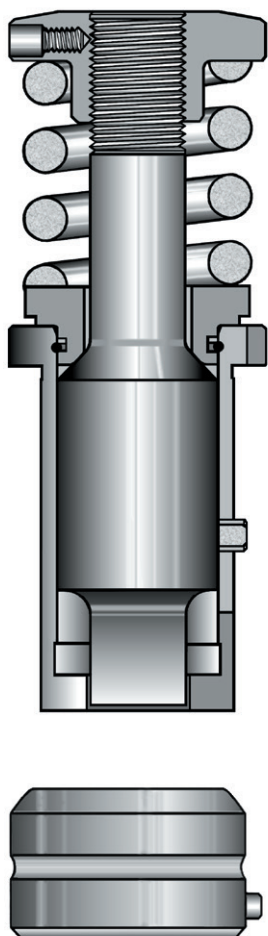


WILSON FAB TOOLING FOR THIN TURRET STRIPPIT



SOLUTIONS FOR PUNCH PRESS TOOLING

Basix B Station	4
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DESCRIPTION	CAT. NO.	PRICE
PUNCH & GUIDE ASSEMBLY		
Round	149	
Shape	164	
Optima® Coating	-	
PUNCHES		
Round	148	
Shape	161	
Optima® Coating	-	
GUIDES		
Round	147	
Shape	159	
DIES		
Round Standard	133	
Round Slug Hugger®	454	
Shape Positive	162	
Shape Negative	244	
Shape Slug Hugger® 2*	10373	

PUNCH SHIMS			
Station	Qty.	Cat. No.	Price
1.5mm Thick			
B	1	152	
B	25	98	
DIE SHIMS			
Station	Qty.	Cat. No.	Price
25mm Thick			
B	1	2097	
B	25	2209	
76mm Thick			
B	1	2723	
B	25	2724	
1.5mm Thick			
B	1	2100	
B	25	2173	

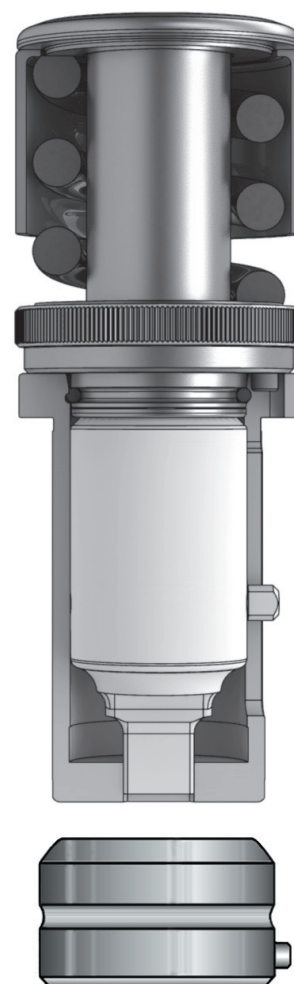
NOTES:

*Slug Hugger® dies must be ordered punch size plus clearance. Size restrictions apply.

Additional charges may apply to non-standard features. See page 9.

DESCRIPTION	CAT. NO.	PRICE
PUNCH & GUIDE ASSEMBLY		
Round	10662	
Shape	10663	
Optima® Coating	-	
PUNCHES		
**Pinned Round	10457	
Shape	161	
Optima® Coating	-	
GUIDES		
Round	158	
Shape	159	
DIES		
Round Standard	133	
Round Slug Hugger®	454	
Shape Positive	162	
Shape Negative	244	
Shape Slug Hugger® 2*	10373	

DIE SHIMS			
Sta- tion	Qty.	Cat. No.	Price
25mm Thick			
B	1	2097	
B	25	2209	
76mm Thick			
B	1	2723	
B	25	2724	
1.5mm Thick			
B	1	2100	
B	25	2173	

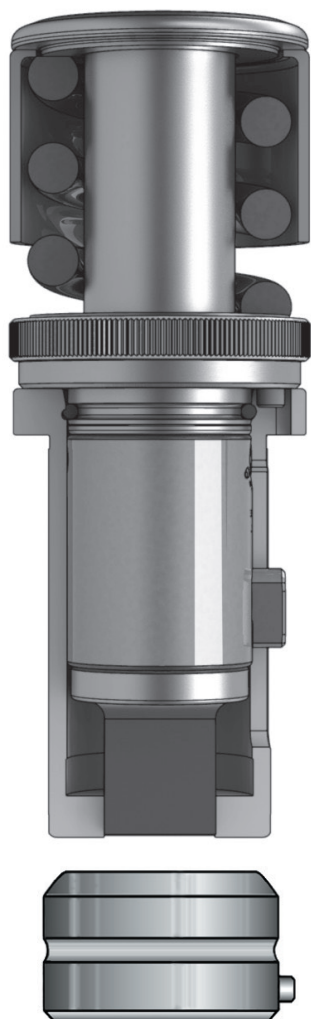


NOTES:

*Slug Hugger® dies must be ordered punch size plus clearance. Size restrictions apply.

**HP2 assembly requires a pinned round punch. This is the replacement punch for Quick Adjust Assemblies

Additional charges may apply to non-standard features. See page 9.



EXP PUNCH HOLDER

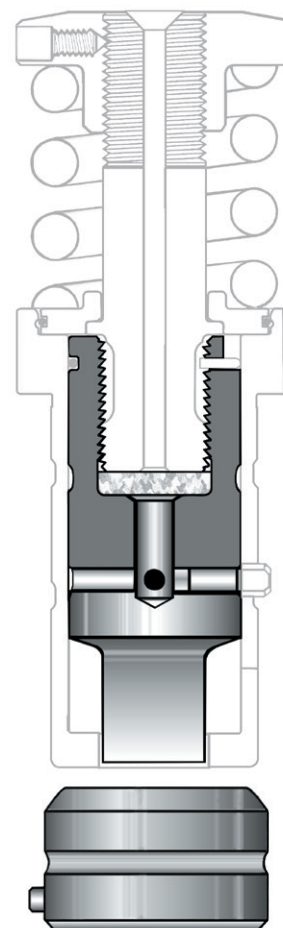
DESCRIPTION	CAT. NO.	PRICE
PUNCH & GUIDE ASSEMBLY		
Round	10661	
Shape	10660	
EXP PUNCH HOLDER only	10627	
PUNCHES		
EXP Round	13916	
EXP Shape	13917	
Optima® Coating	-	
GUIDES		
Round	158	
Shape	159	
DIES		
Round Standard	133	
Round Slug Hugger®	454	
Shape Positive	162	
Shape Negative	244	
Shape Slug Hugger ® 2*	10373	

NOTES:

*Slug Hugger® dies must be ordered punch size plus clearance. Size restrictions apply.

Additional charges may apply to non-standard features. See page 9.

DIE SHIMS			
Station	Qty.	Cat. No.	Price
25mm Thick			
B	1	2097	
B	25	2209	
76mm Thick			
B	1	2723	
B	25	2724	
1.5mm Thick			
B	1	2100	
B	25	2173	



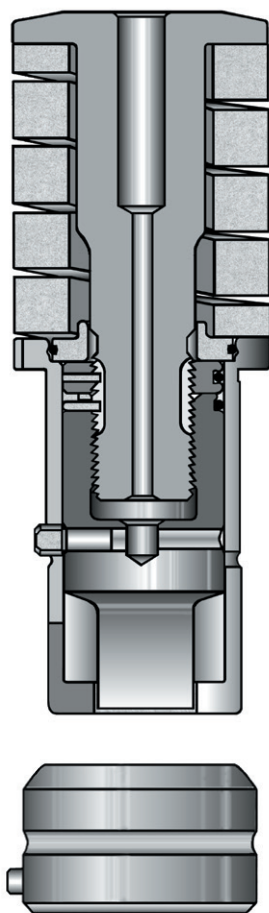
DESCRIPTION	CAT. NO.	PRICE
PUNCHES		
Round	10137	
Shape	10136	
Optima® Coating	-	
GUIDES		
Round	10144	
Shape	10139	
DIES		
Round Standard	133	
Round Slug Hugger®	454	
Shape Positive	162	
Shape Negative	244	
Shape Slug Hugger® 2*	10373	

DIE SHIMS			
Station	Qty.	Cat. No.	Price
25mm Thick			
B	1	2097	
B	25	2209	
76mm Thick			
B	1	2723	
B	25	2724	
1.5mm Thick			
B	1	2100	
B	25	2173	

NOTES:

*Slug Hugger® dies must be ordered punch size plus clearance. Size restrictions apply.

Additional charges may apply to non-standard features. See page 9.



NOTES:

HP Heavy Duty : Spherical concave shear & Optima standard on 25.4mm, 25mm, and 31.75mm diameters.

Maximum material thickness 9.5mm mild steel.

Full size (B Station body) : Urethane spring assemblies available upon request.

*Slug Hugger® dies must be ordered punch size plus clearance. Size restrictions apply.

Additional charges may apply to non-standard features. See page 9.

DESCRIPTION	CAT. NO.	PRICE
PUNCH & GUIDE ASSEMBLY		
Round	10039	
Shape	10040	
Optima® Coating	-	
PUNCHES		
Round	10046	
Shape	10045	
Optima® Coating	-	
GUIDES		
Round	10027	
Shape	10020	
DIES		
Round Standard	133	
Round Slug Hugger®	454	
Shape Positive	162	
Shape Negative	244	
Shape Slug Hugger® 2*	10373	

DIE SHIMS			
Station	Qty.	Cat. No.	Price
25mm Thick			
B	1	2097	
B	25	2209	
76mm Thick			
B	1	2723	
B	25	2724	
1.5mm Thick			
B	1	2100	
B	25	2173	

ADD ON CHARGES FOR NON-STANDARD FEATURES

B Station Add Ons			
Add ons for Rounds			
Small Diameter 0.79 - 1.50mm Clearance < 0.10mm	Punch	Die	Stripper N/C N/C
Add ons for Shapes			
Small Width 0.79 - 1.0mm Clearance < 0.10mm	Punch	Die	Stripper N/C

C Station Add Ons			
Add ons for Rounds			
Small Diameter 25.4mm Clearance < 0.10mm	Punch	Die N/C	Stripper N/C N/C
Add ons for Shapes			
Small Width 0.79 - 1.0mm	Punch	Die	Stripper
Small 'A' Dimension 29.21mm Clearance < 0.10mm		N/C	N/C N/C

D Station Add Ons			
Add ons for Rounds			
Small Diameter < 25.4mm Clearance < 0.10mm	Punch	Die N/C	Stripper N/C N/C
Add ons for Shapes			
Small Width 0.79 - 1.0mm	Punch	Die	Stripper
Small 'A' Dimension < 29.21mm Clearance < 0.10mm			N/C N/C

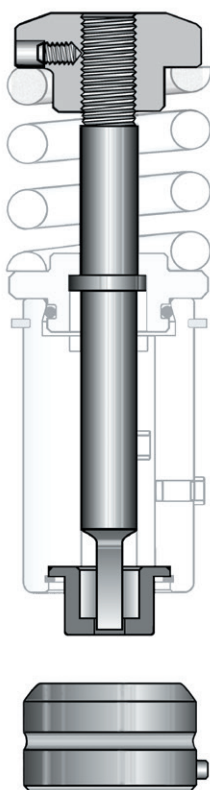
NOTES:

- Add to round or shape punch for extra straight before radius, extra back taper, or no back taper.

'A' Dimension = Longest distance across shape.

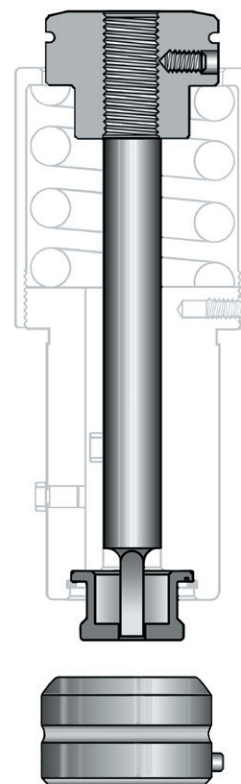
SNAP APART A STATION

SNAP APART A STATION BODY



DROP IN A STATION

A STATION DROP IN



DESCRIPTION	CAT. NO.	PRICE
PUNCHES		
Round	195	
Shape	333	
Optima® Coating	-	
STRIPPERS		
Round	478	
Shape	337	
DIES		
Round Standard	133	
Round Slug Hugger®	454	
Shape Positive	162	
Shape Negative	244	
Shape Slug Hugger® 2*	10373	

NOTES:

*Slug Hugger® dies must be ordered punch size plus clearance. Size restrictions apply.

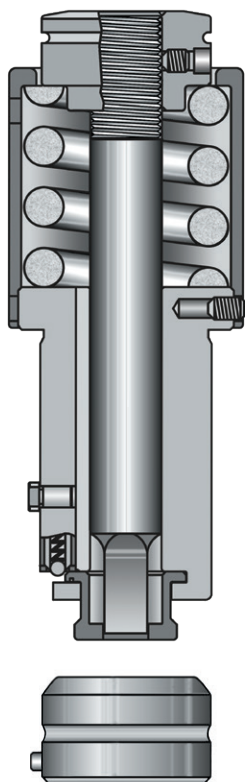
Additional charges may apply to non-standard features. See page 9.

DIE SHIMS			
Sta- tion	Qty.	Cat. No.	Price
25mm Thick			
B	1	2097	
B	25	2209	
76mm Thick			
B	1	2723	
B	25	2724	
1.5mm Thick			
B	1	2100	
B	25	2173	

DESCRIPTION	CAT. NO.	PRICE
PUNCHES		
Round	451	
Shape	450	
Optima® Coating	-	
STRIPPERS		
Round	478	
Shape	337	
DIES		
Round Standard	133	
Round Slug Hugger®	454	
Shape Positive	162	
Shape Negative	244	
Shape Slug Hugger® 2*	10373	
TO FIT STRIPPIT'S HOLDER		
Punch Head - New Style	448	
Stripper - Round	474	
Stripper - Shape Fitted	473	

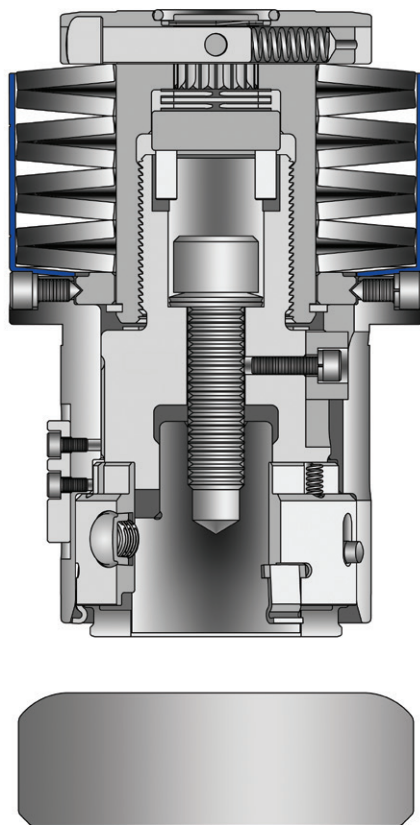
DROP IN A STATION

5/8 STATION DROP IN



DESCRIPTION	CAT. NO.	PRICE
GUIDE ASSEMBLY w/15.88mm dia. Closed Round Stripper Plate	476	
PUNCHES Round	445	
Shape	446	
Optima® Coating	-	
STRIPPERS Round	478	
Shape	479	
DIES Round Standard	133	
Round Slug Hugger®	454	
Shape Positive	162	
Shape Negative	244	
Shape Slug Hugger® 2*	10373	
TO FIT STRIPPIT'S HOLDER Punch Head - Old Style	444	
Punch Head - New Style	475	
Stripper - Round	474	
Stripper - Shape Fitted	473	

DIE SHIMS			
Sta- tion	Qty.	Cat. No.	Price
25mm Thick			
B	1	2097	
B	25	2209	
76mm Thick			
B	1	2723	
B	25	2724	
1.5mm Thick			
B	1	2100	
B	25	2173	



DESCRIPTION	CAT. NO.	PRICE
GUIDE ASSEMBLY	10530	
PUNCHES		
Round	10568	
Shape	10567	
Optima® Coating	-	
STRIPPERS		
Round	10534	
Shape	10535	
DIES		
Round Standard	10544	
Round Slug Hugger®	10545	
Shape Positive	10546	
Shape Negative	10547	
Shape Slug Hugger® 2*	10548	

DIE SHIMS			
Station	Qty.	Cat. No.	Price
25mm Thick			
C	1	2089	
C	25	2210	
76mm Thick			
C	1	2725	
C	25	2726	
1.5mm Thick			
C	1	2092	
C	25	2174	

NOTES:

HP Guide Assemblies are keyed for shapes at 0°, 45°, 90°, 180°, 225°, 270°.

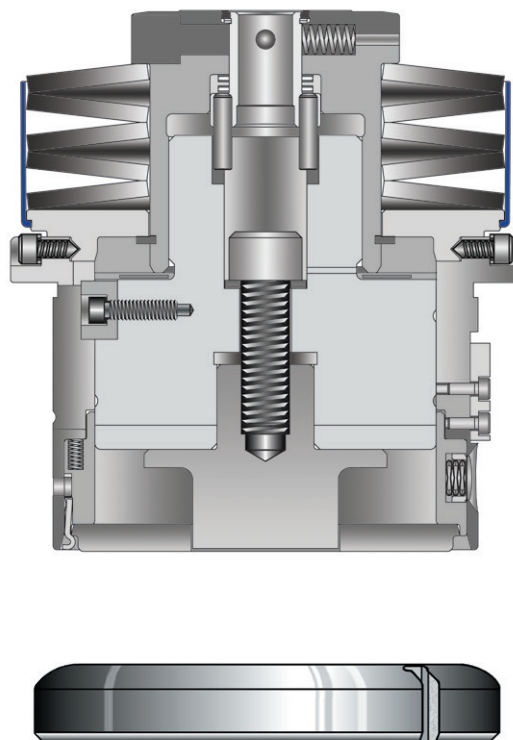
All punches will be shipped with no shear unless specified.

Square dies are keyed for shape at 0° and 45°, all other shaped dies are keyed for shape at 0° and 90°.

*Slug Hugger® dies must be ordered punch size plus clearance. Size restrictions apply.

Additional charges may apply to non-standard features. See page 9.

DESCRIPTION	CAT. NO.	PRICE
GUIDE ASSEMBLY	10436	
PUNCHES		
Round		
31.75-39.67mm Dia.	181	
39.70-57.15mm Dia.**	183	
57.17-73.03mm Dia.**	184	
73.05-88.90mm Dia.**	185	
Punch Retainer	182	
Shape		
31.75-38.10mm 'A' Dim.	188	
38.12-63.50mm 'A' Dim.	189	
63.52-88.90mm 'A' Dim.	190	
Optima® Coating	-	
STRIPPERS		
Round	186	
Shape	192	
DIES		
Round Standard	187	
Round Slug Hugger®	459	
Shape Positive	212	
Shape Negative	251	
Shape Slug Hugger® 2*	10381	
Heavy Duty Dies Available	-	



NOTES:

HP Guide Assemblies are keyed for shapes at 0°, 45°, 90°, 180°, 225°, 270°.

0.79mm Rooftop shear is given to all punches with 'A' dimension greater than 50.8mm and width greater than 6.35mm at no extra charge.

'A' dimension = longest distance across shape.

All punches 6.35mm and under in width will be shipped with no shear unless specified.

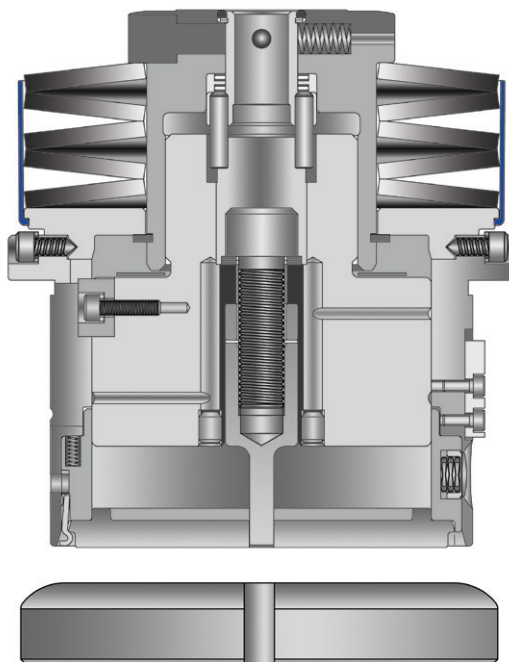
Square dies are keyed for shape at 0° and 45°, all other shaped dies are keyed for shape at 0° and 90°.

*Slug Hugger® dies must be ordered punch size plus clearance. Size restrictions apply.

** Punch retainer required.

Additional charges may apply to non-standard features. See page 9.

DIE SHIMS			
Station	Qty.	Cat. No.	Price
25mm Thick			
D	1	2081	
D	25	2211	
76mm Thick			
D	1	2727	
D	25	2728	
1.5mm Thick			
D	1	2084	
D	25	2175	



DESCRIPTION	CAT. NO.	PRICE
GUIDE ASSEMBLY	10516	
PUNCHES		
Blade	10520	
Optima® Coating	-	
STRIPPERS		
Shape	367	
DIES		
Shape Positive	212	
Shape Negative	251	
Shape Slug Hugger® 2*	10381	
Shape Positive - Heavy Duty	213	
Shape Negative - Heavy Duty	252	
Shape Slug Hugger® 2* - Heavy Duty	10382	

DIE SHIMS			
Station	Qty.	Cat. No.	Price
25mm Thick			
D	1	2081	
D	25	2211	
76mm Thick			
D	1	2727	
D	25	2728	
1.5mm Thick			
D	1	2084	
D	25	2175	

NOTES:

HP Dura-Blade® Guide Assemblies are keyed for shapes at 0°, 45°, 90°.

Maximum width for blade insert is 19.05mm.

*Slug Hugger® dies must be ordered punch size plus clearance.

Size restrictions apply.

Maximum 'A' dimension = 88.9mm.

'A' dimension = longest distance across shape.

Additional charges may apply to non-standard features.
See page 9.

D Station Notcher

(For Series 80® Plus and Series 90® Guide Assemblies)

DESCRIPTION	CAT. NO.	PRICE
PUNCHES		
50.8mm or 50mm square	449	
NOTCHER STRIPPER PLATE	367	
DIES		
Slug Hugger® 2*	10381	
Positive	212	
Negative	251	

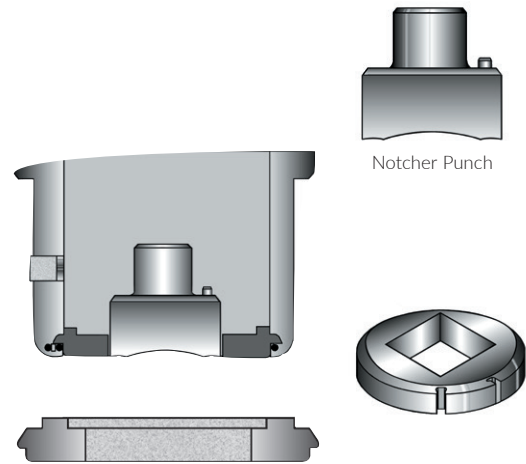
NOTES:

Square dies are keyed for shape at 0° and 45°.

Optima® standard on all Notcher punches.

Includes 1.6mm dbl. concave shear.

*Slug Hugger® dies must be ordered punch size plus clearance.
Size restrictions apply.



Universal Notcher Station

(For Stripit® Universal Notch Guide Assemblies)

DESCRIPTION	CAT. NO.	PRICE
PUNCHES		
Round	238	
Standard Square	215	
25.4mm square		
38.10mm square		
50.80mm square		
50mm square		
Non-standard Square	239	
STRIPPING GUIDE		
Round	278	
Shape	279	
DIES		
Round Slug Hugger® 2*	10597	
Round Standard	187	
Shape Slug Hugger® 2*	10381	
Shape Positive	212	
Shape Negative	251	

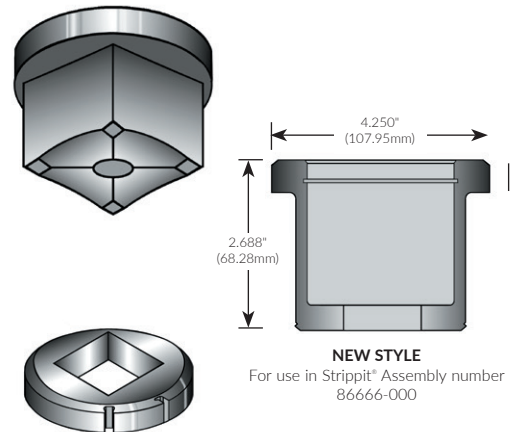
NOTES:

All square dies are keyed for shape at 0° and 45°.

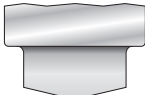
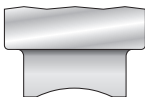
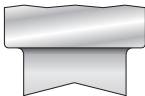
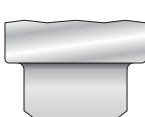
Optima® standard on all Universal Notcher punches.

Additional charge for flat punch.

*Slug Hugger® dies must be ordered punch size plus clearance.
Size restrictions apply.



SHEAR OPTIONS

Type of Shear	Benefit	Limitation
 Rooftop	Best shear for punching at maximum tonnages.	When nibbling, bite must be 75% of punch dimension or excessive side loading will result.
 Concave or Double Concave	Best shear for nibbling because it inverts stresses.	The punch is less resistant to breakage when punching at high tonnages because of inverted stresses.
 Inverted Rooftop	Also good shear for nibbling because it inverts stresses.	More susceptible to breakage because of a sharp focal point for stresses—use great care.
 Double Valley Shear	Best shear for nibbling when shape is long and narrow.	The punch is less resistant to breakage when punching at high tonnages because of inverted stresses.
 JK Shear	A special punch tip shear that allows you to punch high strength materials with a reduced risk of breakage.	Can only be used on punches up to 25.4mm diameter or 'A' dimension†.

SPECIAL SHEARS					
Station	'A' Dimensions†	Inverted Rooftop Single Concave		Double Valley Double Concave	
		1.6mm Shear	2.4mm Shear	1.6mm Shear	3.2mm Shear
B	Within 31.75mm		N/A		N/A
C	Within 50.8mm		N/A		
D	Within 88.9mm		N/A		

0.79mm rooftop shear is given to all punches with 'A' dimension† greater than 50.8mm and width greater than 6.35mm at no extra charge.

All punches 6.35mm and under in width will be shipped with no shear unless specified.

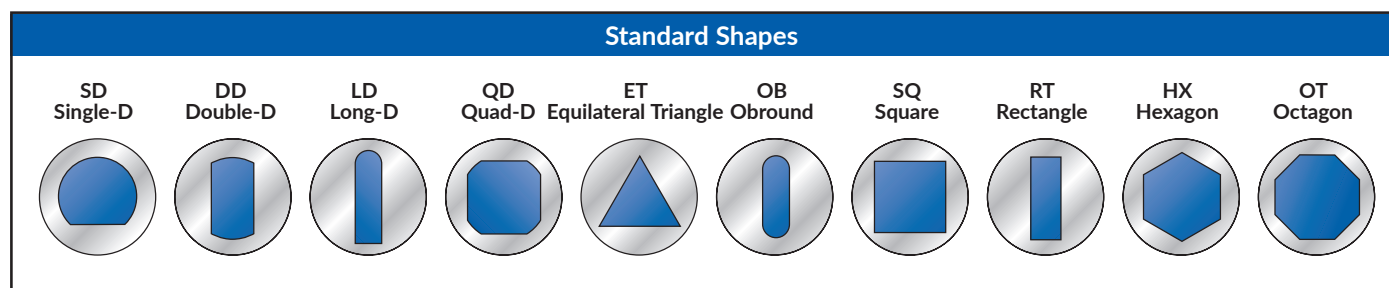
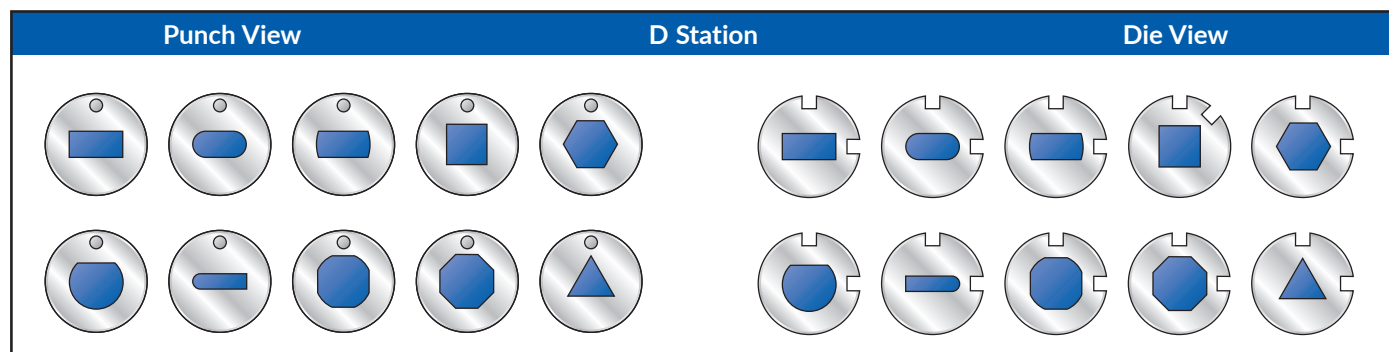
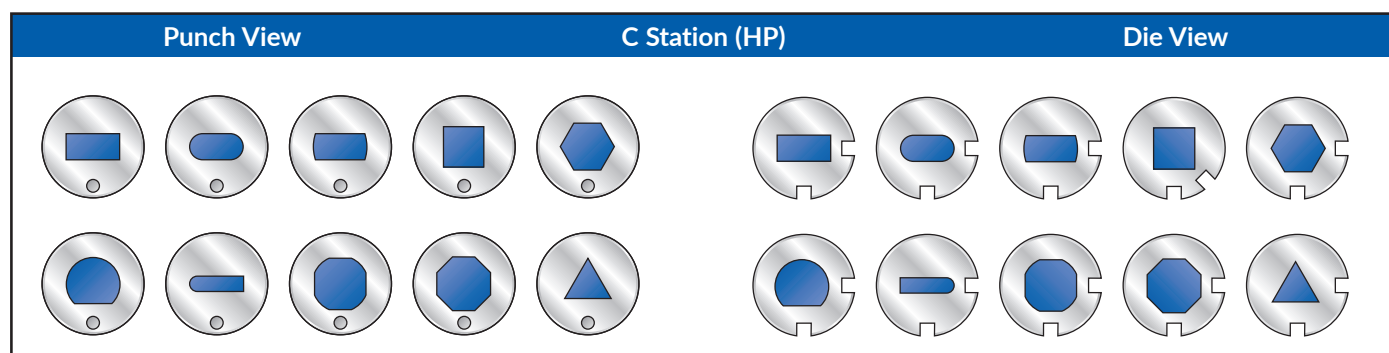
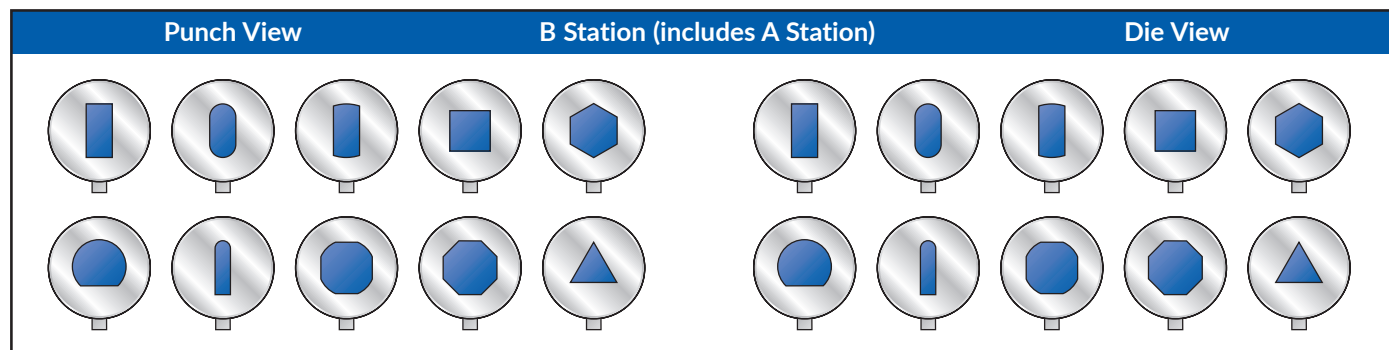
†A' Dimension = Longest distance across shape.

NOTE: In some instances, inverted rooftop is substituted for single and double concave shears.

JK Shear	
Shape	Add On Price
Round	
Rectangle, Square, Hexagon, Singe 'D', Double 'D'	
Obround	
NOTE: If specified: 1.6mm maximum rooftop shear can be given at N/C for any round or shape in C, D or E stations. For rooftop shear on any round or shape in B stations, add .	

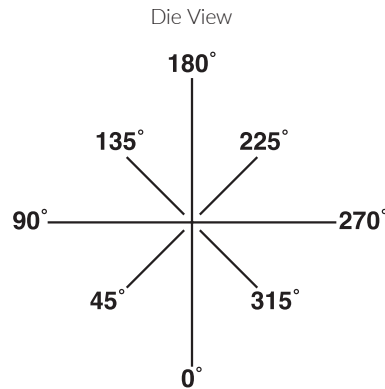
DIE CLEARANCE SELECTION INFORMATION			
Total Clearance			
Material	Minimum	Best	Maximum
Copper, 1/2 Hard	8 %	12 %	16 %
Brass, 1/2 Hard	6 %	11 %	16 %
Mild Steel	10 %	15 %	20 %
Steel 0.50C	12 %	18 %	24 %
Aluminum, Soft	5 %	10 %	15 %
Stainless Steel	15 %	20 %	25 %
% x Material Thickness = Total Clearance			

STANDARD SHAPES & KEYING LOCATIONS



NON STANDARD KEYING

When ordering shapes at non-standard angles, use the diagram below.



Front of Machine

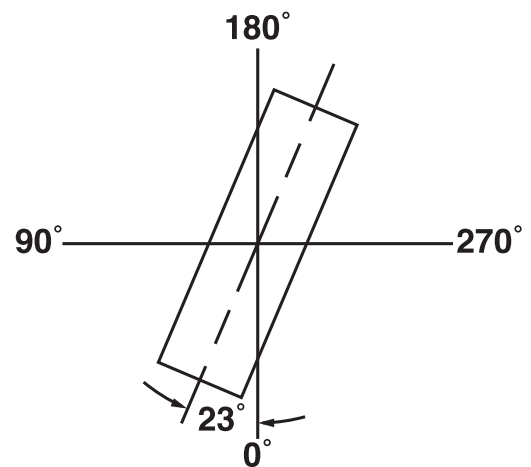
Wilson Tool's keying diagram.

SHAPE at single angles other than standard			
Station	Punches	Dies	Guides or Strippers
A B C D	No Charge		No Charge Not Applicable Not Applicable Not Applicable
NOTE: No additional charge on B stations for shape at 45° increments)			

STANDARD keying, plus extra pins or keys for shapes at other than 45° increments			
Station	Punches	Dies	Guides or Strippers
A B C D	Not Available Not Available per pin per pin	Not Available Not Available per key per key	Not Available Not Available Not Available Not Available

Example

Shape at 23°



STANDARD keying, plus extra pins or keys for shapes at 45° increments					
Station	Punches		Dies		Guides or Strippers
	Available Options	Add On Price	Available Options	Add On Price	
B	0° & 45°		0° & 45°		Closed round guide or 2 fitted guides required Not Available Available Not Available
B	0° & 180°		0° & 180°		
C	45° increments	per pin	45° increments		
D	45° increments	per pin	45° increments		

[illegible]

WILSON TOOL INTERNATIONAL

EUROPE / MIDDLE EAST / AFRICA

Wilson Tool - United Kingdom

Tel (Free): 0800-373748 | Tel: +44 1793 831818
Email: sales@wilsontool.eu.com

Wilson Tool - Germany

Tel: +49 5723 747 0
Email: verkauf@wilsontool.eu.com

Toolspress - Italy

Tel: +39 0521 850510 / 850677
Fax: +39 0521 850796
Email: info@toolspress.com

WORLD HEADQUARTERS

Wilson Tool International - United States

Tel (Free): 800-328-9646 | Tel: 651-286-6001
Email: sales@wilsontool.com

NORTH AMERICA

Wilson Tool - Canada

Punching and Stamping Division
Tel: 800-268-5573
Email: punching@wilsontoolcanada.com

Wilson Tool - Canada

Press Brake Division
Tel: 800-268-4180
Email: bending@wilsontoolcanada.com

Wilson Tool - Mexico

Tel: 52 (81) 1665 1249
Email: americalatina@wilsontool.com

SOUTH AMERICA

Wilson Tool - Brazil

Tel/Fax: 55 11 5624-2444
Email: vendas@wilsontool.com.br