

A SOLUTION FOR SHORT FLANGES AND DIE MARKS

Wilson Tool's V-Series Black Dies for press brakes incorporate replaceable inserts to decrease friction and to enable better performance on certain tough-to-bend applications.

Manufactured by Wilson Tool International, V-Series Black Dies are available for virtually all major styles of press brake tooling. With Wilson Tool as the manufacturer, you will see:

- Higher quality tool steel
- Tighter tolerances
- Increased bend accuracy
- Shorter lead times



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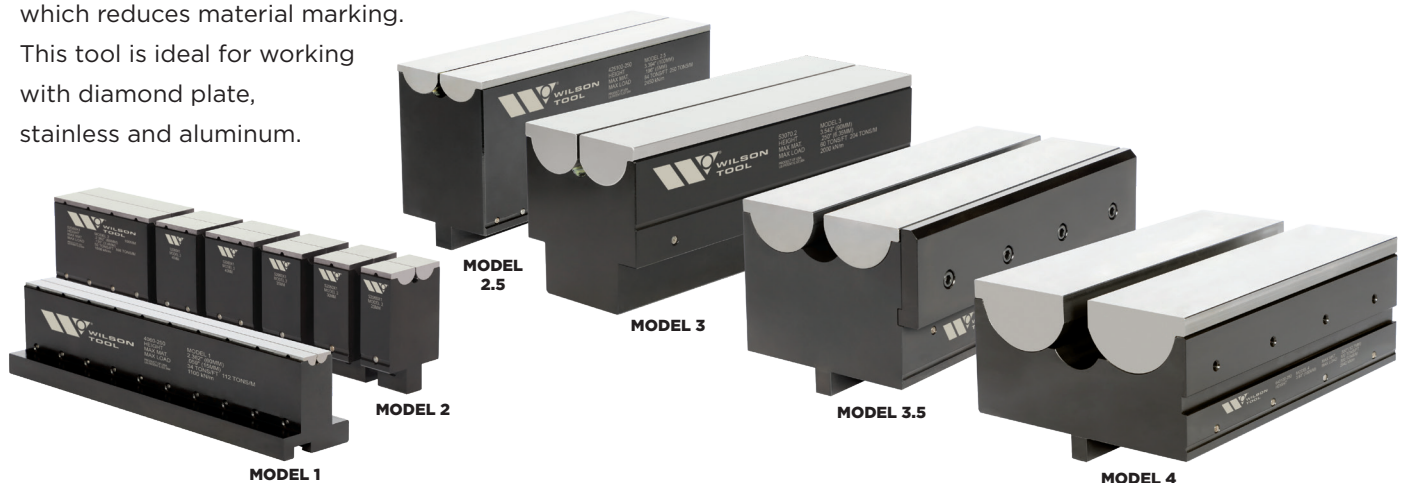
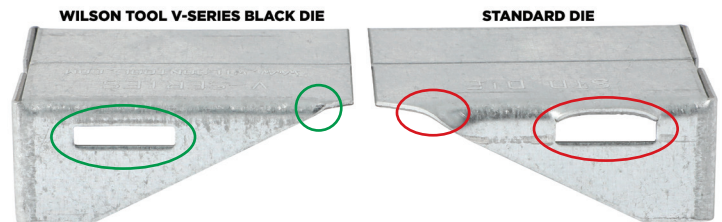
Hard-to-Bend Application Capability

V-Series Black Dies make it much easier to produce small flanges, small bend radii, and bends closer to holes. V-Series Black also enables you to bend a wide range of materials using the same die, reducing set-up time and reducing the amount of tooling required.

Reduced Friction

V-Series Black dies include replaceable built-in inserts that rotate so material glides on a flat surface rather than the traditional grabbing action of a die's shoulder radius. Friction and concentrated load is greatly reduced which reduces material marking.

This tool is ideal for working with diamond plate, stainless and aluminum.

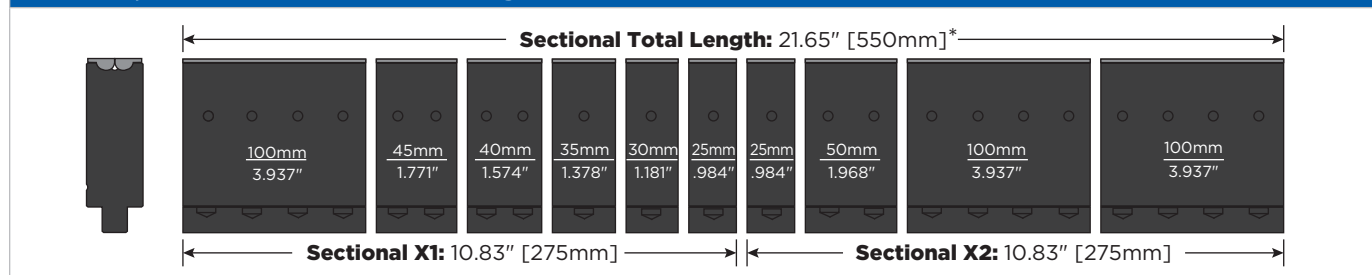


V-SERIES BLACK DIES

	MODEL 1	MODEL 2	MODEL 2.5
EUROPEAN	1071060 Fixed Height 41060	1072074 Fixed Height 42065	425120
AMERICAN	51100 51055	52100 52060	525100
WT-STYLE	61100 61055	62100 62060	625100

Models 1, 2 & 2.5

Solid Lengths Available: 19.68" [500mm] and 9.84" [250mm]



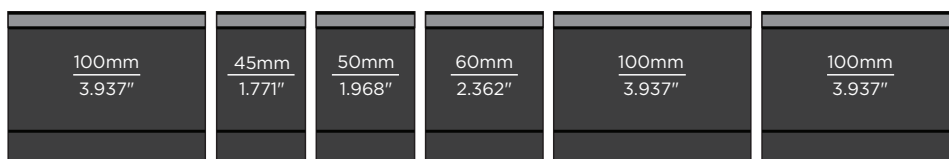
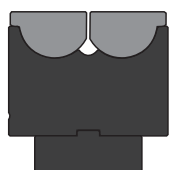
*550mm sectional length not available in Model 2.5

V-SERIES BLACK DIES

	MODEL 3	MODEL 3.5	MODEL 4
EUROPEAN	43090.2 	435100 	440100
AMERICAN	53070.2 	535100 	540100
WT-STYLE	63070.2 	635100 	640100

Models 3, 3.5 and 4

Solid Lengths Available: 9.842" [250mm] & 3.937" [100mm]

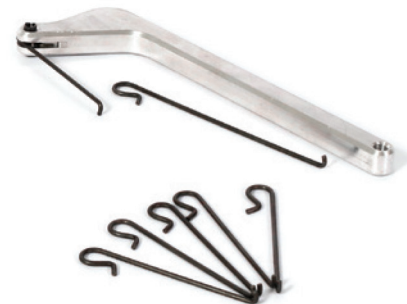


Sectional X1: 10.04" [255mm]

V-SERIES BLACK DIES

V-Series Black Specifications							Capacity		
Model	Material Thickness inch [mm]	Min. Outside Flange inch [mm]	Ton/Ft.	Min. Angle	Min. Outside Radius @ Min. Angle inch [mm]	Max. Outside Radius @ 90° inch [mm]	US Short Ton/Ft.	Metric Tons/M	kN/M
1	.018 [.45]	.118 [3.0]	1.8	34°	.125 [3.17]	.175 [4.45]	38	112	1100
	.020 [.50]		1.8						
	.024 [.60]		2						
	.032 [.80]		2.5						
	.035 [.90]		3.3						
	.040 [1.0]	.153 [3.9]	4						
	.048 [1.2]		5.8						
	.059 [1.5]	.165 [4.2]	9						
2	.075 [1.9]	.335 [8.5]	7	42°	.216 [5.5]	.354 [9.0]	57	168	1650
	.105 [2.7]	.347 [8.8]	13						
	.118 [3.0]	.366 [9.3]	19						
	.126 [3.2]		22						
	.134 [3.4]		25	55°	.276 [7.9]				
2.5	.079 [2.0]	.732 [18.6]	4	46°	.447 [11.35]	.500 [12.7]	84	250	2450
	.157 [4.0]		16	55°	.378 [9.6]				
	.197 [5.0]		28		.343 [8.71]				
3	.157 [4.0]	.886 [22.5]	12	65°	.453 [11.5]	.625 [15.9]	84	250	2450
	.187 [4.75]		26						
	.250 [6.35]		30						
3.5	.236 [6.0]	1.476 [37.5]	15	75°	.267 [6.78]	.945 [24]	84	250	2450
	.315 [8.0]		29		.346 [8.79]				
	.394 [10.0]		49		.425 [10.8]				
4	.236 [6.0]	2.126 [54]	9	78°	.267 [6.78]	1.433 [36.4]	101	300	2942
	.315 [8.0]		17	76°	.346 [8.79]				
	.472 [12.0]		44	73°	.503 [12.78]				

Model	Shoulder Radius inch [mm]	Desired Angle	Theoretical V inch [mm]	Center Line of Inserts inch [mm]
V-OPENING AND SHOULDER RADIUS DIMENSIONS				
1	.043 [1.1]	90°	.283 [7.2]	.315 [8]
		34°	.256 [6.5]	
2	.050 [1.3]	90°	.547 [13.9]	.591 [15]
		42°	.524 [13.3]	
2.5	.079 [2.0]	90°	1.037 [26.3]	1.102 [28]
		55°	1.007 [25.6]	
3	.236 [6.0]	90°	1.299 [33.0]	1.496 [38]
		65°	1.236 [31.4]	
3.5	.138 [3.5]	90°	2.248 [57.1]	2.362 [60]
		75°	2.226 [56.6]	
4	.236 [6.0]	90°	3.151 [80.0]	3.346 [85]
		73°	3.108 [79.0]	



INSTALLATION TOOLS	
Description	Part No.
Spring Installation Tool Kit	981002
Spring Extension Wire (short)	981003
Spring Extension Wire (long)	981004

For more information, visit wilsontool.com/bending, call our tooling technicians at 800.445.4518 or contact your sales engineer.

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