

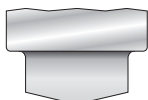
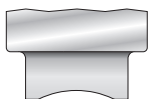
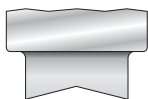
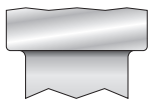
## SALVAGNINI TOOLING



Strength. Performance. Innovation.

# SHEAR OPTIONS AND COATINGS

## SHEAR OPTIONS

| TYPE OF SHEAR                                                                                                      | BENEFIT                                                                                                     | LIMITATION                                                                                           |
|--------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------|
|  <b>Rooftop</b>                   | Best shear for punching at maximum tonnages.                                                                | When nibbling, bite must be 75% of punch dimension or excessive side loading will result.            |
|  <b>Concave or Double Concave</b> | Best shear for nibbling because it inverts stresses.                                                        | The punch is less resistant to breakage when punching at high tonnages because of inverted stresses. |
|  <b>Inverted Rooftop</b>          | Also good shear for nibbling because it inverts stresses.                                                   | More susceptible to breakage because of a sharp focal point for stresses - use great care.           |
|  <b>Double Valley Shear</b>       | 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. |
|  <b>JK Shear</b>                  | 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†.                                 |

## COATING OPTIONS



**OPTIMA®** coating provides significantly longer tool life, more hits between sharpenings, reduced galling, better performance and less downtime. With a surface hardness of 95 Rockwell C, Optima far exceeds the hardness levels that can be achieved with conventional tool steels. It resists galling in stainless and galvanized steel and is unaffected by sharpening.



**WEAR-BEATER™** coating is a titanium nitride (TiN) coating that helps reduce galling and extends punch life in certain applications.



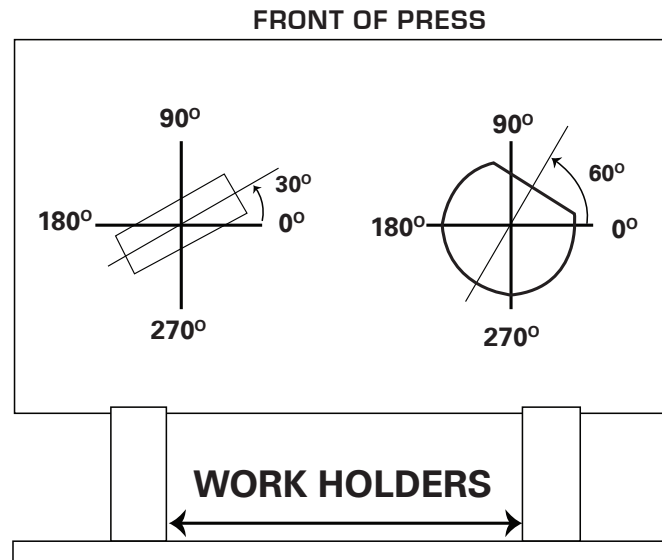
**SLIP-MAX™** coating's combination of hardness and lubricity greatly increases punch life and reduces galling when piercing aluminum. Slip-Max is also very effective in resolving even the most challenging stripping problems with punching or forming stainless steel and aluminum.

# TOOLING OVERVIEW AND TOOL ORIENTATION

## TOOLING OVERVIEW

| HEAD POSITION                                                                                                 | TOOL TYPE | STATION    | SIZE RANGE    | NOTES        |
|---------------------------------------------------------------------------------------------------------------|-----------|------------|---------------|--------------|
| 1 - 20 and 41 - 76<br>[7 Tons]                                                                                | WPA       | 33 mm      | 0.79 - 6 mm   | Round Only   |
|                                                                                                               | WP0       | 33 mm      | 0.79 - 10 mm  | Fully Guided |
|                                                                                                               | WPB       | 33 mm      | 6 - 10.5 mm   | Round Only   |
|                                                                                                               | WP9       | 33 mm      | Up to 26 mm   | Fully Guided |
|                                                                                                               | WS4       | 33 mm      | Up to 33 mm   |              |
| 30 - 35<br>[12 Tons]                                                                                          | WP5       | 60 mm      | Up to 42.4 mm | Rotational   |
|                                                                                                               | WS6       | 60 mm      | Up to 60 mm   | Rotational   |
| 21 - 24<br>[26 Tons]                                                                                          | WS8       | 70 x 90 mm | 70 x 90 mm    | Type 70      |
|                                                                                                               | WS9       | 70 x 90 mm | 70 x 90 mm    | Type 90      |
|                                                                                                               | WSA       | 90 x 90 mm | 90 x 90 mm    | Type 90      |
| Wilson Tool types are compatible with Salvagnini S4, S6, S8, S9, SA, P0, P9, P5 and Mate tool types PA and PB |           |            |               |              |

## TOOLING ORIENTATION



Note: Please refer to non-standard key locations by the following method:

- Example 1 "Shape at 30°"
- Example 2 "Shape at 60°"

|      | STANDARD SHAPE |  |  |  |  |  | DIE VIEW |  |  |  |  |
|------|----------------|--|--|--|--|--|----------|--|--|--|--|
| 0°   |                |  |  |  |  |  |          |  |  |  |  |
| 90°  |                |  |  |  |  |  |          |  |  |  |  |
| 180° |                |  |  |  |  |  |          |  |  |  |  |
| 270° |                |  |  |  |  |  |          |  |  |  |  |



WPA



WPB



WS4

| DESCRIPTION                  | WPA0.79 - 6 mm | PRICE | WPB6 - 10.5 mm | PRICE |
|------------------------------|----------------|-------|----------------|-------|
| Punch Holder w/Locking Screw | 17610          |       | 17612          |       |
| Punch Locking Screw          | 25212          |       | 25212          |       |
| Punch - Round                | 17611          |       | 17613          |       |
| Optima Add-On                |                |       |                |       |
| Stripper - Round             | 17502          |       | 17502          |       |
| Die - Round                  | 17716          |       | 17716          |       |
| Die - Round Slug Hugger® 2   | 17718          |       | 17718          |       |
| Die Shim Pack*               | 17602          |       | 17602          |       |

**Grind Life for WPA, WPB, WS4:**

Punches can be resharpened 4 mm

Dies can be resharpened 1.5 mm

\* Die Shim Pack includes:

5 each 0.1 mm

3 each 0.2 mm

2 each 0.3 mm

| DESCRIPTION                                 | WS4Up to 33 mm | PRICE |
|---------------------------------------------|----------------|-------|
| Punch - Round                               | 17500          |       |
| Punch - Shape                               | 17501          |       |
| Optima Add-On                               |                |       |
| Stripper - Round                            | 17502          |       |
| Stripper - Shape                            | 17503          |       |
| Die - Round [0 - 10.5 mm]                   | 17716          |       |
| Die - Round [10.5 - 33 mm]                  | 17504          |       |
| Die - Round Slug Hugger® 2 [0 - 10.5 mm]    | 17718          |       |
| Die - Round Slug Hugger® 2 M [10.5 - 33 mm] | 17604          |       |
| Die - Shape [0 - 10.5 mm]                   | 17717          |       |
| Die - Shape [10.5 - 33 mm]                  | 17505          |       |
| Die - Shape Slug Hugger® 2 [0 - 10.5 mm]    | 17719          |       |
| Die - Shape Slug Hugger® 2 [10.5 - 33 mm]   | 17605          |       |
| Die Shim Pack*                              | 17602          |       |

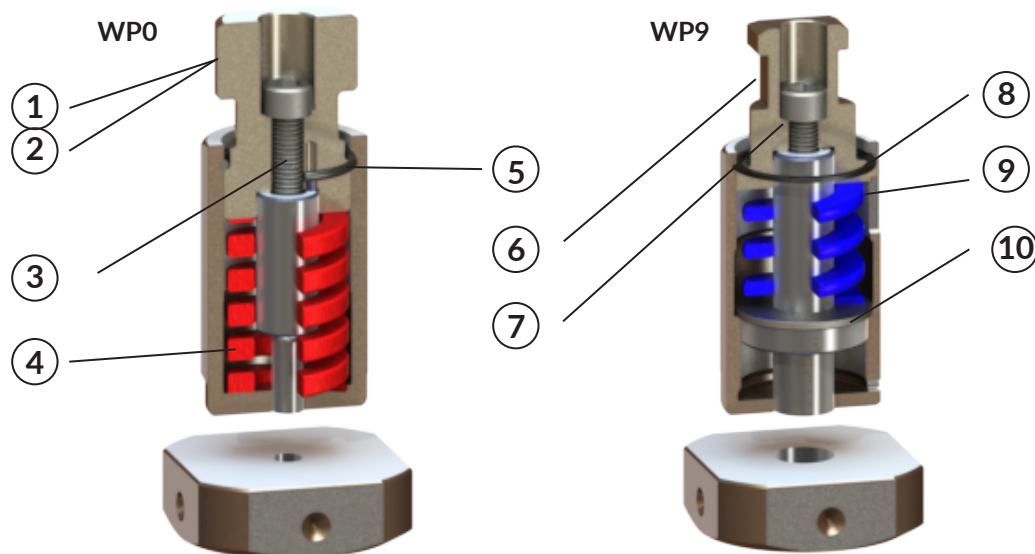
**H3 HEAD**

|               | 30 | 31 | 32 | 33 | 34 | 35 |
|---------------|----|----|----|----|----|----|
| 24<br>90 x 90 | 76 | 68 | 60 | 56 | 52 | 48 |
|               | 75 | 67 | 59 | 55 | 51 | 47 |
| 23<br>70 x 90 | 74 | 66 | 58 | 54 | 50 | 46 |
|               | 73 | 65 | 57 | 53 | 49 | 45 |
| 22<br>70 x 90 | 72 | 64 | 20 | 16 | 12 | 8  |
|               | 71 | 63 | 19 | 15 | 11 | 7  |
| 21<br>90 x 90 | 70 | 62 | 18 | 14 | 10 | 6  |
|               | 69 | 61 | 17 | 13 | 9  | 5  |

**HEAD POSITIONS**

1-20, 41-76 7 TON

| STANDARD SHAPE |  |  |  |  |  |  | DIE VIEW |  |  |  |
|----------------|--|--|--|--|--|--|----------|--|--|--|
|                |  |  |  |  |  |  |          |  |  |  |
|                |  |  |  |  |  |  |          |  |  |  |
|                |  |  |  |  |  |  |          |  |  |  |
|                |  |  |  |  |  |  |          |  |  |  |



| DESCRIPTION                | WP00.79 - 10 mm | PRICE |
|----------------------------|-----------------|-------|
| Punch Assembly - Round     | 17510           |       |
| Punch Assembly - Shape     | 17511           |       |
| Punch - Round              | 17512           |       |
| Punch - Shape              | 17513           |       |
| Optima Add-On              |                 |       |
| Stripping Guide - Round    | 17514           |       |
| Stripping Guide - Shape    | 17515           |       |
| Die - Round                | 17716           |       |
| Die - Round Slug Hugger® 2 | 17718           |       |
| Die - Shape                | 17717           |       |
| Die - Shape Slug Hugger® 2 | 17719           |       |
| Die Shim Pack*             | 17602           |       |
| 1 Punch Holder - Round     | 17516           |       |
| 2 Punch Holder - Shaped    | 17517           |       |
| 3 Socket Head Cap Screw    | 6409            |       |
| 4 Spring                   | 980644          |       |
| 5 Retaining Ring           | 980572          |       |

\* Die Shim Pack includes:  
 5 each 0.1 mm  
 3 each 0.2 mm  
 2 each 0.3 mm

| DESCRIPTION                               | WP9 Up to 26 mm | PRICE |
|-------------------------------------------|-----------------|-------|
| Punch Assembly - Round                    | 17529           |       |
| Punch Assembly - Shape                    | 17521           |       |
| Punch - Round                             | 17522           |       |
| Punch - Shape                             | 17523           |       |
| Optima® Add-On                            |                 |       |
| Stripping Guide - Round                   | 17524           |       |
| Stripping Guide - Shape                   | 17525           |       |
| Die - Round [0 - 10.5 mm]                 | 17716           |       |
| Die - Round [10.5 - 33 mm]                | 17504           |       |
| Die - Round Slug Hugger® 2 [0 - 10.5 mm]  | 17718           |       |
| Die - Round Slug Hugger® 2 [10.5 - 33 mm] | 17604           |       |
| Die - Shape [0 - 10.5 mm]                 | 17717           |       |
| Die - Shape [10.5 - 33 mm]                | 17505           |       |
| Die - Shape Slug Hugger® 2 [0 - 10.5 mm]  | 17719           |       |
| Die - Shape Slug Hugger® 2 [10.5 - 33 mm] | 17605           |       |
| Die Shim Pack*                            | 17602           |       |
| 6 Punch Holder                            | 17526           |       |
| 7 Socket Head Cap Screw                   | 6416            |       |
| 8 Retaining Ring                          | 17528           |       |
| 9 Spring                                  | 6241            |       |
| 10 Spring Support Washer                  | 17527           |       |

## Grind Life for WPO

Punches can be resharpened 1.5 mm  
 Dies can be resharpened 1.5 mm

## Grind Life for WP9

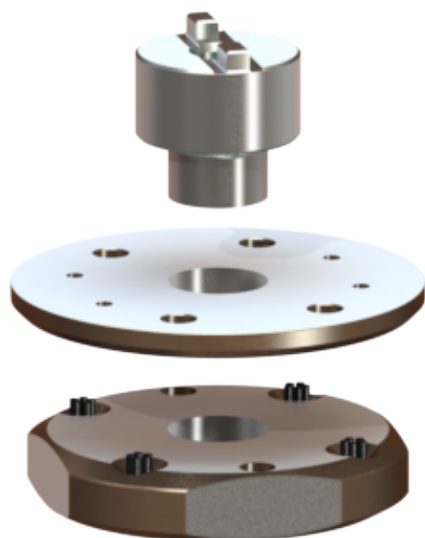
3 mm  
 1.5 mm

|      | STANDARD SHAPE |  |  |  |  |  | DIE VIEW |  |  |  |  |  |
|------|----------------|--|--|--|--|--|----------|--|--|--|--|--|
| 0°   |                |  |  |  |  |  |          |  |  |  |  |  |
| 90°  |                |  |  |  |  |  |          |  |  |  |  |  |
| 180° |                |  |  |  |  |  |          |  |  |  |  |  |
| 270° |                |  |  |  |  |  |          |  |  |  |  |  |

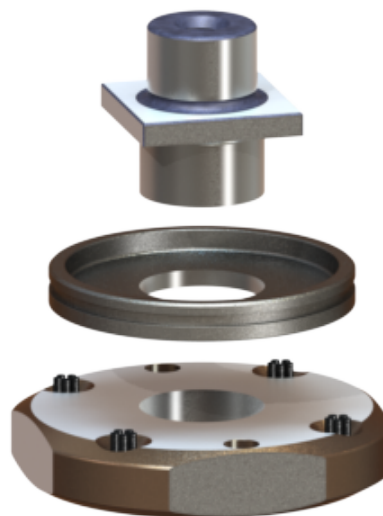
## H3 HEAD

|         | 30 | 31 | 32 | 33 | 34 | 35 |
|---------|----|----|----|----|----|----|
| 24      | 76 | 68 | 60 | 56 | 52 | 48 |
| 90 x 90 | 75 | 67 | 59 | 55 | 51 | 47 |
| 23      | 74 | 66 | 58 | 54 | 50 | 46 |
| 70 x 90 | 73 | 65 | 57 | 53 | 49 | 45 |
| 22      | 72 | 64 | 56 | 52 | 48 | 44 |
| 70 x 90 | 71 | 63 | 55 | 51 | 47 | 43 |
| 21      | 70 | 62 | 54 | 50 | 46 | 42 |
| 90 x 90 | 69 | 61 | 53 | 49 | 45 | 41 |

HEAD POSITIONS  
 1-20, 41-76 7 TON



WP5



WS6

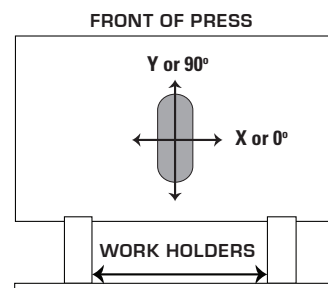
| DESCRIPTION                | WP5<br>Up to 42.4 mm | PRICE | WS6<br>Up to 60 mm | PRICE |
|----------------------------|----------------------|-------|--------------------|-------|
| Punch - Round              | 17532                |       | 17542              |       |
| Punch - Shape              | 17533                |       | 17543              |       |
| Optima® Add-On             |                      |       |                    |       |
| Stripper - Round           | 17534                |       | 17544              |       |
| Stripper - Shape           | 17535                |       | 17545              |       |
| Die - Round                | 17536                |       | 17536              |       |
| Die - Round Slug Hugger® 2 | 17636                |       | 17636              |       |
| Die - Shape                | 17537                |       | 17537              |       |
| Die - Shape Slug Hugger® 2 | 17637                |       | 17637              |       |
| Die Brush 8mm              | 17601                |       | 17601              |       |

\* Dies come with brushes installed.

#### Grind Life for WP5, WS6:

Punches can be re-sharpened 4 mm

Dies can be re-sharpened 1.5 mm



#### H3 HEAD

|               | 30       | 31       | 32       | 33       | 34       | 35       |
|---------------|----------|----------|----------|----------|----------|----------|
| 24<br>90 x 90 | 76<br>75 | 68<br>67 | 60<br>59 | 56<br>55 | 52<br>51 | 48<br>47 |
| 23<br>70 x 90 | 74<br>73 | 66<br>65 | 58<br>57 | 54<br>53 | 50<br>49 | 46<br>45 |
| 22<br>70 x 90 | 72<br>71 | 64<br>63 | 20<br>19 | 16<br>15 | 12<br>11 | 8<br>7   |
| 21<br>90 x 90 | 70<br>69 | 62<br>61 | 18<br>17 | 14<br>13 | 10<br>9  | 6<br>5   |

|      | STANDARD SHAPE |  |  |  |  |  | DIE VIEW |  |  |  |  |
|------|----------------|--|--|--|--|--|----------|--|--|--|--|
| 0°   |                |  |  |  |  |  |          |  |  |  |  |
| 90°  |                |  |  |  |  |  |          |  |  |  |  |
| 180° |                |  |  |  |  |  |          |  |  |  |  |
| 270° |                |  |  |  |  |  |          |  |  |  |  |

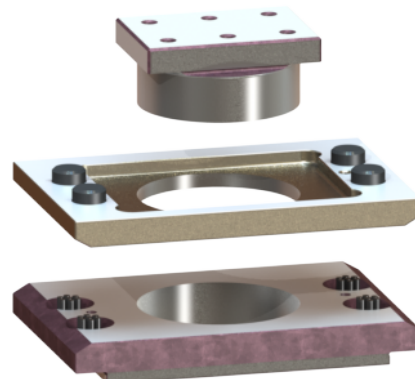
#### HEAD POSITIONS

30 - 35 12 TON

| TYPE 70TYPE 70             | WS8<br>70 x 90 mm | PRICE |
|----------------------------|-------------------|-------|
|                            | Type 70Type 70    |       |
| Punch - Round              | 17562             |       |
| Punch - Shapes             | 17563             |       |
| Optima® Add-On             |                   |       |
| Stripper - Round           | 17564             |       |
| Stripper - Shapes          | 17565             |       |
| Die - Round                | 17566             |       |
| Die - Round Slug Hugger® 2 | 17666             |       |
| Die - Shape                | 17567             |       |
| Die - Shape Slug Hugger® 2 | 17667             |       |
| Large Brush 13 mm          | 17600             |       |

\* Die and Strippers come with brushes installed.

Type 70



WS8

## HEAD POSITIONS 21-24 26 TON

Verify what stations are in the cartridge.

### TYPE 70

|               | 30 | 31 | 32 | 33 | 34 | 35 |
|---------------|----|----|----|----|----|----|
| 24<br>70 x 90 | 76 | 68 | 60 | 56 | 52 | 48 |
| 23<br>70 x 90 | 75 | 67 | 59 | 55 | 51 | 47 |
| 22<br>70 x 90 | 74 | 66 | 58 | 54 | 50 | 46 |
| 21<br>70 x 90 | 73 | 65 | 57 | 53 | 49 | 45 |
|               | 72 | 64 | 20 | 16 | 12 | 8  |
|               | 71 | 63 | 19 | 15 | 11 | 7  |
|               | 70 | 62 | 18 | 14 | 10 | 6  |
|               | 69 | 61 | 17 | 13 | 9  | 5  |

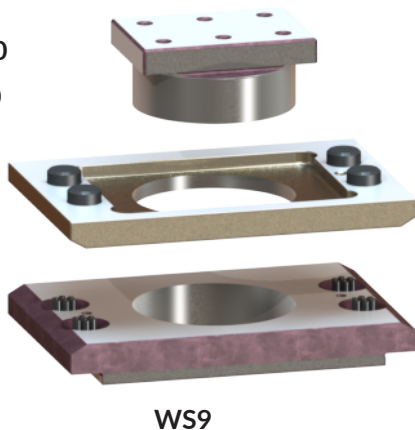
### Grind Life for WS8

Punches can be resharpened 4 mm  
Dies can be resharpened 1.5 mm

Slug retention options available upon request.

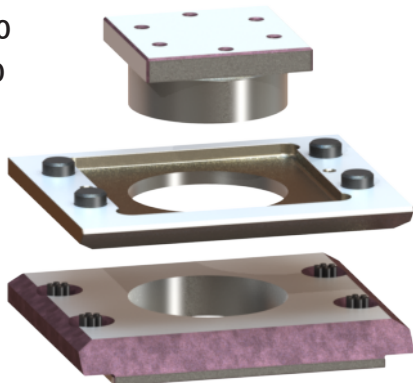
|      | STANDARD SHAPE |  |  |  |  |  | DIE VIEW |  |  |  |  |  |
|------|----------------|--|--|--|--|--|----------|--|--|--|--|--|
| 0°   |                |  |  |  |  |  |          |  |  |  |  |  |
| 90°  |                |  |  |  |  |  |          |  |  |  |  |  |
| 180° |                |  |  |  |  |  |          |  |  |  |  |  |
| 270° |                |  |  |  |  |  |          |  |  |  |  |  |

Type 90  
70 x 90



WS9

Type 90  
90 x 90



WSA

| DESCRIPTION                | WS9<br>70 x 90 mm | PRICE | WSA<br>90 x 90 mm | PRICE |
|----------------------------|-------------------|-------|-------------------|-------|
|                            | Type 90           |       | Type 90           |       |
| Punch - Round              | 17562             |       | 17582             |       |
| Punch - Shapes             | 17563             |       | 17583             |       |
| Optima® Add-On             |                   |       |                   |       |
| Stripper - Round           | 17574             |       | 17584             |       |
| Stripper - Shapes          | 17575             |       | 17585             |       |
| Die - Round                | 17576             |       | 17586             |       |
| Die - Round Slug Hugger® 2 | 17676             |       | 17686             |       |
| Die - Shape                | 17577             |       | 17587             |       |
| Die - Shape Slug Hugger® 2 | 17677             |       | 17687             |       |
| Large Brush 13 mm          | 17600             |       | 17600             |       |

\* Die and Strippers come with brushes installed.

## TYPE 90

|               | 30 | 31 | 32 | 33 | 34 | 35 |
|---------------|----|----|----|----|----|----|
| 24<br>90 x 90 | 76 | 68 | 60 | 56 | 52 | 48 |
| 23<br>70 x 90 | 75 | 67 | 59 | 55 | 51 | 47 |
| 22<br>70 x 90 | 74 | 66 | 58 | 54 | 50 | 46 |
| 21<br>90 x 90 | 73 | 65 | 57 | 53 | 49 | 45 |
|               | 72 | 64 | 20 | 16 | 12 | 8  |
|               | 71 | 63 | 19 | 15 | 11 | 7  |
|               | 70 | 62 | 18 | 14 | 10 | 6  |
|               | 69 | 61 | 17 | 13 | 9  | 5  |

## HEAD POSITIONS 21-24 26 TON

Verify what stations are in the cartridge.

### Grind Life for WS9 & WSA

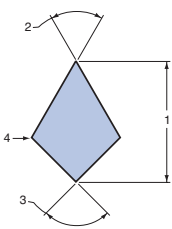
Punches can be resharpened 4 mm  
Dies can be resharpened 1.5 mm

Slug retention options available upon request.

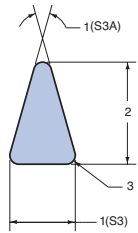
|      | STANDARD SHAPE |  |  |  |  |  | DIE VIEW |  |  |  |  |
|------|----------------|--|--|--|--|--|----------|--|--|--|--|
| 0°   |                |  |  |  |  |  |          |  |  |  |  |
| 90°  |                |  |  |  |  |  |          |  |  |  |  |
| 180° |                |  |  |  |  |  |          |  |  |  |  |
| 270° |                |  |  |  |  |  |          |  |  |  |  |

## GROUP "A"

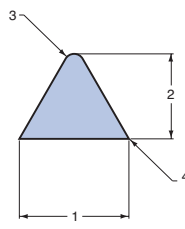
Note: Special Considerations May Alter Price and Lead Time



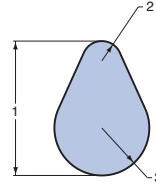
S1



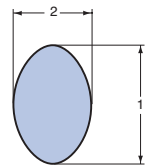
S3 -S3A



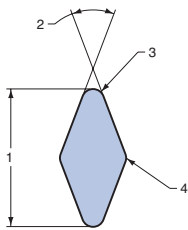
S4



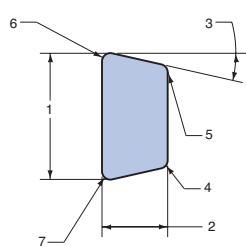
S7



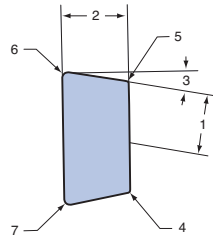
S8



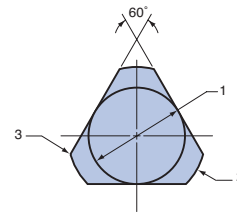
S9



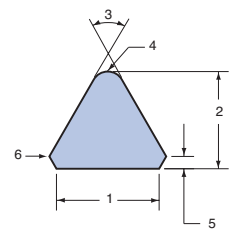
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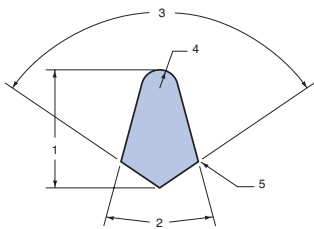
S23A



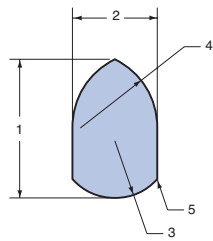
S50



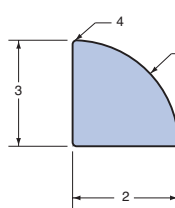
S51



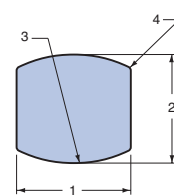
S59



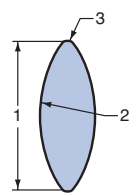
S65



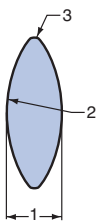
S69



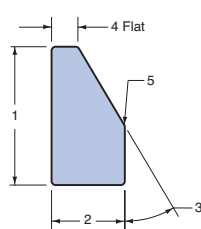
S81



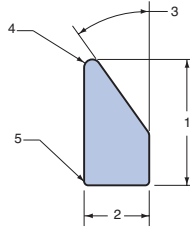
S95L



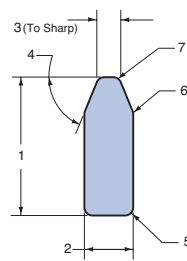
S95W



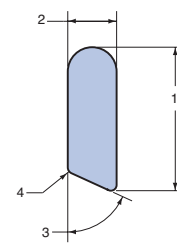
S97



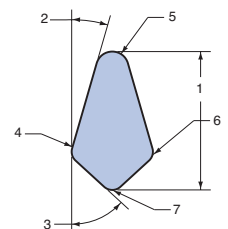
S100



S102

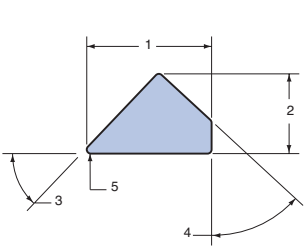


S103

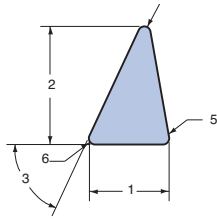


S105

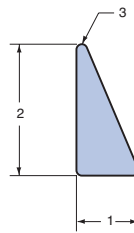
## GROUP "A"



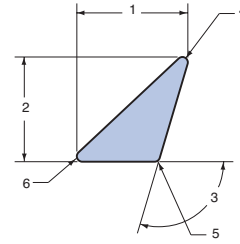
S106



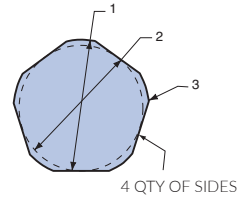
S108



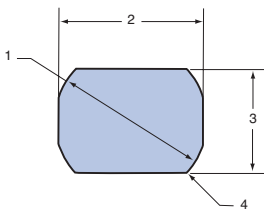
S109



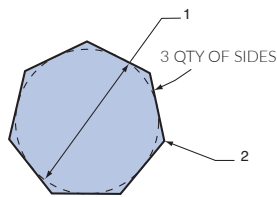
S110



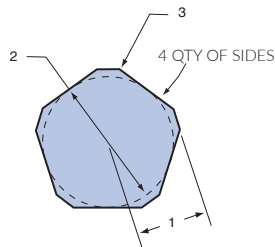
S121



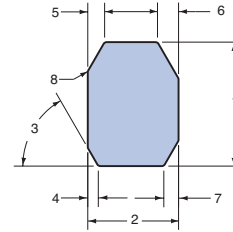
S122



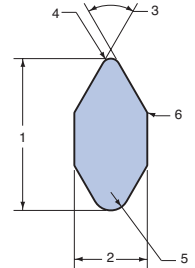
S123



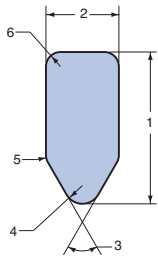
S124



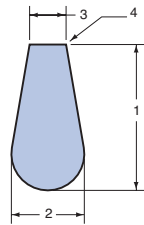
S161



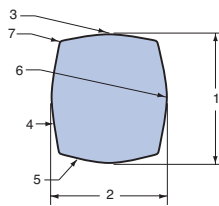
S162



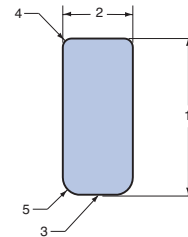
S163



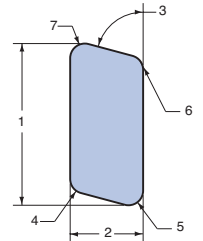
S164



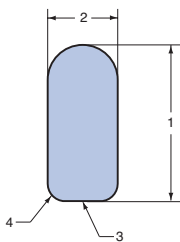
S165



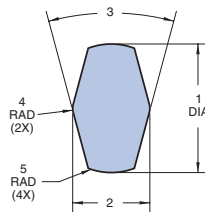
S166



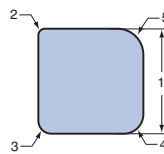
S167



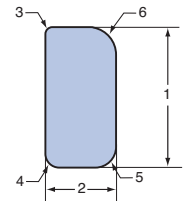
S170



SQF

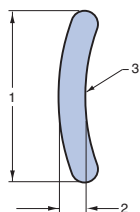


PN

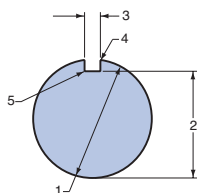


RTF

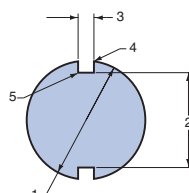
## GROUP "B"



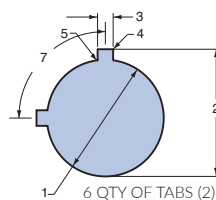
S6



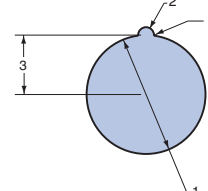
S10



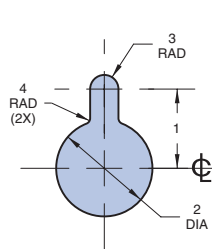
S11



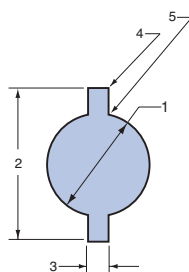
S12



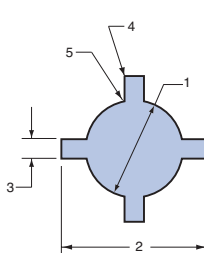
S13



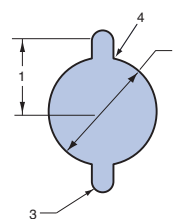
S14



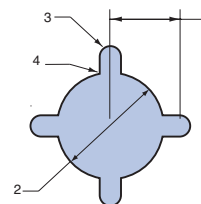
S15



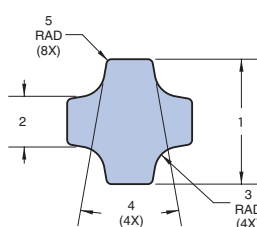
S16



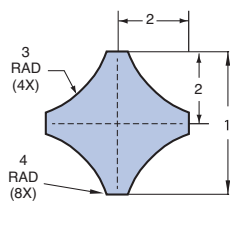
S17



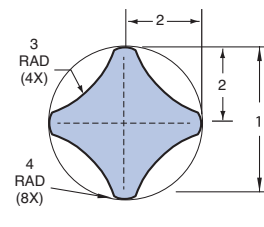
S18



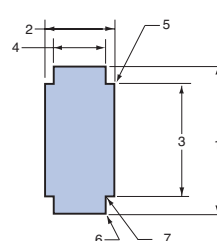
S19



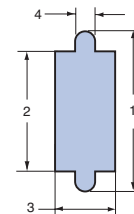
S19A



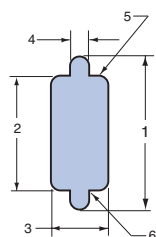
S19B



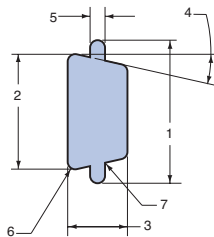
S20



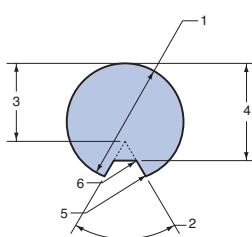
S21



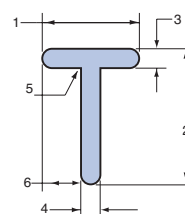
S22



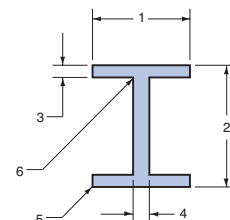
S24



S30

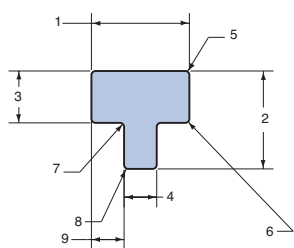


S31

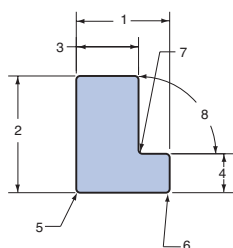


S33

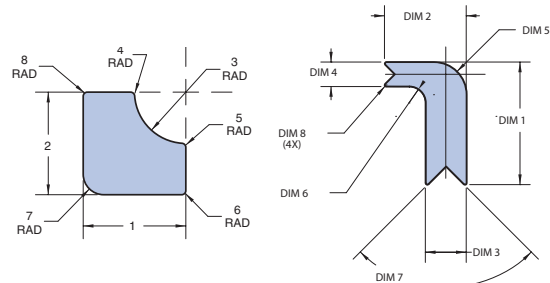
## GROUP "B"



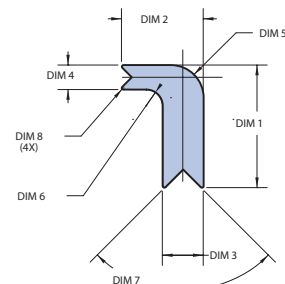
S35



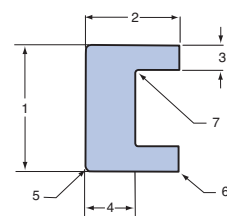
S36



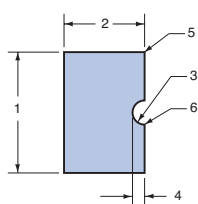
S36A



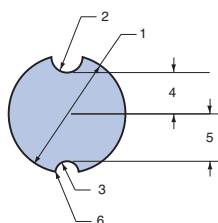
S37



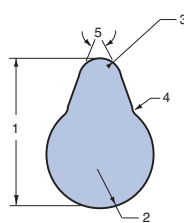
S40



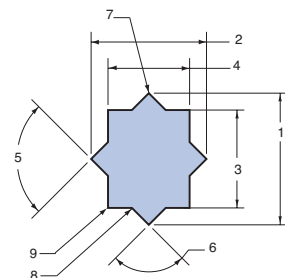
S41



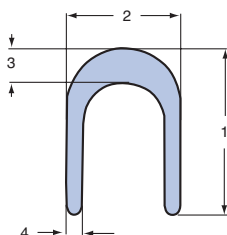
S42



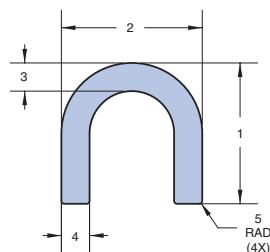
S43



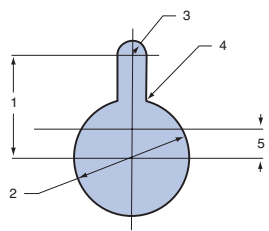
S46



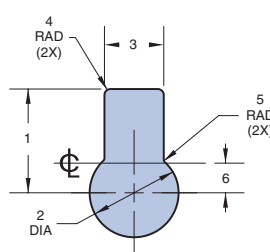
S54



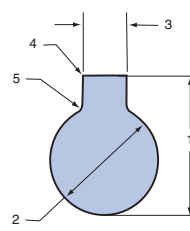
S55



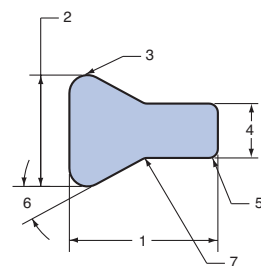
S56



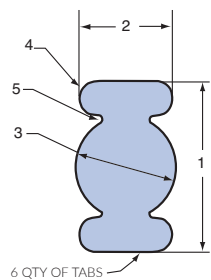
S57



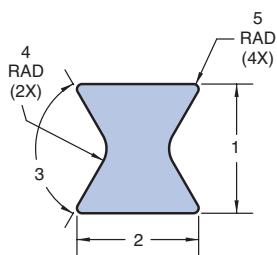
S58



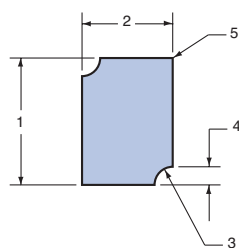
S60



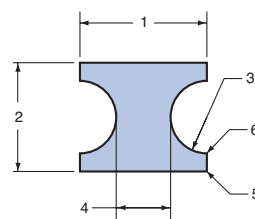
S61



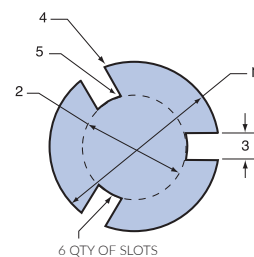
S62



S66

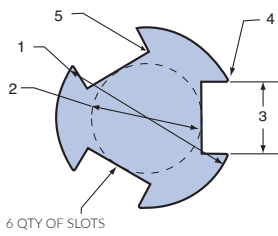


S79

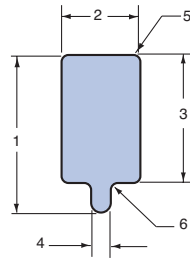


S82

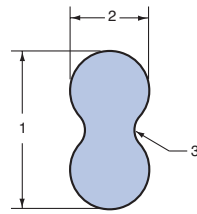
## GROUP "B"



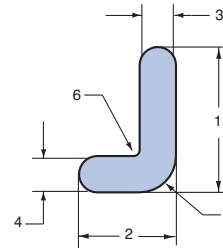
S83



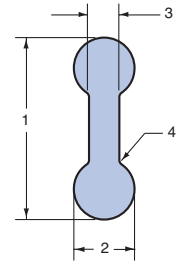
S84



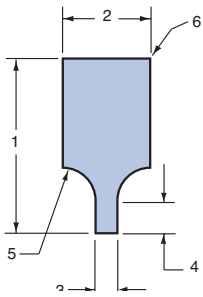
S87



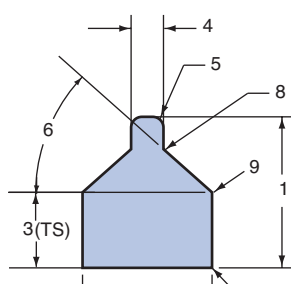
S88



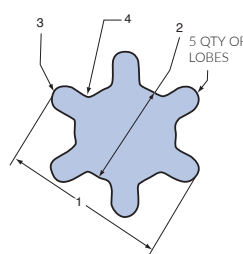
S91



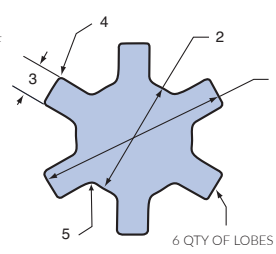
S93



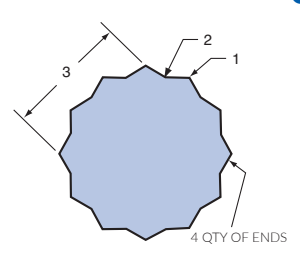
S114



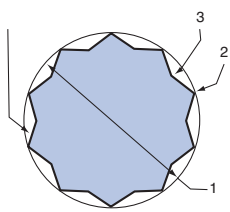
S115



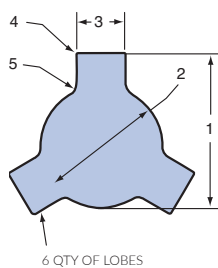
S116



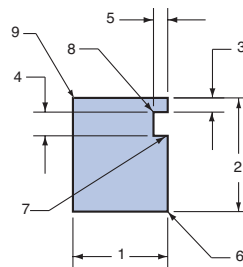
S117



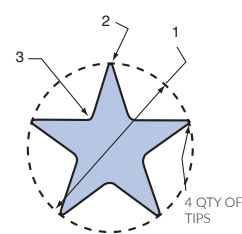
S118



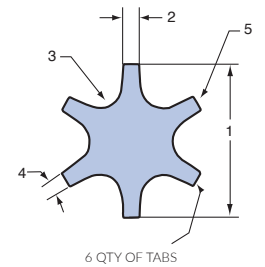
S119



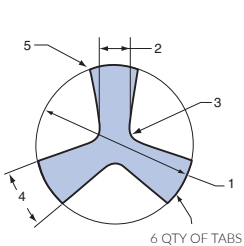
S120



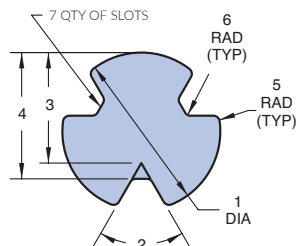
S125



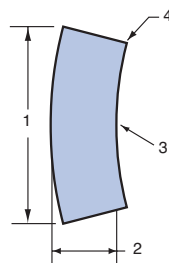
S126



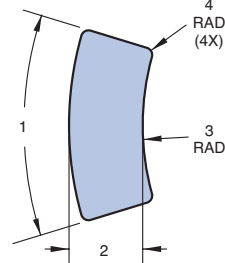
S127



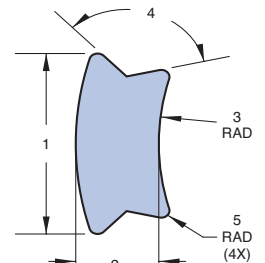
S128



S141

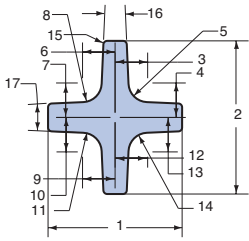


S141A

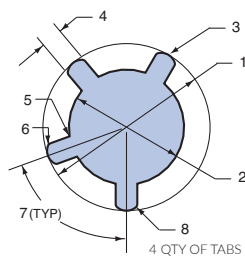


S142

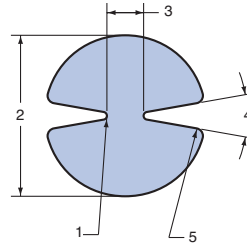
## GROUP "B"



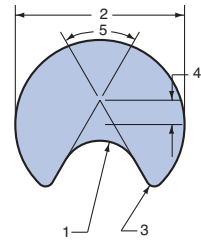
S168



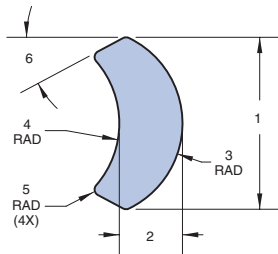
S169



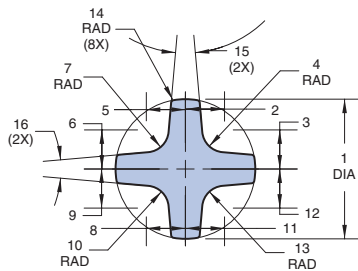
S171



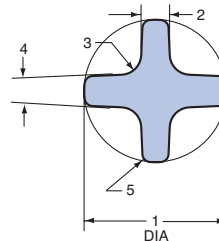
S172



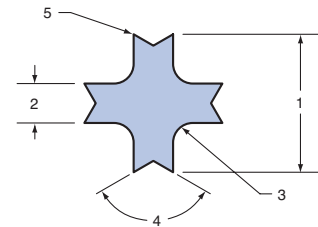
S174



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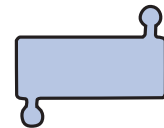
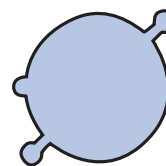
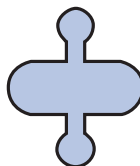
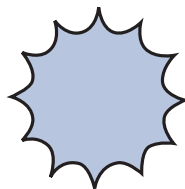
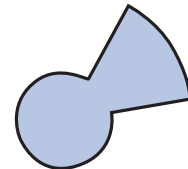
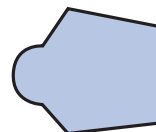
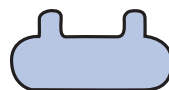
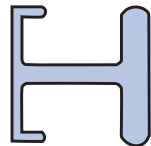
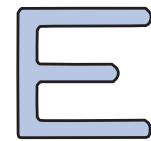
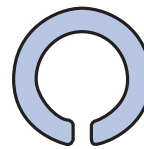
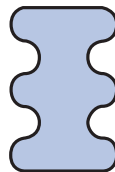
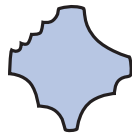
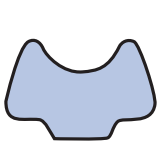


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## GROUP "C"





## WORLD HEADQUARTERS

### Wilson Tool International - United States

Tel (Free): 800-328-9646 | Tel: 651-286-6001  
Fax (Free): 800-222-0002 | Fax: 651-286-5959  
Email: sales@wilsontool.com

## NORTH AMERICA

### Wilson Tool - Canada

Punching and Stamping Division  
Tel: 800-268-5573 | Fax: 800-668-9314  
Email: punching@wilsontoolcanada.com

### Wilson Tool - Canada

Press Brake Division  
Tel: 905-840-2240 | Fax: 905-840-1032  
Email: bending@wilsontoolcanada.com

### Wilson Tool - Mexico

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

## SOUTH AMERICA

### Milling Ferramentas - Brazil

Tel/Fax: 55 11 5621-2100  
Email: vendas@milling.com.br

## EUROPE / MIDDLE EAST / AFRICA

### Wilson Tool - United Kingdom

Tel (Free): 0800-373748 | Tel: +44 1793 831818  
Fax (Free): 0800-373758 | Fax: +44 1793 831945 or 46  
Email: sales@wilsontool.eu.com

### Wilson Tool - Germany

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

### Wilson Tool - Denmark

Tel: +45 44 53 1699  
Email: salesdk@wilsontool.eu.com

### Wilson Tool - France

Tel: +33 (0) 164 13 47 80  
Email: ventes@wilsontool.eu.com

### Toolspress - Italy

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

