



EUROPEAN-STYLE PRESS BRAKE TOOLING

2025

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EUROPEAN-STYLE PRESS BRAKE TOOLING

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Prices and product availability are subject to change without notice.

ABOUT WILSON TOOL INTERNATIONAL

From humble beginnings in a small manufacturing facility in St. Paul, Minnesota, Wilson Tool International has added manufacturing facilities and sales channels around the world to better serve our thousands of global customers. Throughout our expansion, our mission has never wavered — we continue to offer products and services that help you be more successful. Every product you buy, every employee with whom you communicate, and every training event you attend, are designed to help customers just like you be more successful.

At Wilson Tool, we continue to invest in your success through constant innovation. Our tooling and solutions represent decades of knowledge and experience in assisting manufacturers resolve their most challenging fabrication issues. We understand that no two jobs are the same. Change is the only constant in manufacturing. So, working with a tooling supplier who's flexible, nimble, and knowledgeable is important.

Our goal is to deliver exceptional
customer service
along with the most reliable and
innovative products and solutions
so that our **customers**
can be more successful.

When you have a challenge, reach out to us. At Wilson Tool we are more than tools... we are solutions. Your local Sales Engineer is available in person, by phone and through e-mail. Let us put our many decades of expertise to the test. We will work with you to find the best possible solution to whatever challenge you may be facing. And every order comes with our guarantee to outperform your current tooling.

From all of us at Wilson Tool, thank you for the trust you have placed in us to provide products and services that are critical to your business. We look forward to your continued success as we head into the future.



BENDING

Wilson Tool's Bending division delivers the most complete line of tooling and clamping solutions available anywhere.

Whether you use American, European, WT, Bystronic or LVD-style precision or conventional tooling, Wilson Tool has a solution for you. Our clamping options cover these styles as well. With hydraulic push button, quick release mechanical or standard manual clamps, we have a clamping solution for any style of machine or budget. And our custom tooling manufacturing capabilities are the envy of the industry with innovative solutions for complex bending challenges. With manufacturing facilities located in the USA and Canada, our delivery times to North American fabricators are the fastest in the industry.



STAMPING



Wilson Tool's Stamping division, Impax Tooling Solutions®, offers high quality punch and die components, accessories and retainers for the stamping industry.

Innovative products such as our HP Accu-Lock® Retainer Inserts and extensive coating options, combined with our world-class customer service, have enabled us to quickly grow into a world-class provider. With a direct sales force throughout North America, we deliver products straight from the factory to you, enabling the fastest deliveries in the industry. Our custom tooling expertise is second to none with many customers coming to us for their most difficult stamping challenges.

PUNCHING

Wilson Tool's Punching division continues to drive the industry with new levels of quality, delivery, service and innovation.

From the early days of Series 80 to the Wilson Wheel® Family to EXP® technology, our punching division has been the industry-leading innovation driver. Combined with the most experienced customer support professionals in the industry, Wilson Tool continues to raise the bar. Thick turret, TRUMPF-style, Salvagnini-style, or any other style of punch press you may be using, Wilson Tool offers the most complete line of tooling solutions available today.



TRUMPF is a trademark of TRUMPF GmbH + Co. KG.

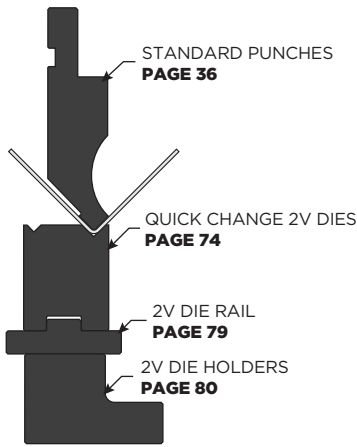
ACCESSORIES



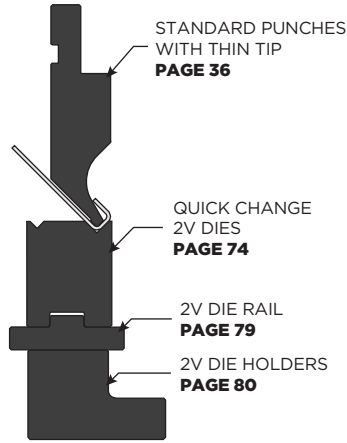
Whether you need storage systems, grinders, urethane rolls, hand tools or related supplies, we offer a wide range of solutions to help you be more productive, organized and efficient.



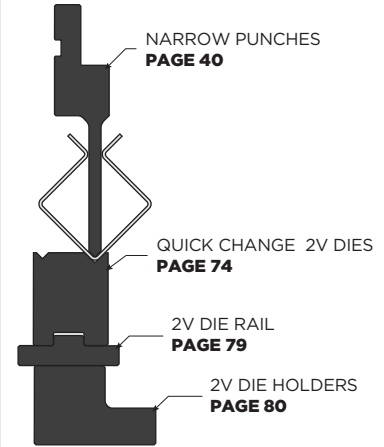
**90° BENDING
(27 GA - 10 GA)**



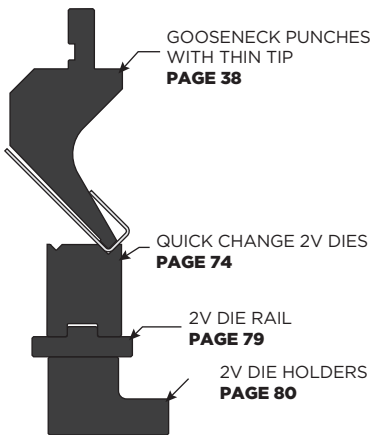
**90° BENDING
W/THIN TIP PUNCH**



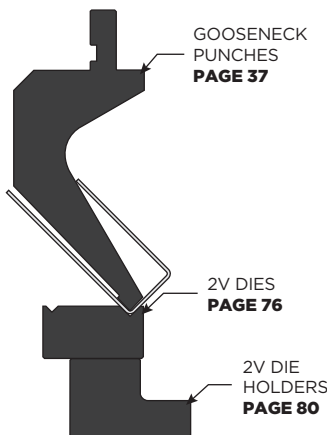
**90° BENDING
W/NARROW PUNCH**



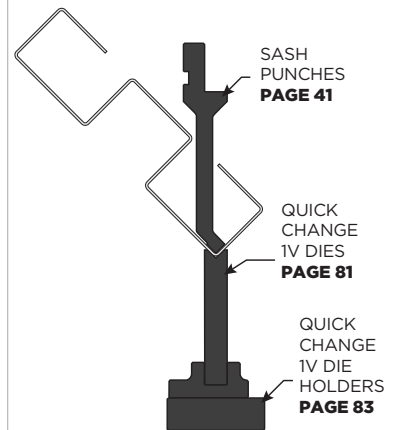
**90° BENDING W/THIN TIP
GOOSENECK PUNCH**



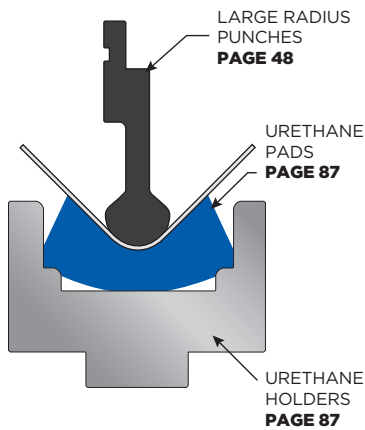
**90° BENDING
W/GOOSENECK PUNCH**



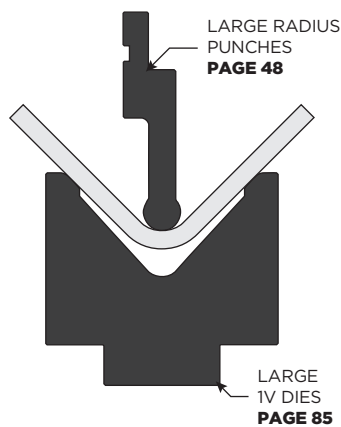
**90° BENDING
(SASH)**



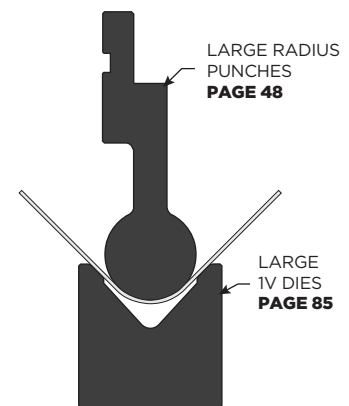
**LARGE RADIUS BENDING
URETHANE PAD**



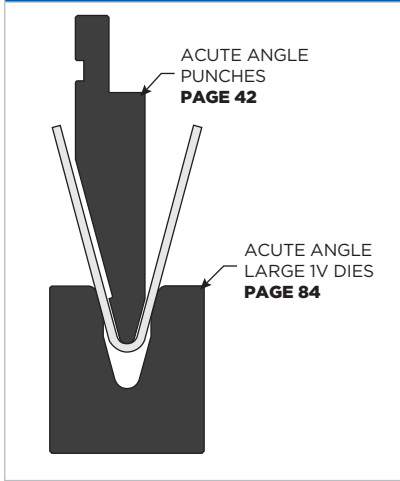
**90° BENDING
(3/8" - 1/2")**



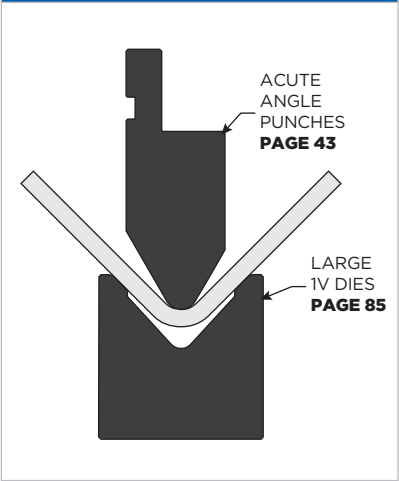
**LARGE
RADIUS BENDING**



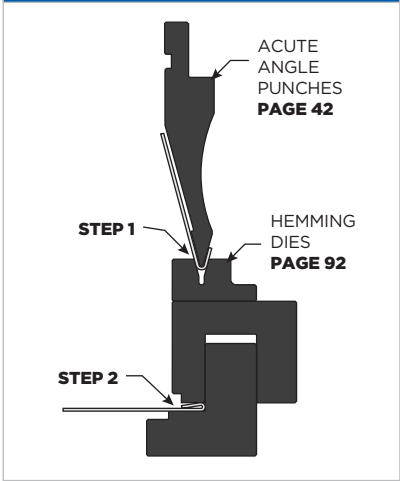
**ACUTE-ANGLE BENDING
(12 GA - 6 GA)**



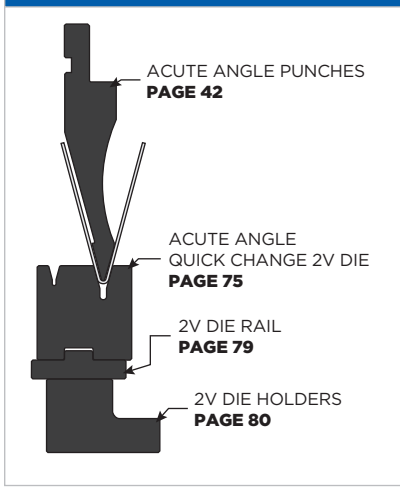
**90° BENDING
(9 GA - 3/8")**



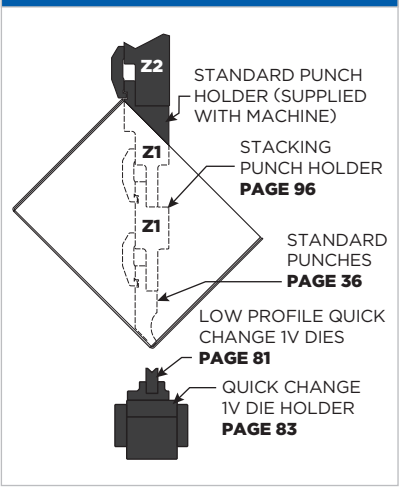
**HEMMING (2 STAGE)
(27 GA - 14 GA)**



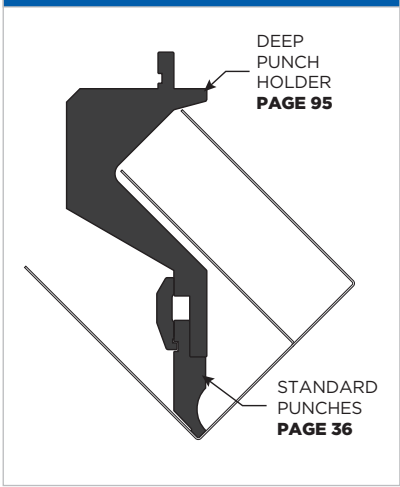
**ACUTE-ANGLE BENDING
(27 GA - 14 GA)**



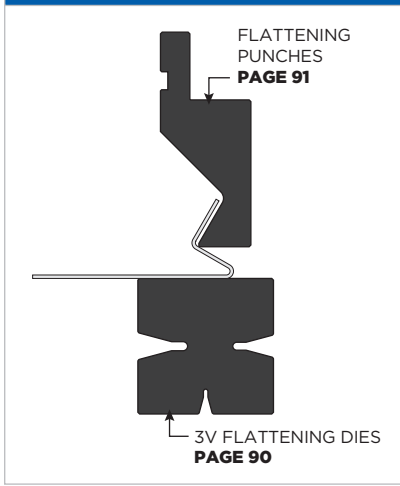
DEEP BOX BENDING



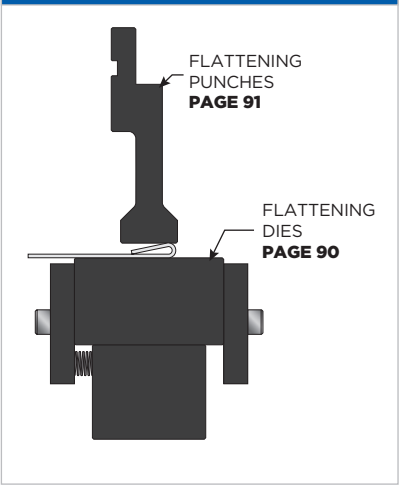
DEEP PUNCH HOLDER



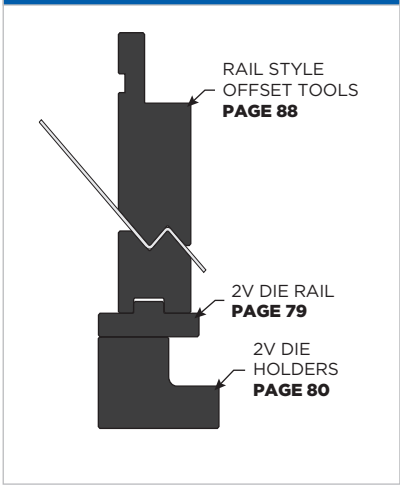
**HEMMING
(27 GA - 16 GA)**



**HEMMING
(27 GA - 11 GA)**



**OFFSET BENDING
(27 GA - 16 GA)**



BENDING DIAGRAMS

FIXED HEIGHT TOOLING

THE TOOLING YOU NEED WITH WILSON TOOL BENEFITS

Wilson Tool International Fixed Height tooling is optimized for performance and ease of use. All tooling is heat treated for optimal performance and features our rust prohibitive black surface. This ensures longer life and better performance. Each section includes tooling detail in easy-to-read laser marking.

Wilson Tool's Fixed Height line is fully compatible with Amada® machines. It is made in and shipped from the USA with the shortest lead-times available.

The Customization You Require

As with all Wilson Tool press brake tool styles, Fixed Height tooling can be custom made in special configurations for unique bends. Tip modifications and cuts are designed and manufactured out of our Minnesota headquarters.



Amada® is a registered trademark of Amada Co., Ltd. and is used by Amada America, Inc., Amada Capital Corporation and Amada Co., Ltd.





SECTIONALIZED PUNCH & DIE LENGTHS — Ear section notes only apply to punches

L = 32.87" [835mm]

S = 20.08" [510mm]

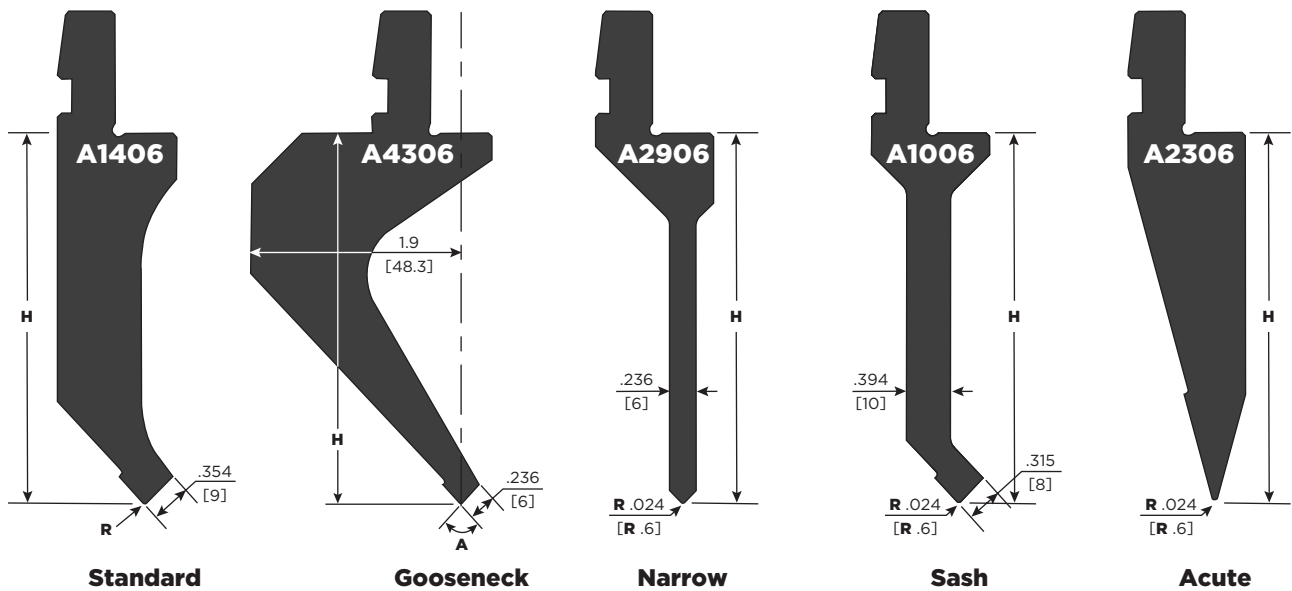
X = 14.57" [370mm]

X Section Lengths [mm]: 10 (2) | 15 | 20 | 25 | 40 | 50 | 100 Ear Sections (2)

100 = 3.93" [100mm]

Featuring the beveled punch tang.

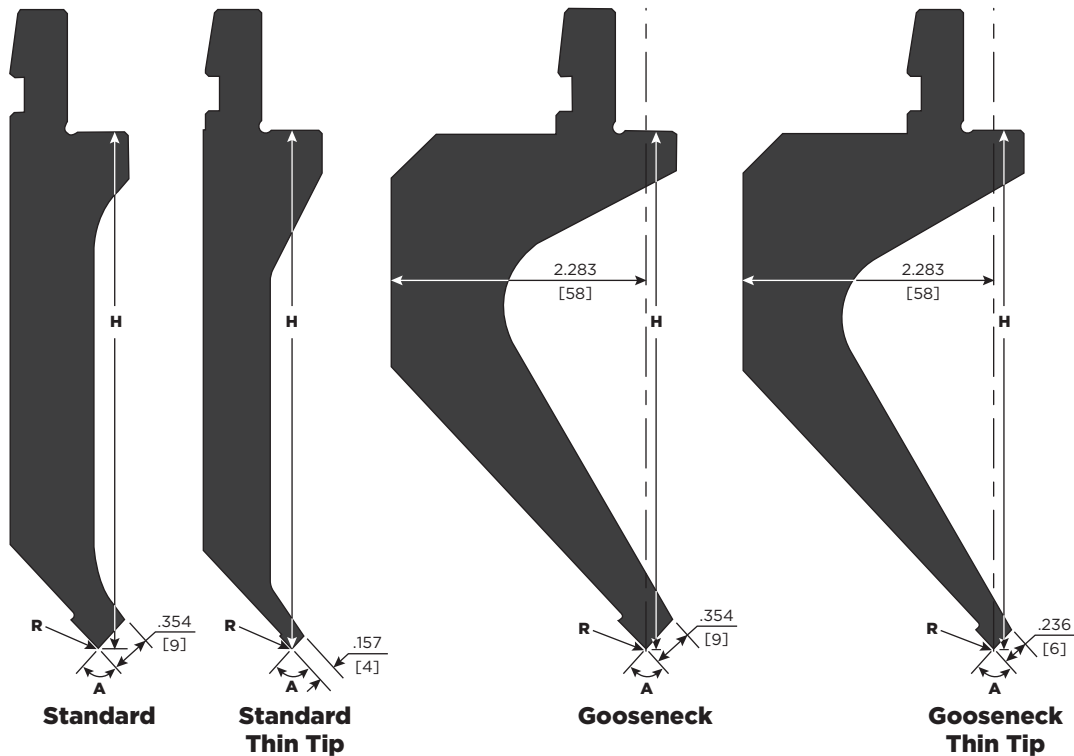
85mm TALL PUNCHES — FIXED HEIGHT



FIXED HEIGHT TOOLING

Part No.	A Angle	R Radius inch [mm]	Height inch [mm]	L & S	X	Weight lbs./inch [kg/mm]	L	S	X	100
				Max. Ton feet [m]	32.87" [835mm]		20.08" [510mm]	14.6" [370mm]	3.93" [100mm]	
85mm TALL PUNCHES W/ BEVELED TANG (FIXED HEIGHT)										
A1406	86°	.024 [0.6]	3.339 [84.8]	30 [100]	14 [47]	1.01 [.018]				
A4306				21 [70]	14 [47]	1.16 [.021]				
A2906				15 [50]	3.7 [12]	0.51 [.009]				
A1006				15 [50]	5 [17]	0.70 [.012]				
A2306	30°	.024 [0.6]	3.339 [84.8]	30 [100]	9 [30]	0.86 [.015]				

120mm TALL PUNCHES – FIXED HEIGHT



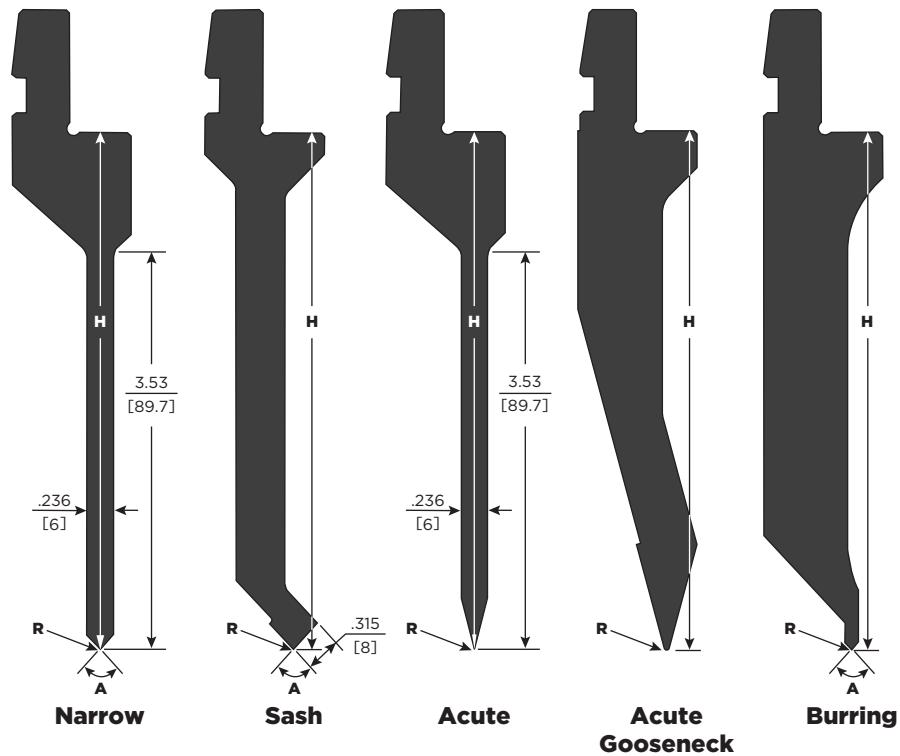
FIXED HEIGHT TOOLING

Punch Style	Part No.	A Angle	Tip Radius inch [mm]	Height inch [mm]	L & S	X	Weight lbs./inch [kg/mm]	L	S	X	100
					Max. Ton feet [m]	32.87" [835mm]		20.08" [510mm]	14.6" [370mm]	3.93" [100mm]	
120mm TALL PUNCHES W/ BEVELED TANG (FIXED HEIGHT)											
Standard	A0402	86°	.008 [0.2]	4.724 [120]	30 [100]	12 [40]	1.29 [.023]				
	A0406		.024 [0.6]	4.717 [119.8]							
	A0415		.060 [1.5]	4.701 [119.4]							
	A0423		.090 [2.3]	4.686 [119]							
	A1602	90°	.008 [0.2]	4.724 [120]							
	A5501	84°	.118 [3]	4.670 [118.6]							
Thin	A6021	86°	.008 [0.2]	4.724 [120]	15 [50]	7 [23]	.99 [018]				
	A6061		.024 [0.6]	4.717 [119.8]							
Gooseneck	A4702	86°	.008 [0.2]	4.724 [120]	15 [50]	12 [40]	.192 [.034]				
	A4706		.024 [0.6]	4.717 [119.8]							
	A4731		.060 [1.5]	4.701 [119.4]							
	A4733		.090 [2.3]	4.686 [119.0]							
	A4735	.118 [3]	4.373 [118.7]								
	A4802	90°	.008 [0.2]	4.724 [120]							
Thin	A3021	86°	.008 [0.2]	4.724 [120]	10.5 [35]	9 [30]	1.62 [.029]				
	A3061		.024 [0.6]	4.717 [119.8]							

= 30 lbs. / 13.6kg or more



120mm TALL PUNCHES — FIXED HEIGHT

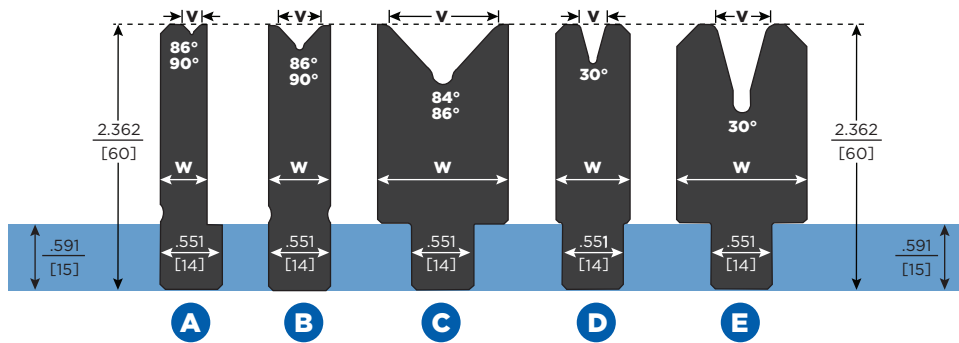


Punch Style	Part No.	A Angle	Tip Radius inch [mm]	Height inch [mm]	L & S	X	Weight lbs./inch [kg/mm]	L	S	X	100
					Max. Ton feet [m]	32.87" [835mm]		20.08" [510mm]	14.6" [370mm]	3.93" [100mm]	
120mm TALL PUNCHES W/ BEVELED TANG (FIXED HEIGHT)											
Narrow	A1902	86°	.008 [0.2]	4.724 [120]	15 [50]	7 [23]	.086 [.015]				
	A1906		.024 [0.6]	4.717 [119.8]							
	A1802	90°	.008 [0.2]	4.724 [120]							
Sash	A2002	86°	.008 [0.2]	4.724 [120]	15 [50]	7 [23]	.086 [.015]				
	A2006		.024 [0.6]	4.717 [119.8]							
	A2102	90°	.008 [0.2]	4.724 [120]							
Acute	A1302	30°	.008 [0.2]	4.724 [120]	15 [50]	7 [23]	.086 [.015]				
	A1306		.024 [0.6]	4.717 [119.8]							
Acute Gooseneck	A0061	30°	.024 [0.6]	4.717 [119.8]	30 [100]	9 [30]	.95 [.017]				
Burring	A0502	86°	.008 [0.2]	4.724 [120]	15 [50]	7 [23]	1.29 [.023]				
	A0506		.024 [0.6]	4.717 [119.8]							
	A1702	90°	.008 [0.2]	4.724 [120]							

M Made To Order

= 30 lbs. / 13.6kg or more

ACUTE & BLOCK DIES



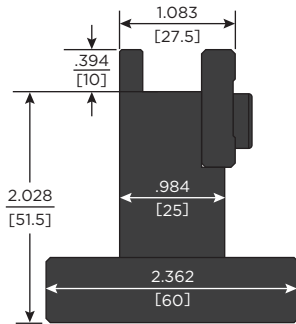
FIXED HEIGHT TOOLING

Part No.	Angle	V Opening inch [mm]	W Width inch [mm]	Max. Ton feet [m]	Weight lbs./inch [kg/mm]	L 32.87" [835mm]	S 20.08" [510mm]	X 14.57" [370mm]	100 3.93" [100mm]
86°, 84° & 90° DIES (FIXED HEIGHT)									
A	A8406	.157 [4]	.394 [10.0]	26 [87]	0.33 [.006]				
	A8506	.197 [5]	.413 [10.5]						
	A7006	.236 [6]	.433 [11.0]						
	A8606	.276 [7]	.453 [11.5]						
	A7106	.315 [8]	.472 [12.0]						
B	A7206	.394 [10]	.551 [14.0]	30 [100]	0.51 [.009]				
	A7406	.472 [12]	.630 [16.0]						
	A7606	.551 [14]	.709 [18.0]						
	A7706	.630 [16]	.787 [20.0]						
	A7806	.709 [18]	.866 [22.0]						
C	A7906	.787 [20]	.961 [24.4]						
C	A8206	.984 [25]	1.161 [29.5]		0.70 [.012]				
	A5320	1.260 [32]	1.496 [38.0]	30 [100]	0.71 [.013]				
	A5400	1.575 [40]	1.614 [41.0]		0.79 [.014]				
A	A8409	.157 [4]	.413 [10.5]	26 [87]	0.33 [.006]				
	A8509	.197 [5]	.433 [11.0]						
	A7009	.236 [6]	.453 [11.5]						
	A8609	.276 [7]	.472 [12.0]						
	A7109	.315 [8]	.492 [12.5]						
B	A7209	.394 [10]	.551 [14.0]	30 [100]	0.33 [.006]				
	A7409	.472 [12]	.630 [16.0]		0.51 [.009]				
30° DIES (FIXED HEIGHT)									
D	A8403	.157 [4]	.551 [14.0]	5 [17]	0.33 [.006]				
	A7003	.236 [6]	.669 [17.0]	6 [20]	0.51 [.009]				
	A7103	.315 [8]	.787 [20.0]						
E	A7203	.394 [10]	.984 [25.0]	8 [26]					
	A7403	.472 [12]	1.811 [30.0]	9 [30]					

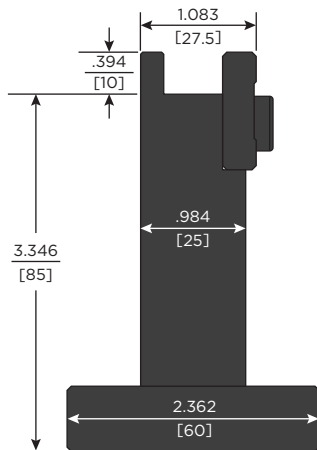
M Made To Order




TV DIE HOLDERS



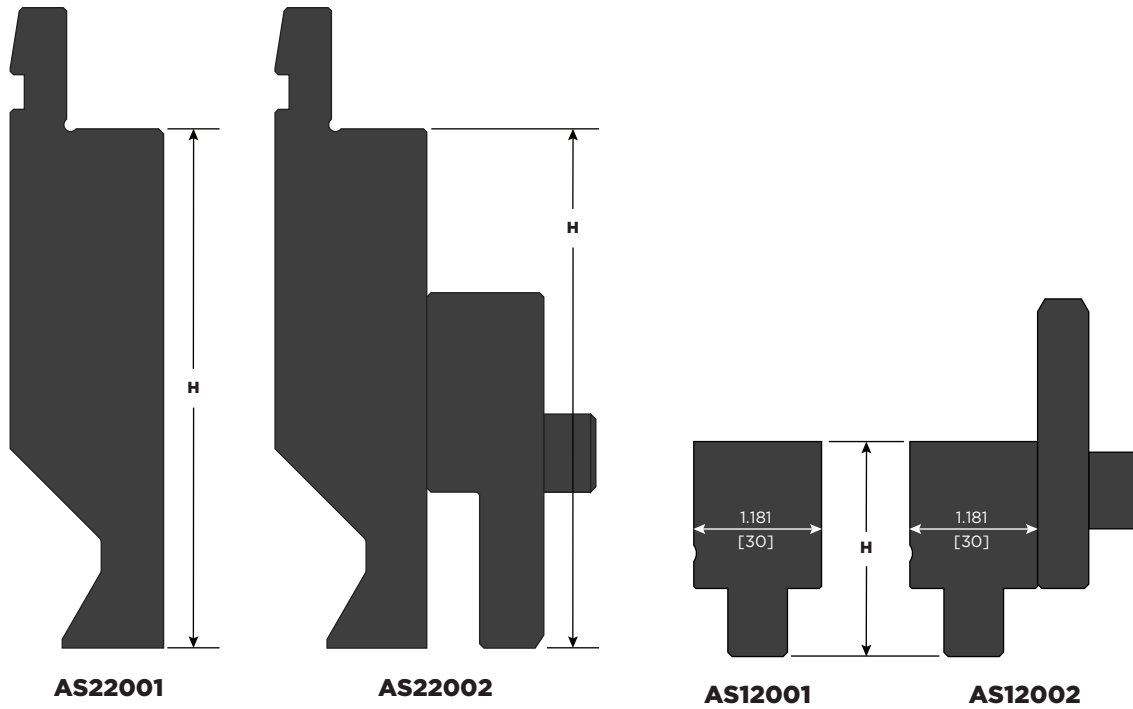
Part No.	Max. Ton feet [m]	Weight lbs./inch [kg/mm]	L 33.07" [840mm]	S 16.54" [420mm]
A8150	30 [100]	0.72 [.004]		








Part No.	Max. Ton feet [m]	Weight lbs./inch [kg/mm]	L 33.07" [840mm]	S 16.54" [420mm]
A8160	30 [100]	1.5 [.026]		

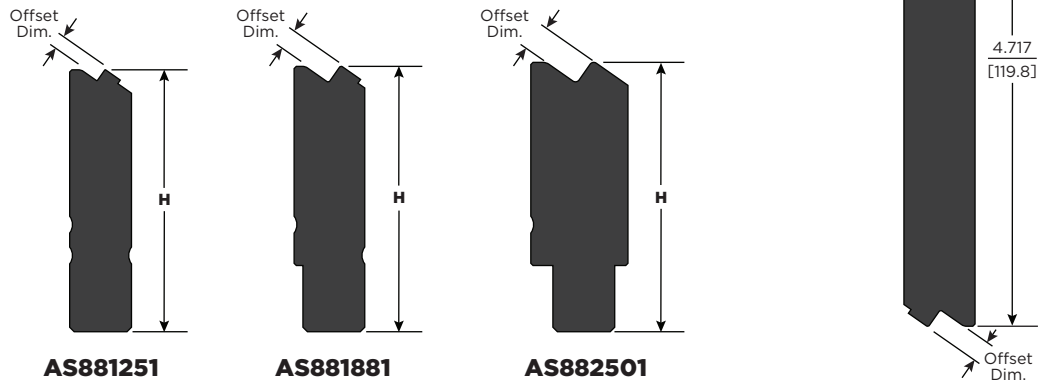
FIXED HEIGHT TOOLING


FLATTENING PUNCHES & DIES


FIXED HEIGHT TOOLING

Part No.	Max. Ton feet [m]	H Height inch [mm]	Weight lbs./inch [kg/mm]	L	S	X
				32.87" [835mm]	20.08" [510mm]	14.57" [370mm]
FLATTENING PUNCHES (COMMON SHUT HEIGHT)						
AS22001 (punch only)	30 [100]	4.717 [119.8]	1.72 [.031]			
AS22002 (punch and thrust plate)			2.43 [.043]			
FLATTENING DIES (COMMON SHUT HEIGHT)						
AS12001 (punch only)	30 [100]	1.988 [50.0]	.56 [.010]			
AS12002 (punch and thrust plate)			.91 [.016]			

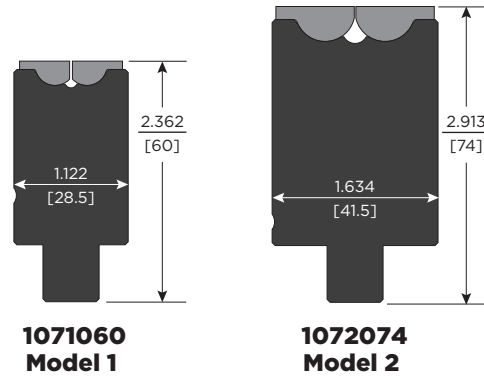
OFFSET PUNCH & DIE SETS



Part No.	Max. Ton feet [m]	H Height inch [mm]	Angle	Offset Dim. inch [mm]	Effective V	Weight lbs./inch [kg/mm]	L	S	X
							32.87" [835mm]	20.08" [510mm]	14.57" [370mm]
90° OFFSET PUNCH & DIE SETS (COMMON SHUT HEIGHT)									
AS881251	40 [133]	2.336 [59.33]	90°	.125 [3.0]	.177 [4.5]	1.39 [.029]			
AS881881		2.367 [60.11]		.188 [4.7]	.266 [6.8]	1.50 [.027]			
AS882501		2.402 [61.02]		.250 [6.4]	.354 [9.0]	1.56 [.028]			

FIXED HEIGHT TOOLING

V-SERIES BLACK (VSB) DIES



Scan QR Code to Watch the Video

FIXED HEIGHT TOOLING

MODEL 1	SOLID		X1	X2
Length	9.84" [250mm]	19.68" [500mm]	10.83" [275mm]	10.83" [275mm]
Height	2.36" [60mm]	2.36" [60mm]	2.36" [60mm]	2.36" [60mm]
Assembly Part No.	1071060-250	1071060-500	1071060 x 1	1071060 x 2
Spring	(20 qty.) 980682	(40 qty.) 980682	(22 qty.) 980682	(22 qty.) 980682
Weight	5.8 lbs. [2.62kg]	11.7 lbs. [5.31kg]	6.4 lbs. [2.9kg]	6.4 lbs. [2.9kg]
Price				
Insert Part No.	(2) 980872A	(4) 980872A	987158	987159

MODEL 2	SOLID		X1	X2
Length	9.84" [250mm]	19.68" [500mm]	10.83" [275mm]	10.83" [275mm]
Height	2.91" [74mm]	2.91" [74mm]	2.91" [74mm]	2.91" [74mm]
Assembly Part No.	1072074-250	1072074-500	1072074 x 1	1072074 x 2
Spring	(20 qty.) 980683	(40 qty.) 980683	(22 qty.) 980683	(22 qty.) 980683
Weight	8.0 lbs. [3.65kg]	16.1 lbs. [7.32kg]	8.8 lbs. [3.97kg]	8.8 lbs. [3.97kg]
Price				
Insert Part No.	(2) 980948	(4 qty.) 980948	987160	987161

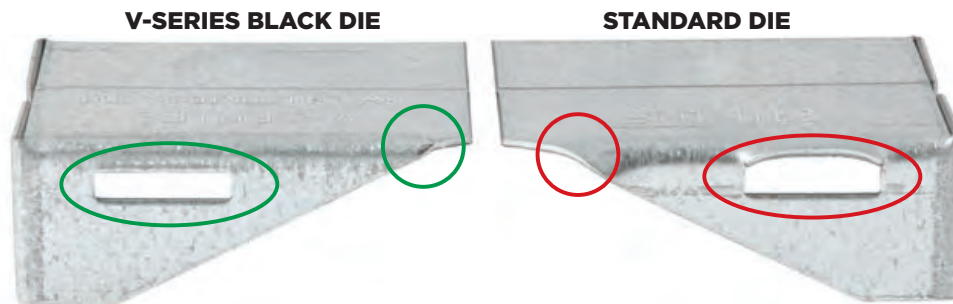
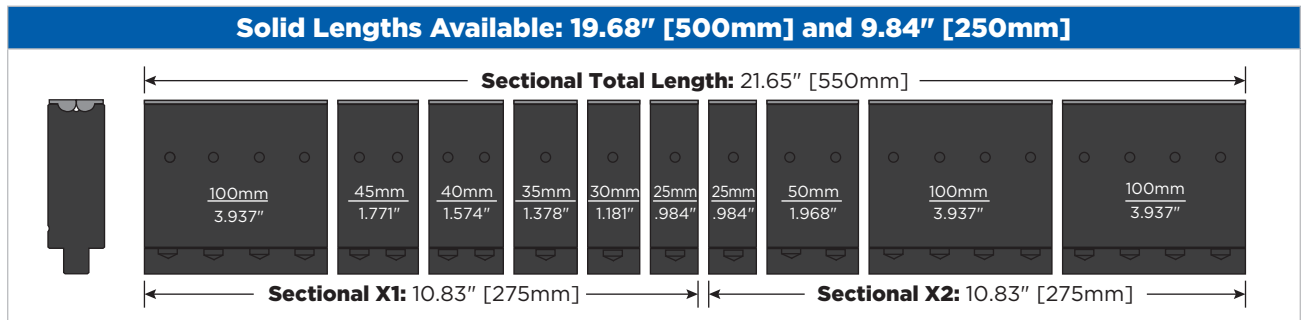
INSTALLATION TOOLS		
Description	Part No.	Price
Spring Installation Tool Kit	981002	
Spring Extension Wire (short)	981003	
Spring Extension Wire (long)	981004	



V-SERIES BLACK (VSB) DIES

Model	Material Thickness inch [mm]	Min. Outside Flange inch [mm]	Ton feet	Min. Angle	Punch Tip Required to Achieve Angle	Max. OR Radius @ Min. Angle inch [mm]	Max. OR Radius @ 90° inch [mm]	Tonnage Cap/Ft.	T/M	kN/M
V-SERIES BLACK (VSB) SPECIFICATIONS										
1	.018 [.45]	.118 [3.0]	1.8	34°	.054	.125 [3.17]	.175 [4.45]	38	112	1100
	.020 [.50]		1.8		.052					
	.024 [.60]		2		.047					
	.032 [.80]		2.5		.036					
	.035 [.90]	3.3	.031							
	.040 [1.0]	4								
	.048 [1.2]	5.8								
	.059 [1.5]	9								
2	.075 [1.9]	.335 [8.5]	7	42°	.122	.216 [5.5]	.354 [9.0]	57	168	1650
	.105 [2.7]	.347 [8.8]	13		.112					
	.118 [3.0]	.366 [9.3]	19		.099					
	.126 [3.2]		22	.091						
	.134 [3.4]		25	55°	.082					

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]	

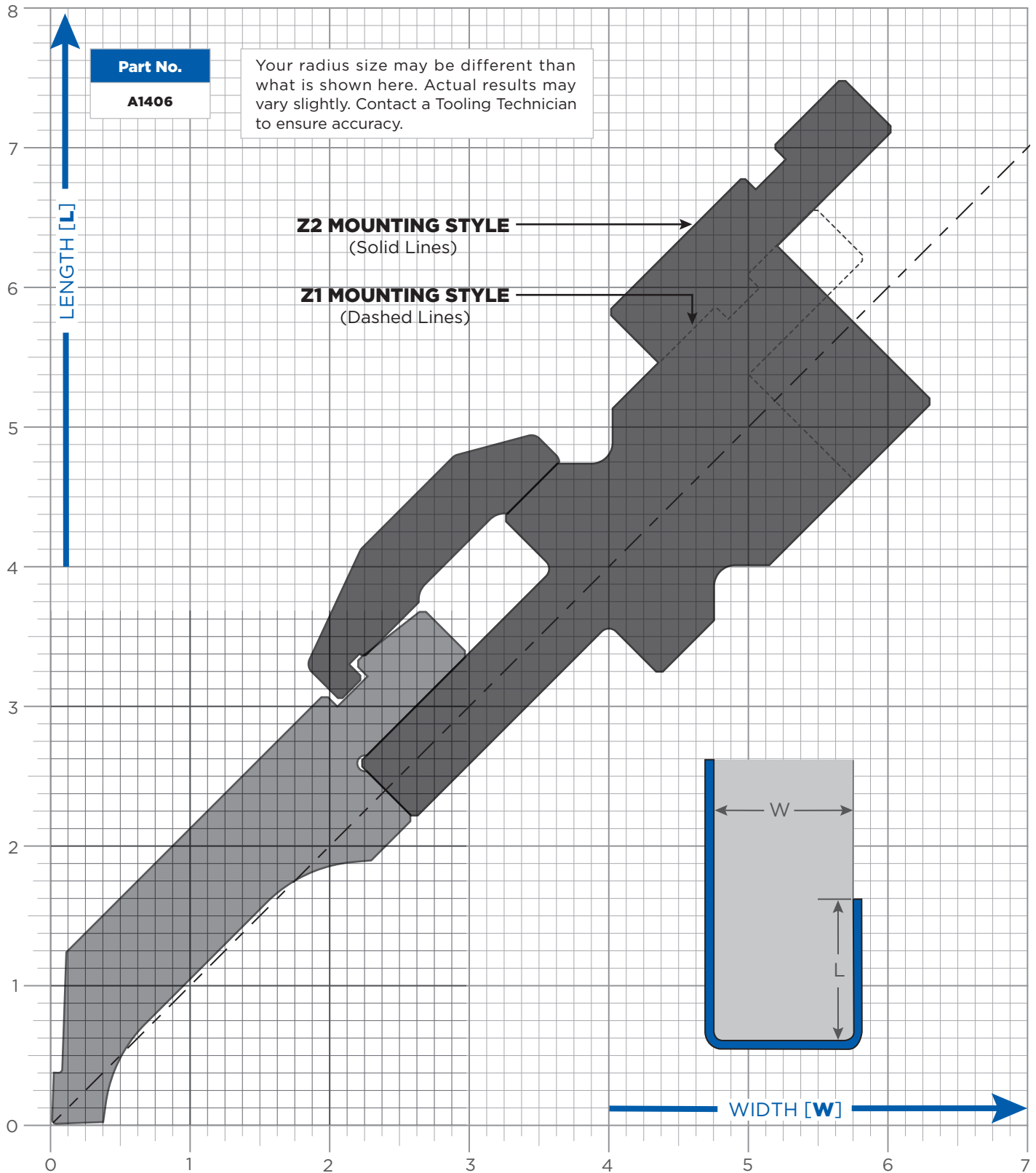


FIXED HEIGHT TOOLING

STANDARD PUNCH (FIXED HEIGHT)

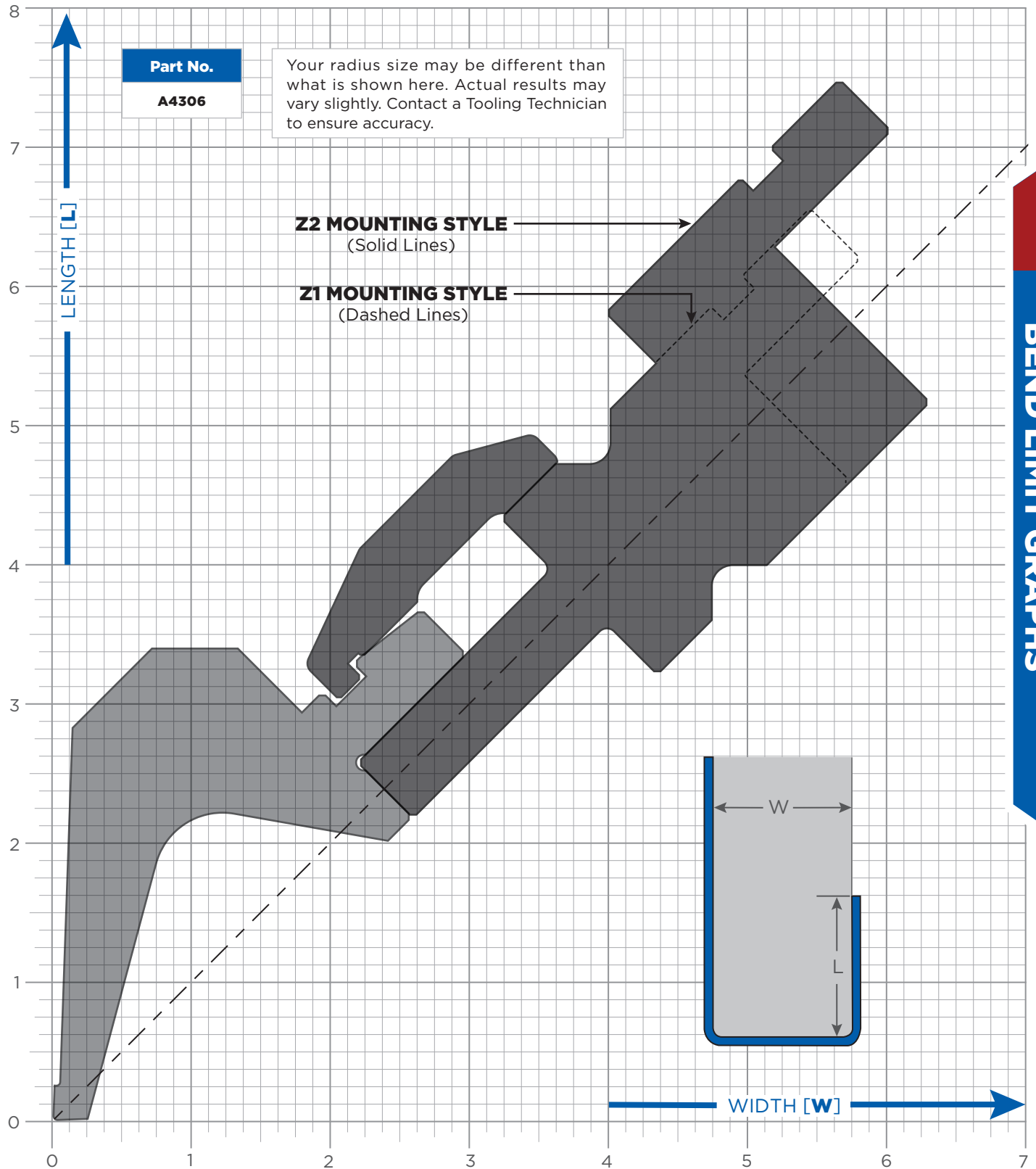
86°

BEND LIMIT GRAPHS



GOOSENECK PUNCH (FIXED HEIGHT)

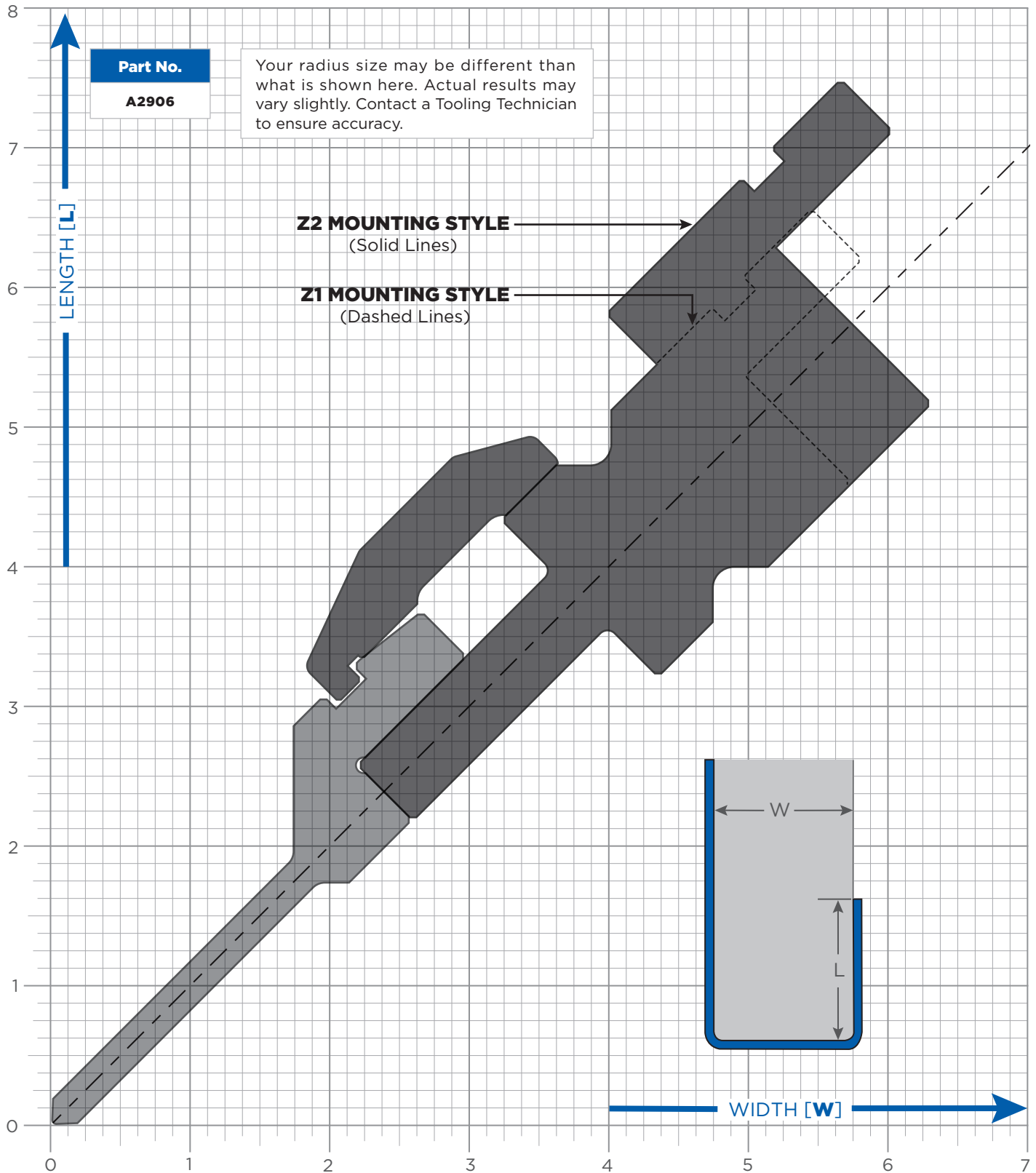
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NARROW PUNCH (FIXED HEIGHT)

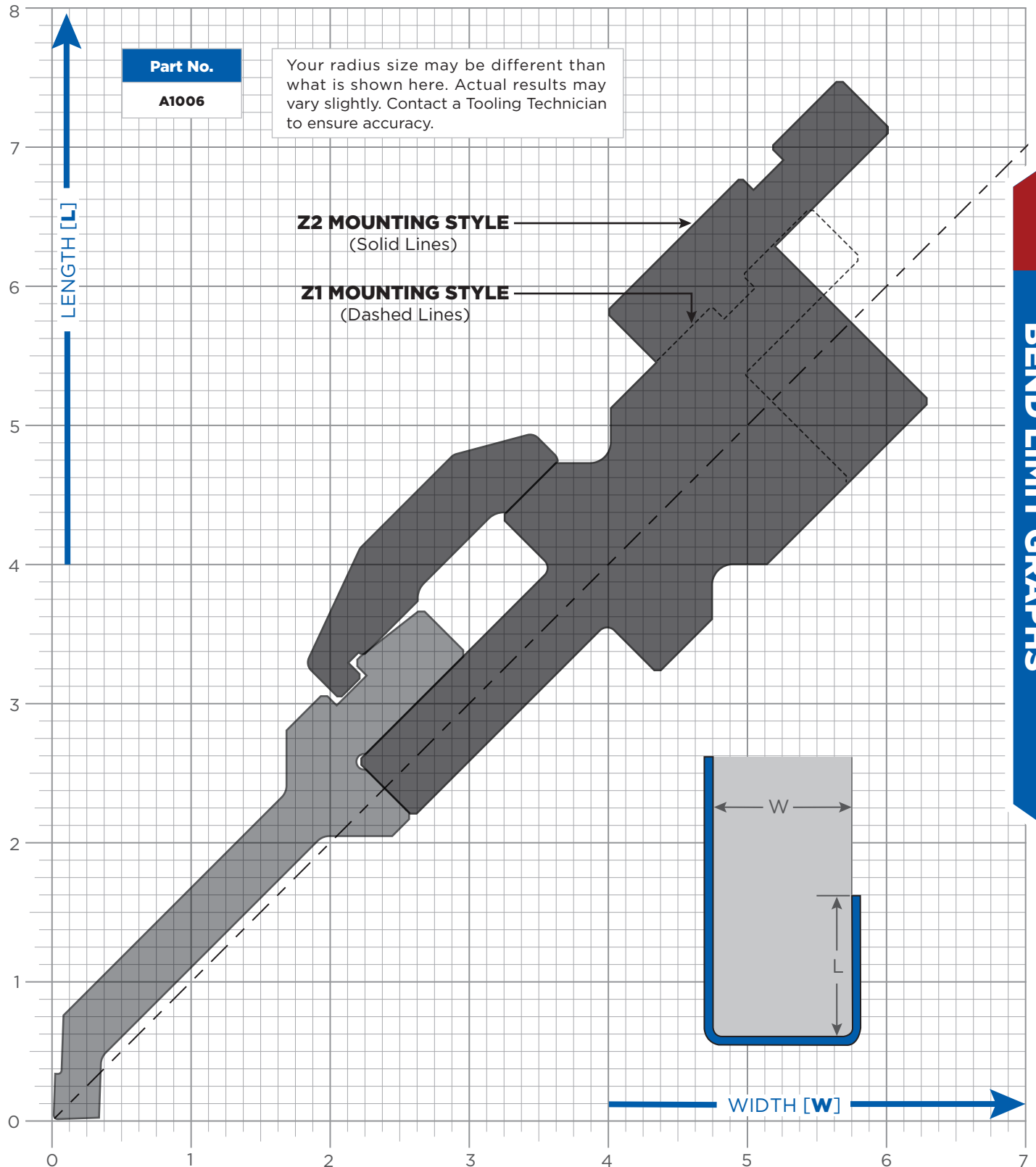
30°

BEND LIMIT GRAPHS



SASH PUNCH (FIXED HEIGHT)

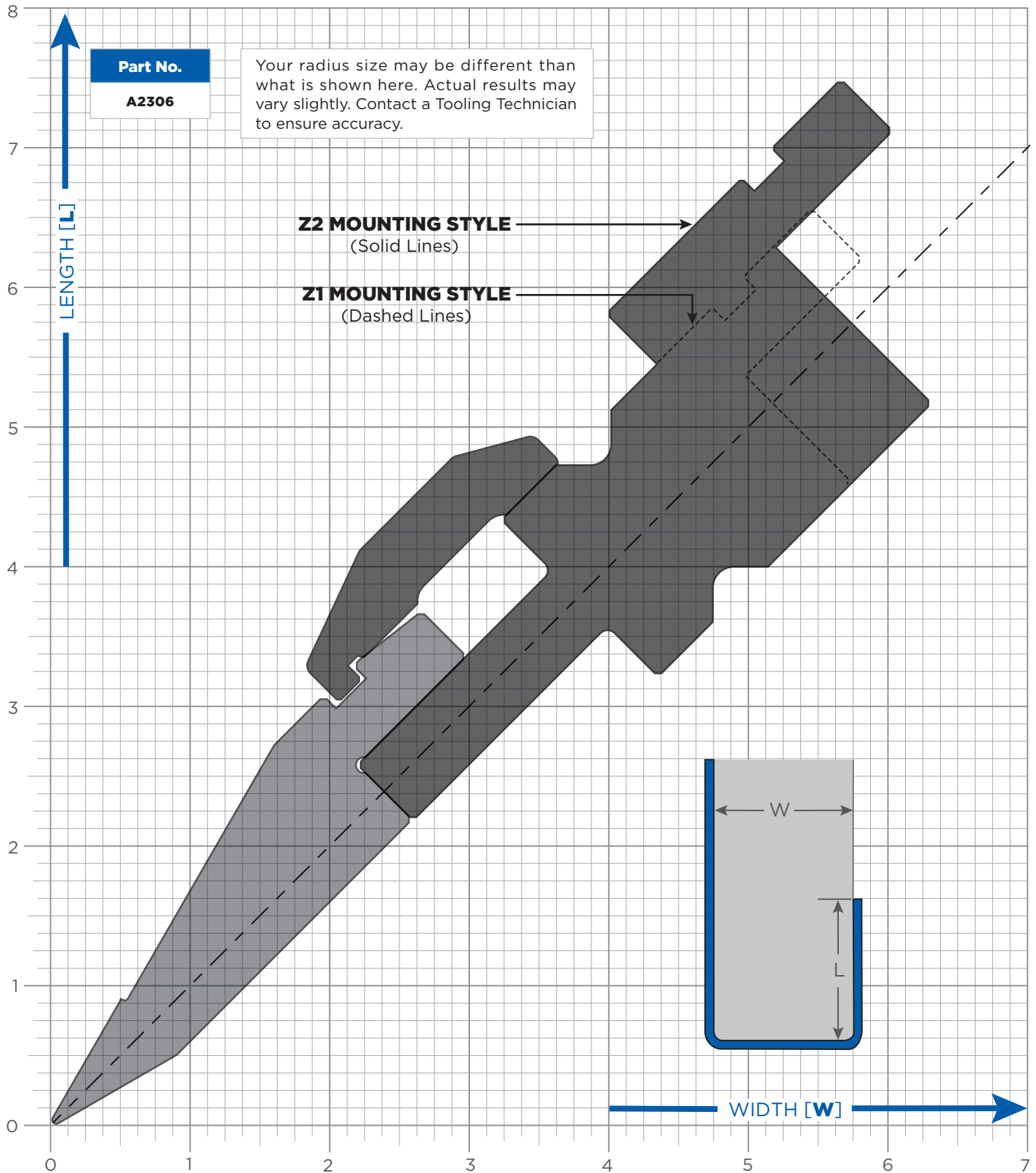
86°



ACUTE PUNCH (FIXED HEIGHT)

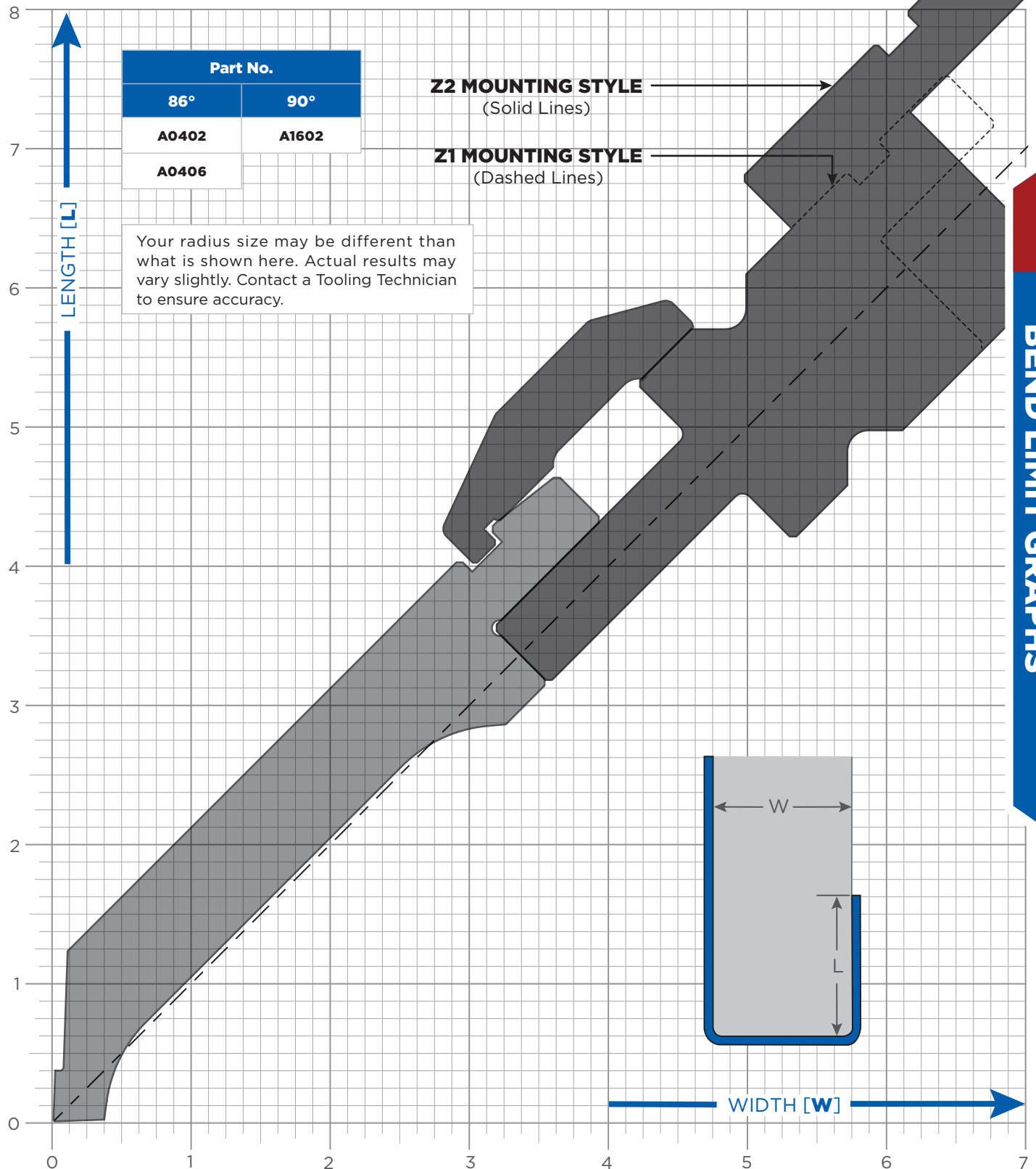
30°

BEND LIMIT GRAPHS



STANDARD PUNCH (FIXED HEIGHT)

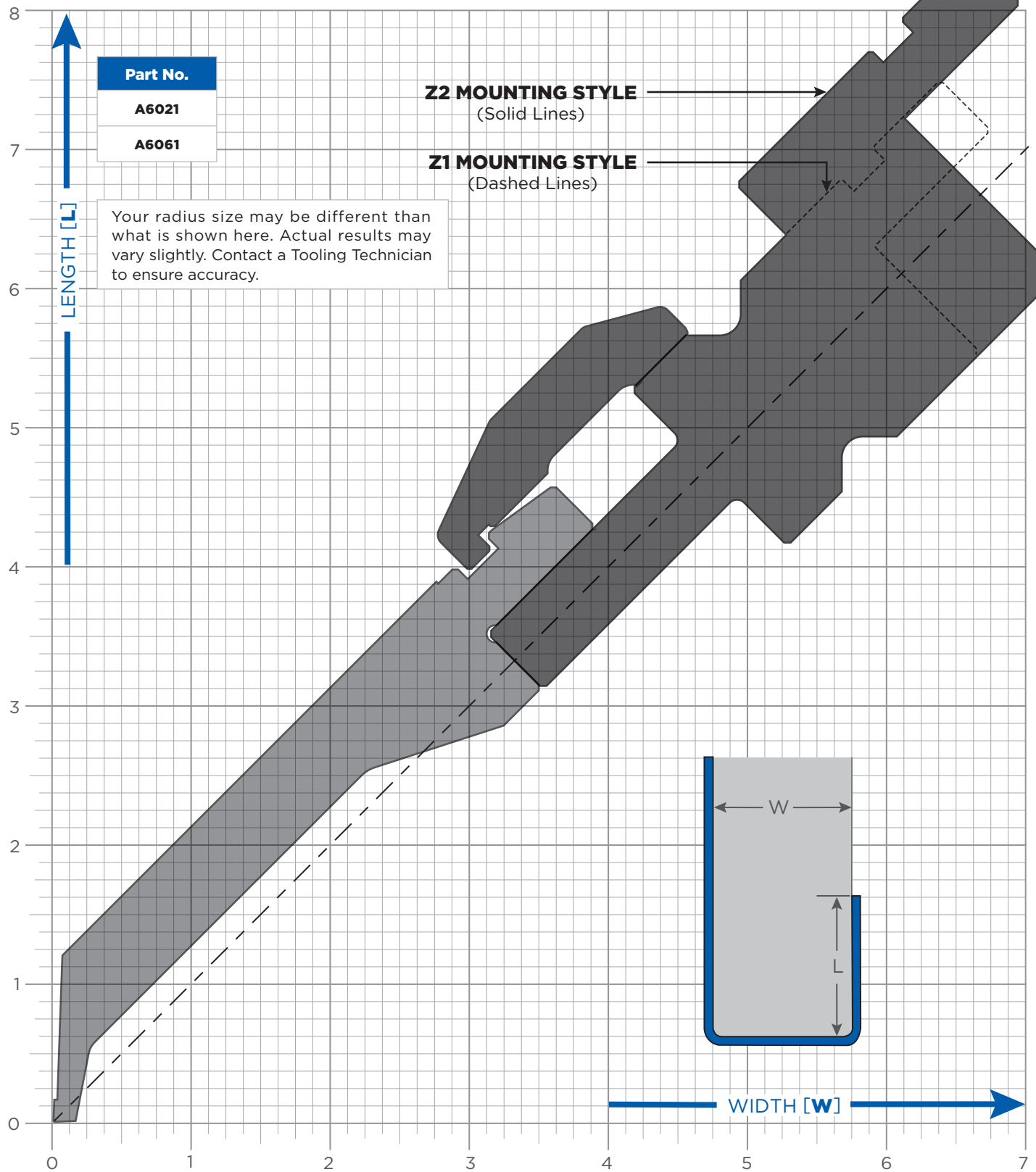
86° & 90°



STANDARD THIN TIP PUNCH (FIXED HEIGHT)

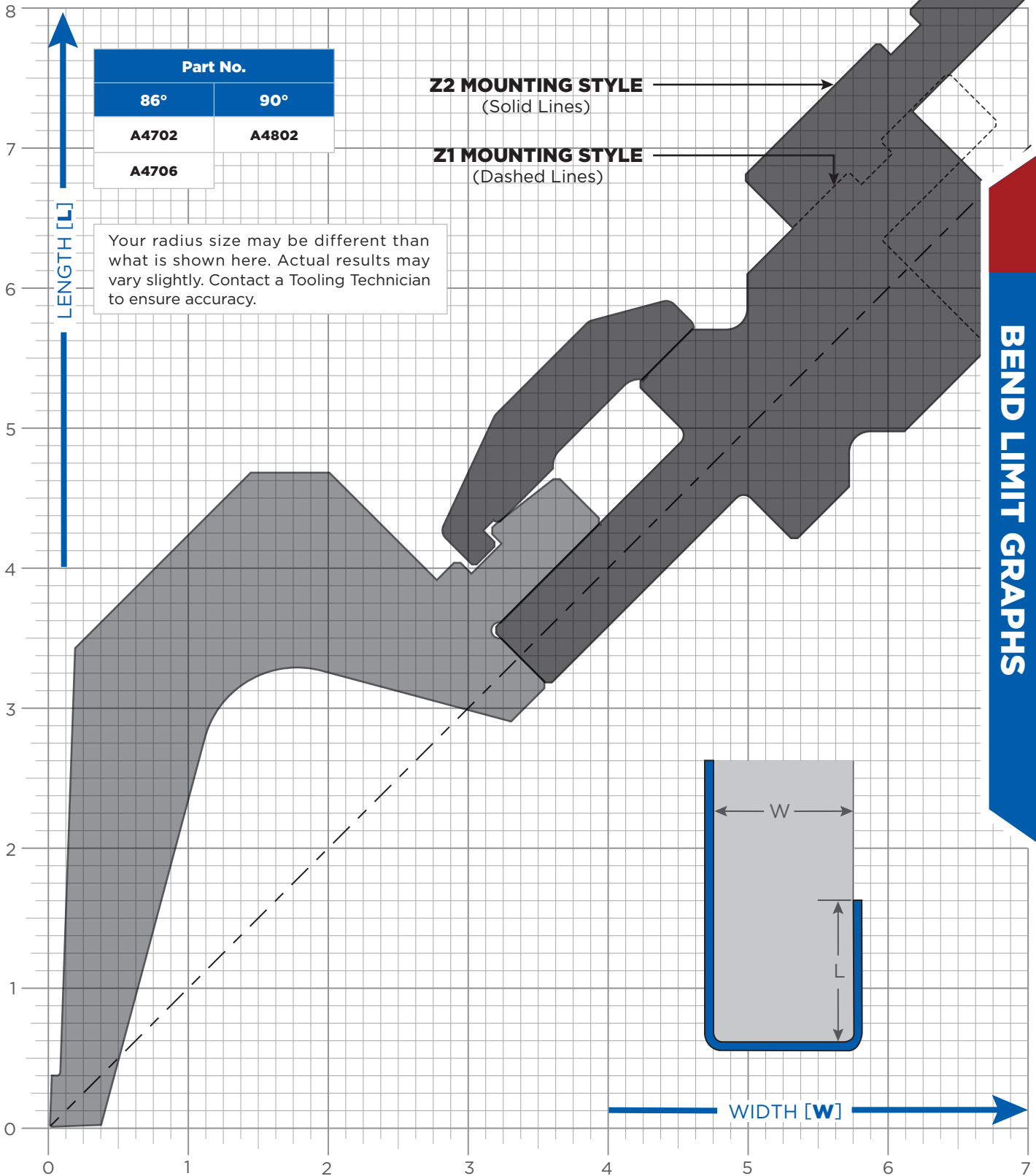
86°

BEND LIMIT GRAPHS



GOOSENECK PUNCH (FIXED HEIGHT)

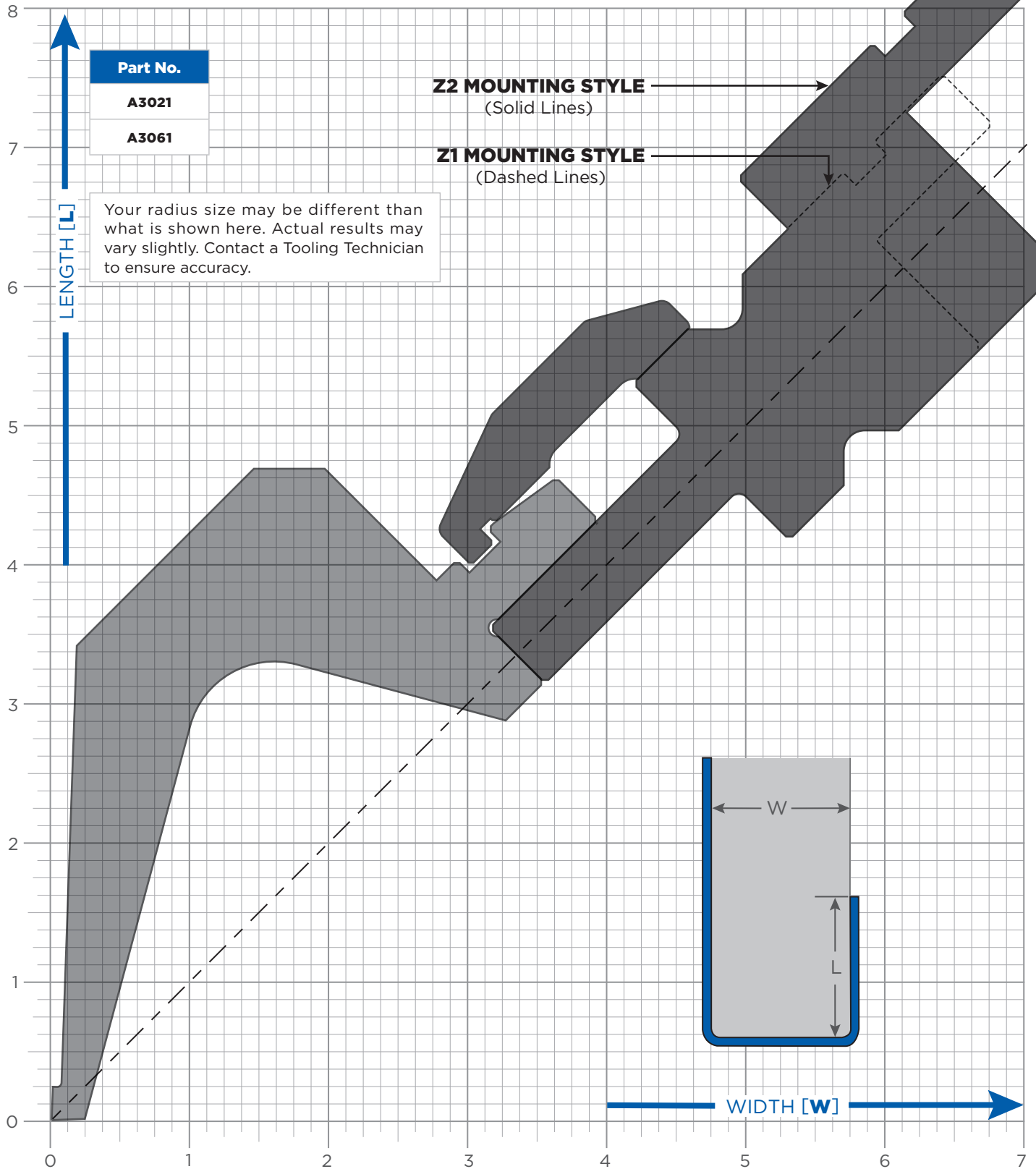
86° & 90°



GOOSENECK THIN TIP PUNCH (FIXED HEIGHT)

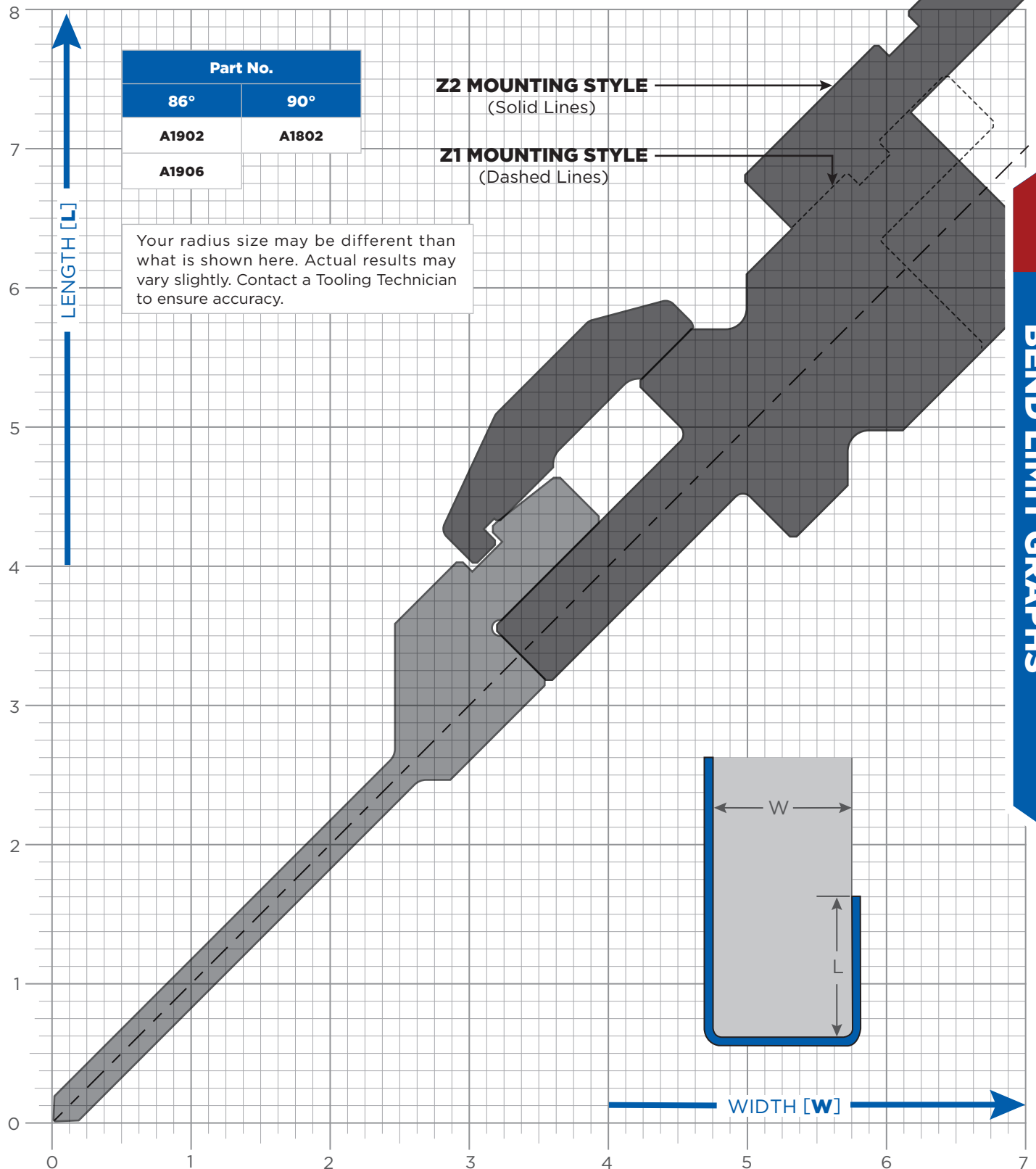
86°

BEND LIMIT GRAPHS



NARROW PUNCH (FIXED HEIGHT)

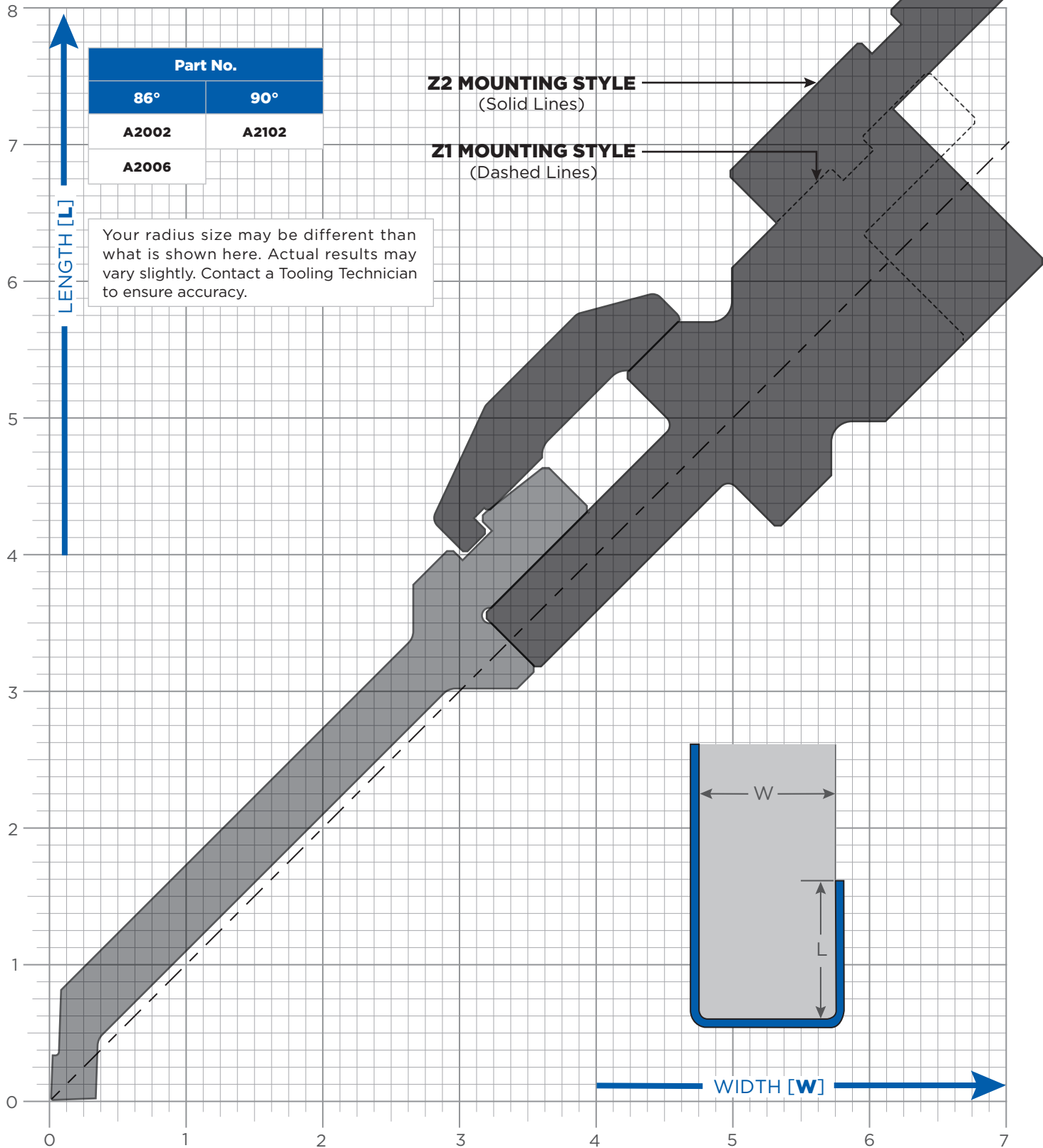
86° & 90°



SASH PUNCH (FIXED HEIGHT)

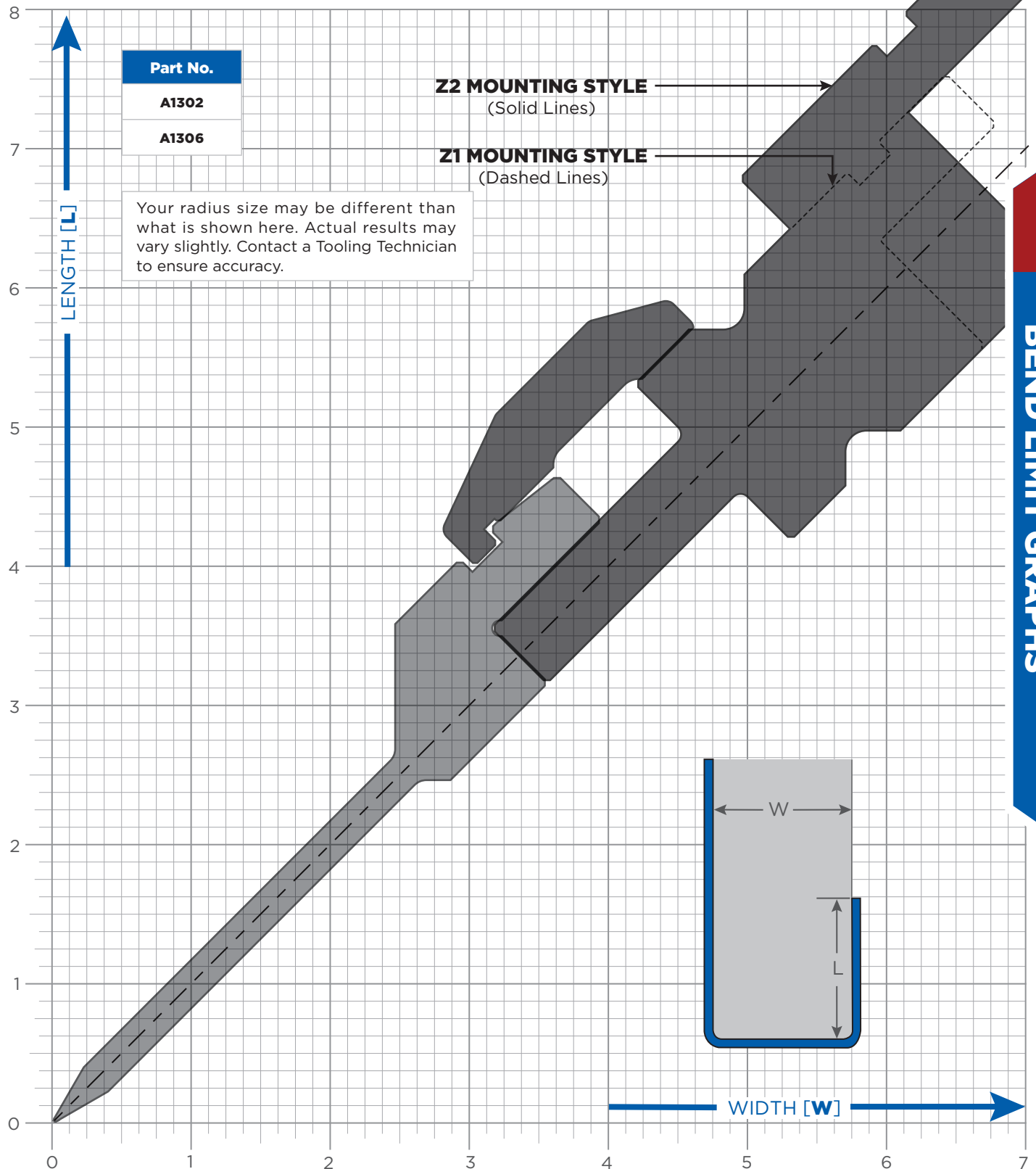
86° & 90°

BEND LIMIT GRAPHS



ACUTE PUNCH (FIXED HEIGHT)

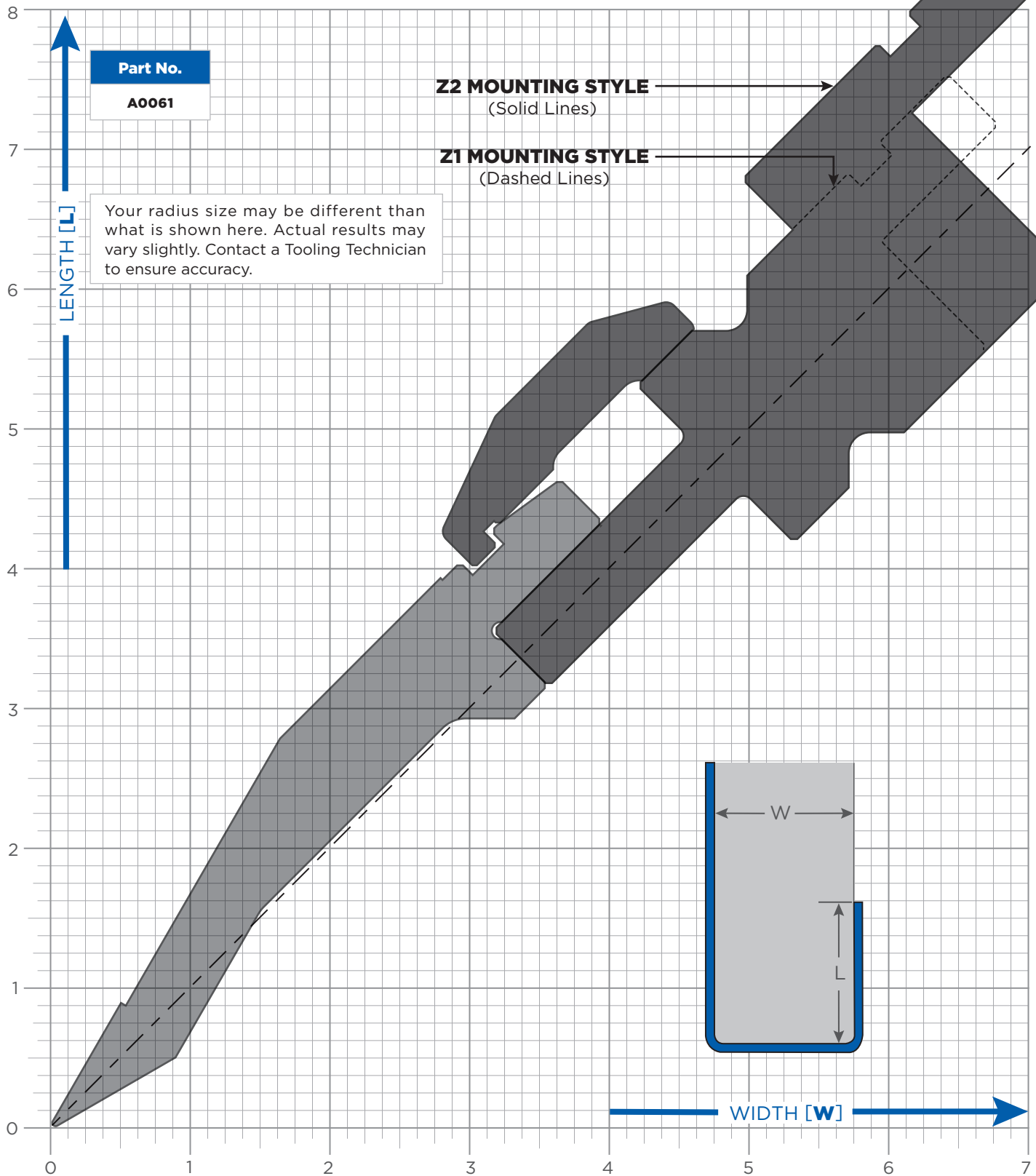
30°



ACUTE GOOSENECK PUNCH (FIXED HEIGHT)

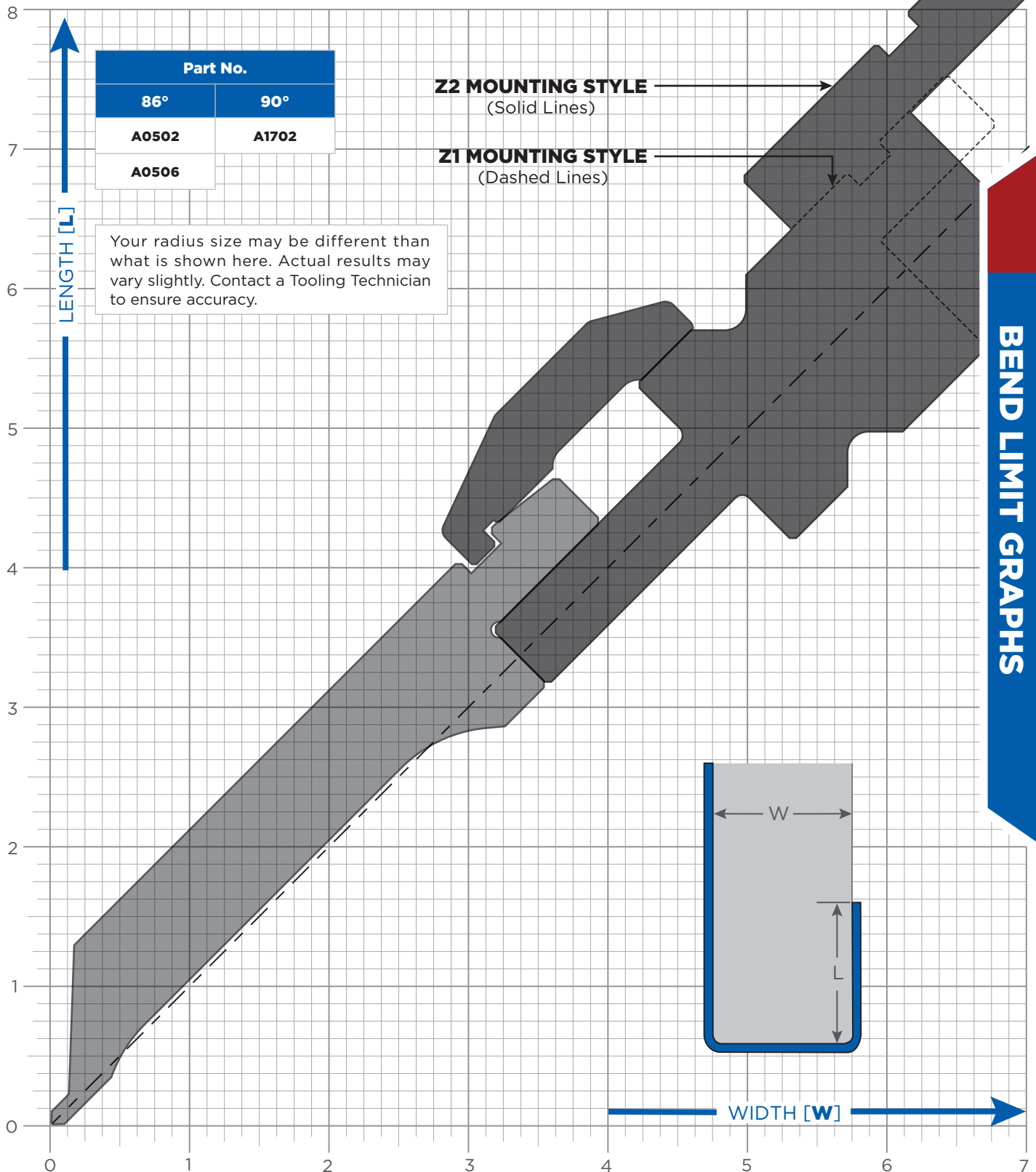
30°

BEND LIMIT GRAPHS



BURRING PUNCH (FIXED HEIGHT)

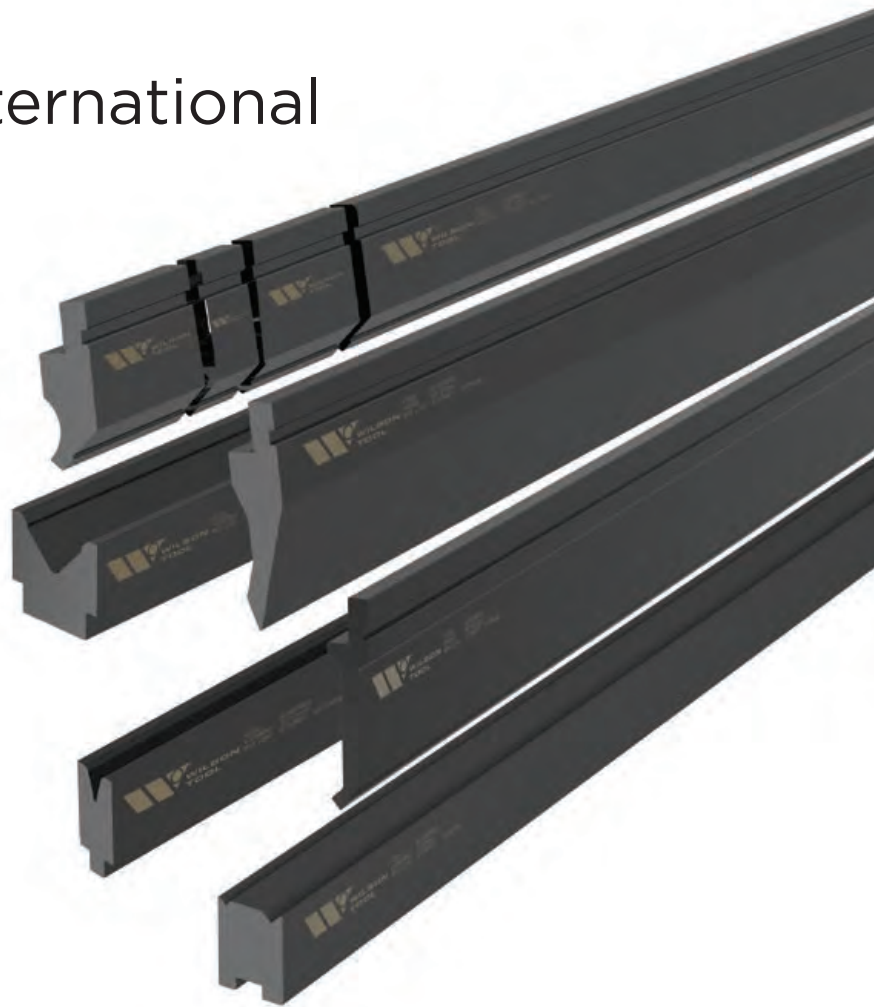
86° & 90°



EUROPEAN STANDARD TOOLING

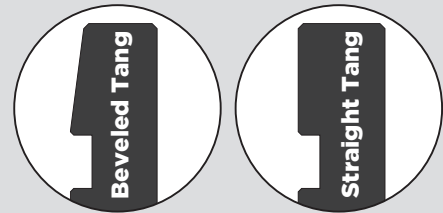
STOCKED AND READY FOR
SAME-DAY DELIVERY

Let Wilson Tool International support all of your European-Style Tooling needs with exact match **STANDARD PUNCH & DIE PROFILES** and a lead time that tops the industry!



EUROPEAN TRADITIONAL

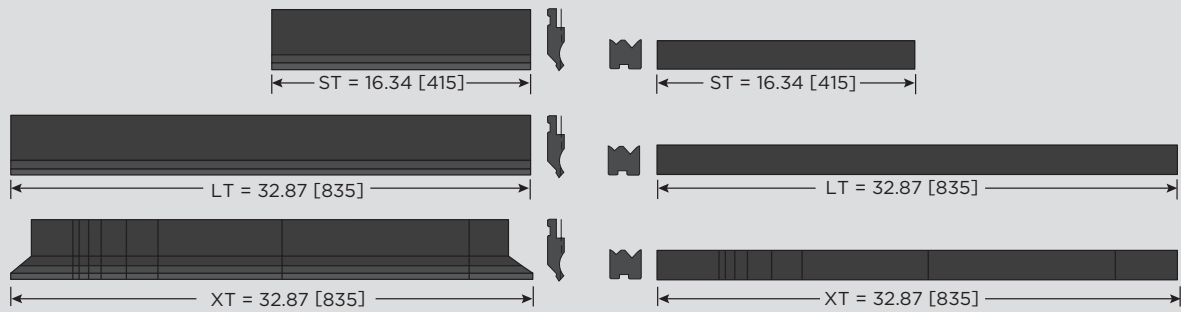
European Traditional Tooling has two main die styles that include 1V and quick change 2V dies. Both are offered with a holder that allows alignment-free changeover and no extra fastening step.



Punches are commonly loaded into a segmented holder. This allows for shorter punches to be used for box bending since the punch holder creates space for the part, and also increases the height of the punch. Operators like European Traditional Tooling because they get to handle a smaller, lighter punch. All punches are available with a straight or beveled tang.

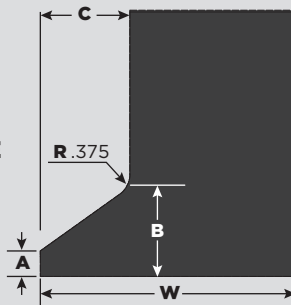
Our European Traditional Tooling is precision ground, and comes in sectionalized punches with "ear pieces" for box bending. Tooling is heat-treated for optimal life and durability, laser marked for easy identification, and available "staged" so you don't need to add shims or risers to make your tooling close at the same height.

PUNCH AND DIE LENGTHS



SPECIAL EAR PIECE

When ordering a special ear section, indicate these dimensions:



SECTION WIDTHS

- .394" (10mm)
- .591" (15mm)
- .787" (20mm)
- 1.575" (40mm)
- 1.969" (50mm)
- 3.937" (100mm) Left Ear
- 3.937" (100mm) Right Ear
- 7.874" (200mm)
- 11.811" (300mm)

EUROPEAN TRADITIONAL

EXPRESS CLAMPS

- Clamps and seats punches with straight or beveled tangs
- Height compatible with OEM punch holders
- Gap the holders as traditionally used or push together to create a solid upper beam
- Simultaneous front and back clamping means tools can be loaded front and back at the same time
- If clamp plates are in the way, pop clamp plates off with the palm of your hand
- No more loose punches - the serrated fingers on each clamp plate securely clamps small sections

Clamp & Seat Beveled Tangs	Clamp & Seat Straight Tangs

	Clamp Plates	Height	Part No.	Price	Part No.	Price
American Press Brake w/Wedge and Grooved Mounting Tang	2 Front	100mm	43815igb-2		43815igs-2	
	2 Front 2 Back		43815igb		43815igs	
American Press Brake w/Wedge	2 Front	100mm	43815ib-2		43815is-2	
	2 Front 2 Back		43815ib		43815is	
Z1 Series w/Wedge	2 Front	100mm	43817ib-2		43817is-2	
	2 Front 2 Back		43817ib		43817is	
Z2 Series w/Wedge	2 Front	120mm	43818ib-2		43818is-2	
	2 Front 2 Back		43818ib		43818is	
Trumpf-Style Press Brake w/Wedge	2 Front	140mm	43819ib-2		43819is-2	
	2 Front 2 Back		43819ib		43819is	

EUROPEAN TRADITIONAL



Space holders in press brake with a traditional gap or interlock them to make a solid upper beam.

Scan QR Code to Watch the Video





Add Express Clamps to your press brake wherever you need more efficiency. Holders are height compatible with OEM holders and can be placed in the middle of the press brake.

AMERICAN PRESS BRAKE W/WEDGE

43815is

Z1 SERIES W/WEDGE

43817is

Z2 SERIES W/WEDGE

43818is

TRUMPF-STYLE PRESS BRAKE W/WEDGE

43819is

Handles are easily removed to reduce interference.

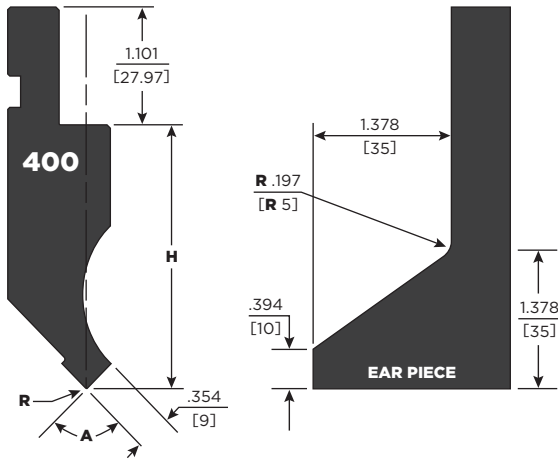


Part No.	Description	Price
REPLACEMENT COMPONENTS		
A	43812b Beveled Self-Seating Assembly	
	43812s Straight Self-Seating Assembly	
B	43726 Pivot (2)	
C	43732 Spring (6)	
	8018240 Beveled Self-Seating Label	—
	8018239 Straight Self-Seating Label	—
HANDLE ASSEMBLY		
D	43020 Handle Assembly	
E	43727 Shaft Socket	
F	43734 O-Ring	

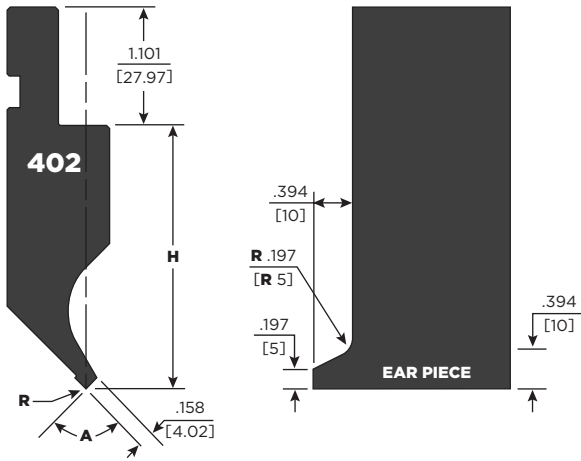
Part No.	Description	Price
EXPRESS CLAMP TORQUE WRENCH KIT		
8002	Complete Kit Includes: Case, 2 Pivots, Wrench, 2 Hex Tips	
KIT COMPONENTS		
8003	Case	
43726	Pivot (2)	
6793	Wrench	
6795	Hex Tip (2)	

EUROPEAN TRADITIONAL

88° & 90° STANDARD TIP



88° & 90° THIN TIP



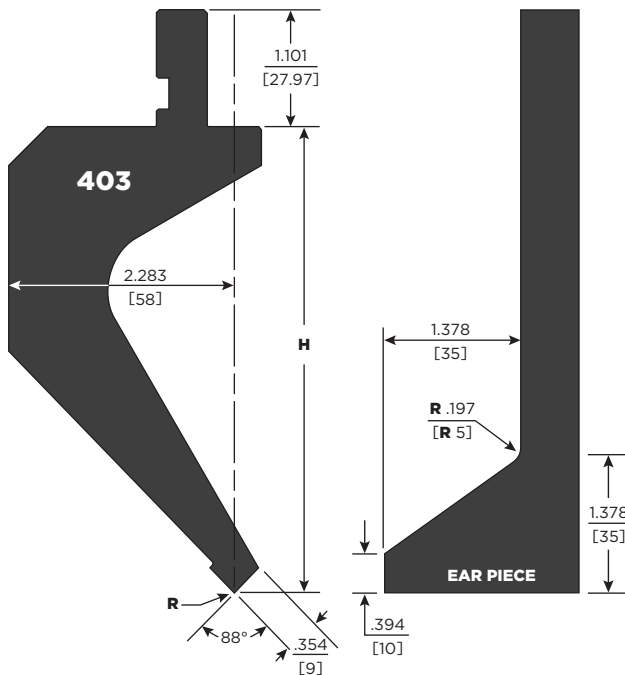
Part No.		A Angle	R Tip Radius inch [mm]	H Height inch [mm]	LT & ST	XT	Weight lbs./inch [kg/mm]	LT	ST	XT
Straight	Beveled				Max. Ton feet [m]	32.87" [835mm]		16.34" [415mm]	32.87" [835mm]	
400 SERIES – 88° STANDARD TIP PUNCHES										
40002	40002B	88°	.008 [0.2]	2.634 [66.9]	30 [100]	14 [47]	.86 [.015]			
40008	40008B		.030 [0.8]	2.624 [66.6]						
40015	40015B		.060 [1.5]	2.612 [66.3]						
40023	40023B		.090 [2.3]	2.598 [66.0]						
40030	40030B		.120 [3.0]	2.586 [65.7]						
400 SERIES – 90° STANDARD TIP PUNCHES										
40102	40102B	90°	.008 [0.2]	2.634 [66.9]	30 [100]	14 [47]	.86 [.015]			
40108	40108B		.030 [0.8]	2.624 [66.7]						
40115	40115B		.060 [1.5]	2.613 [66.4]						
40123	40123B		.090 [2.3]	2.600 [66.0]						
40130	40130B		.120 [3.0]	2.588 [65.7]						

Part No.		A Angle	R Tip Radius inch [mm]	H Height inch [mm]	LT & ST	XT	Weight lbs./inch [kg/mm]	LT	ST	XT
Straight	Beveled				Max. Ton feet [m]	32.87" [835mm]		16.34" [415mm]	32.87" [835mm]	
402 SERIES – 88° & 90° THIN TIP PUNCHES										
40212	40212B	88°	.008 [0.2]	2.634 [66.9]	12 [40]	3 [10]	.86 [.015]			
40202	40202B	90°	.008 [0.2]	2.634 [66.9]						

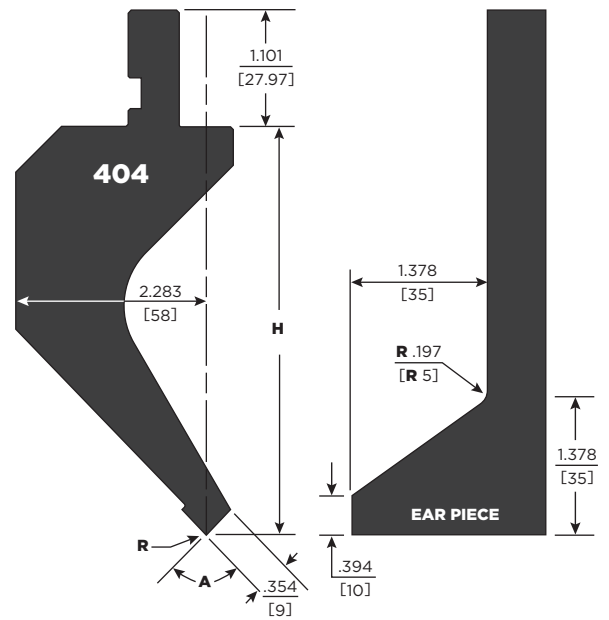
Note: Punch relief available at an additional cost. Contact a Tooling Technician for pricing and lead times.



88° GOOSENECK



88° & 90° GOOSENECK



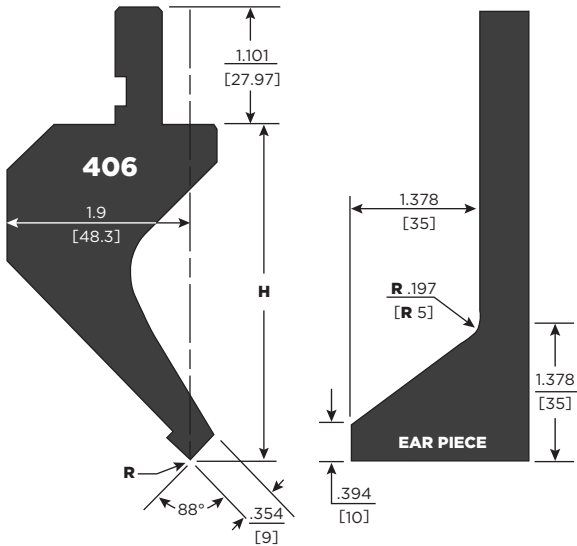
Part No.		A Angle	R Tip Radius inch [mm]	H Height inch [mm]	Max. Ton feet [m]	Weight lbs./inch [kg/mm]	LT	ST	XT
Straight	Beveled						32.87" [835mm]	16.34" [415mm]	32.87" [835mm]
403 SERIES — 88° GOOSENECK PUNCHES									
40302	40302B	88°	.008 [0.2]	4.721 [119.9]	15 [50]	1.68 [.030]			
40308	40308B		.030 [0.8]	4.711 [119.7]					

Part No.		A Angle	R Tip Radius inch [mm]	Height inch [mm]	LT & ST	XT	Weight lbs./inch [kg/mm]	LT	ST	XT
Straight	Beveled				Max. Ton feet [m]			32.87" [835mm]	16.34" [415mm]	32.87" [835mm]
404 SERIES — 88° & 90° GOOSENECK PUNCHES										
40402	40402B	88°	.008 [0.2]	4.130 [104.9]	15 [50]	14 [47]	1.54 [.027]			
40408	40408B		.030 [0.8]	4.120 [104.6]						
40415	40415B		.060 [1.5]	4.108 [104.3]						
40430	40430B		.120 [3.0]	4.082 [103.7]						
40502	40502B	90°	.008 [0.2]	4.130 [104.9]						

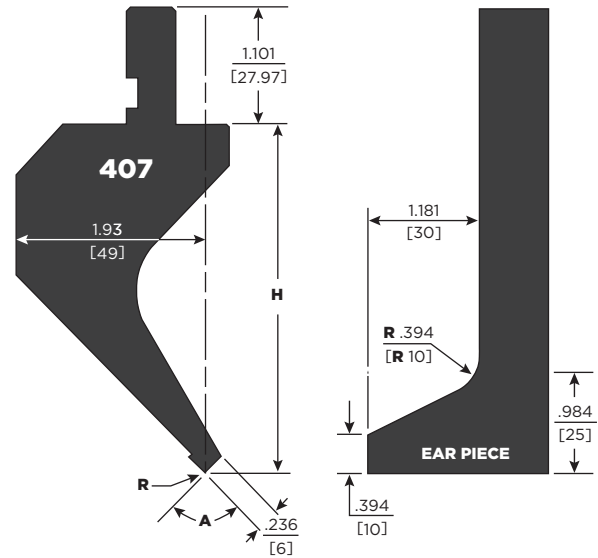
Note: Punch relief available at an additional cost.
Contact a Tooling Technician for pricing and lead times.

= 30 lbs. / 13.6kg or more

88° GOOSENECK STANDARD TIP



88° & 90° GOOSENECK THIN TIP



EUROPEAN TRADITIONAL

Part No.		A Angle	R Tip Radius inch [mm]	H Height inch [mm]	LT & ST	XT	Weight lbs./inch [kg/mm]	LT	ST	XT
Straight	Beveled				Max. Ton feet [m]			32.87" [835mm]	16.34" [415mm]	32.87" [835mm]
406 SERIES — 88° STANDARD TIP GOOSENECK PUNCHES										
40602	40602B	88°	.008 [0.2]	3.539 [89.9]	21 [70]	14 [47]	1.29 [.023]			
40608	40608B		.030 [0.8]	3.529 [89.6]						
40615	40615B		.060 [1.5]	3.517 [89.3]						
40630	40630B		.120 [3.0]	3.491 [88.7]						

Part No.		A Angle	R Tip Radius inch [mm]	H Height inch [mm]	LT & ST	XT	Weight lbs./inch [kg/mm]	LT	ST	XT
Straight	Beveled				Max. Ton feet [m]			32.87" [835mm]	16.34" [415mm]	32.87" [835mm]
407 SERIES — 88° THIN TIP GOOSENECK PUNCHES										
40702	40702B	88°	.008 [0.2]	3.539 [89.9]	15 [50]	9 [30]	1.29 [.023]			
40708	40708B		.030 [0.8]	3.529 [89.6]						
407 SERIES — 90° THIN TIP GOOSENECK PUNCHES										
40712	40712B	90°	.008 [0.2]	3.539 [89.9]	15 [50]	9 [30]	1.29 [.023]			
40718	40718B		.030 [0.8]	3.530 [89.7]						

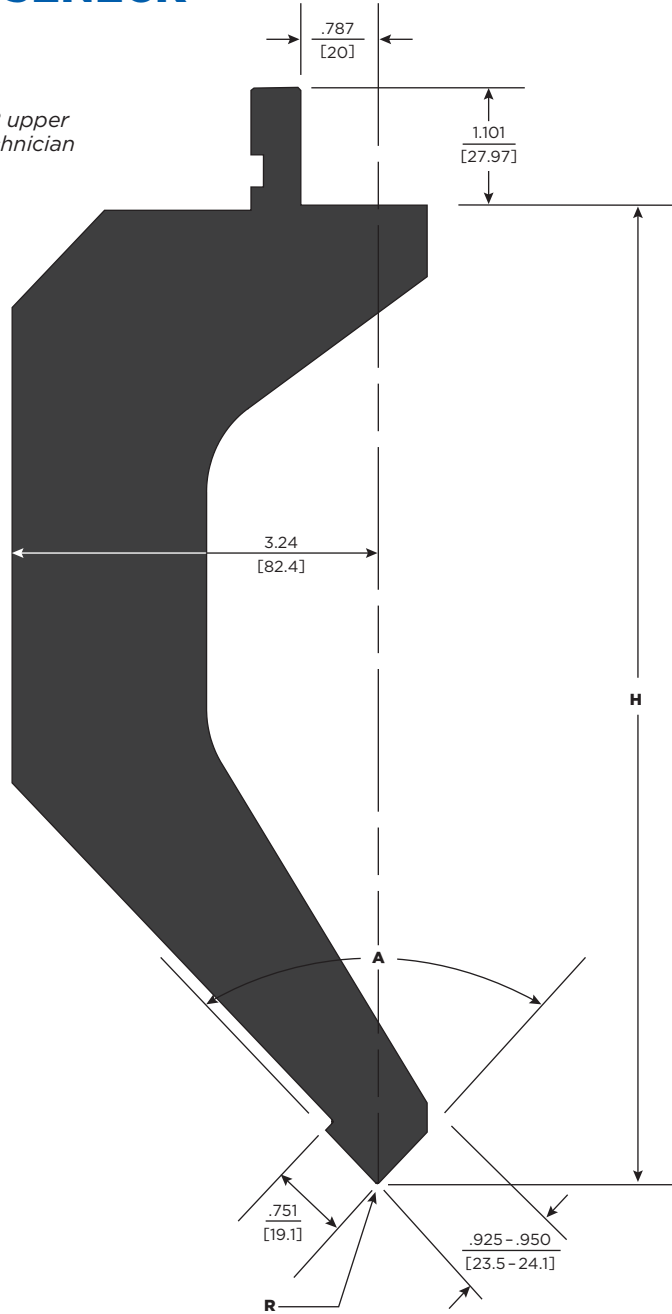
Note: Punch relief available at an additional cost.
Contact a Tooling Technician for pricing and lead times.

= 30 lbs. / 13.6kg or more



Z2 STYLE GOOSENECK

Note: This punch mounts to Z2 upper beam. Please call a Tooling Technician for further explanation.

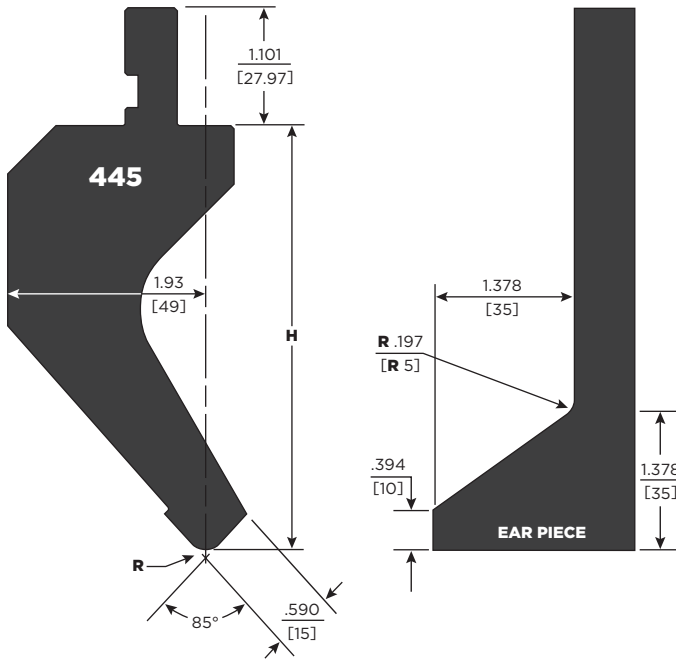


EUROPEAN TRADITIONAL

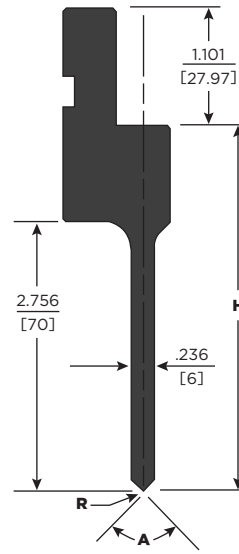
Part No.	A Angle	R Tip Radius inch [mm]	H Height inch [mm]	Max. Ton feet [m]	Weight lbs./inch [kg/mm]	S	200mm
						16.34" [415mm]	7.87" [200mm]
Z2 STYLE GOOSENECK PUNCHES							
43080C	85° - 90°	.008 - .7 [0.2 - 17.75]	Variable 9.555 [242.7]	25 [83]	6.0 [.100]		
43081	88°	.030 [0.8]					

= 30 lbs. / 13.6kg or more

85° GOOSENECK



88° & 90° NARROW



Part No.		A Angle	R Tip Radius inch [mm]	H Height inch [mm]	LT & ST	XT	Weight lbs./inch [kg/mm]	LT	ST	XT
Straight	Beveled				Max. Ton feet [m]			32.87" [835mm]	16.34" [415mm]	32.87" [835mm]
445 SERIES — 85° GOOSENECK PUNCHES										
44540	44540B	85°	.188 [4.8]	4.134 [105.0]	30 [100]	14 [47]	1.68 [.030]			
44560	44560B		.250 [6.4]	4.105 [104.3]						

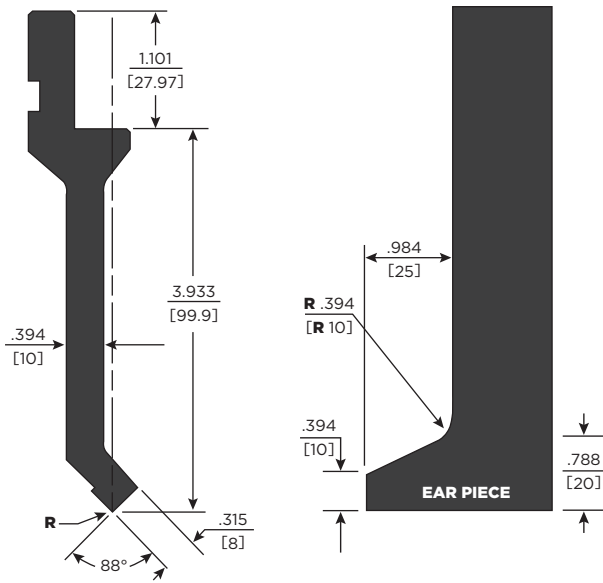
Part No.		A Angle	R Tip Radius inch [mm]	H Height inch [mm]	Max. Ton feet [m]	Weight lbs./inch [kg/mm]	LT	ST	XT	
Straight	Beveled						32.87" [835mm]	16.34" [415mm]	32.87" [835mm]	
88° & 90° NARROW PUNCHES										
40802	40802B	88°	.008 [0.2]	3.740 [95.0]	15 [50]	0.70 [.012]				
40902	40902B	90°	.008 [0.2]							

Note: Sectionalized version does not include ear pieces (horns). Ear pieces (horns) available at an additional cost. Punch relief available at an additional cost. Contact a Tooling Technician for pricing and lead times.

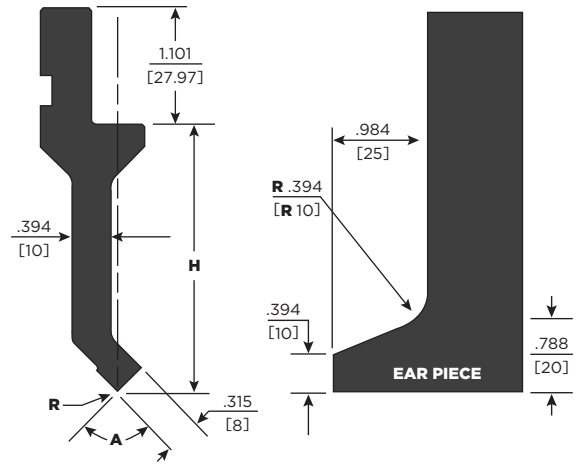
= 30 lbs. / 13.6kg or more



88° SASH – TALL



88° & 90° SASH – SHORT

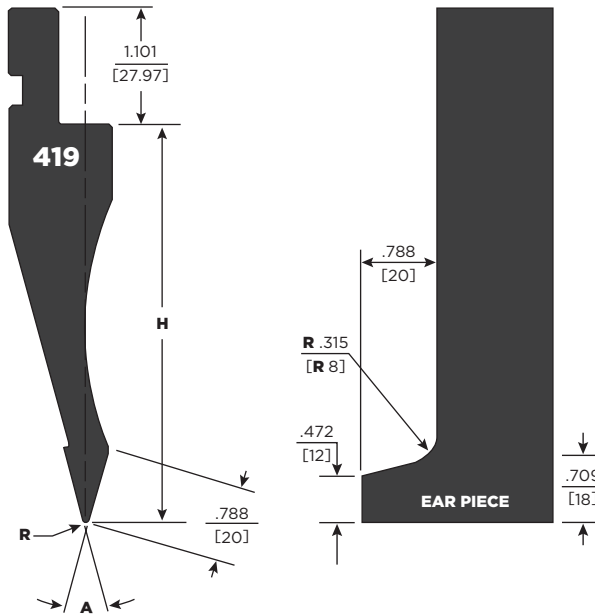


Part No.		A Angle	R Tip Radius inch [mm]	H Height inch [mm]	Max. Ton feet [m]	Weight lbs./inch [kg/mm]	LT	ST	XT
Straight	Beveled						32.87" [835mm]	16.34" [415mm]	32.87" [835mm]
88° SASH PUNCHES – TALL									
41002	41002B	88°	.008 [0.2]	3.933 [99.9]	10 [30]	0.70 [.012]			

Part No.		A Angle	R Tip Radius inch [mm]	H Height inch [mm]	Max. Ton feet [m]	Weight lbs./inch [kg/mm]	LT	ST	XT
Straight	Beveled						32.87" [835mm]	16.34" [415mm]	32.87" [835mm]
88° & 90° SASH PUNCHES – SHORT									
41102	41102B	88°	.008 [0.2]	2.752 [69.9]	10 [30]	0.51 [.009]			
41202	41202B	90°							

Note: Punch relief available at an additional cost. Contact a Tooling Technician for pricing and lead times.

30° ACUTE – TALL



EUROPEAN TRADITIONAL

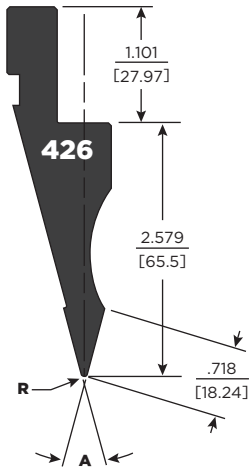
Part No.		A Angle	R Tip Radius inch [mm]	H Height inch [mm]	LT & ST	XT	Weight lbs./inch [kg/mm]	LT	ST	XT
Straight	Beveled				Max. Ton feet [m]			32.87" [835mm]	16.34" [415mm]	32.87" [835mm]
419 SERIES – 30° ACUTE PUNCHES – TALL										
41908	41908B		.030 [0.8]	4.095 [104.0]	30 [100]	14 [47]	1.01 [.018]			
41915	41915B		.060 [1.5]	4.016 [102.0]						
41923	41923B		.090 [2.3]	3.927 [99.7]						
41930	41930B		.120 [3.0]	3.846 [97.7]						
41948	41948B		.188 [4.8]	3.648 [92.7]						
41964	41964B		.250 [6.35]	3.469 [88.1]						

Note: Punch relief available at an additional cost.
Contact a Tooling Technician for pricing and lead times.

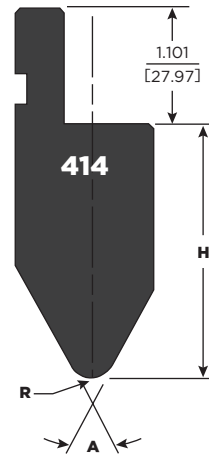
= 30 lbs. / 13.6kg or more



30° ACUTE – SHORT



60° ACUTE



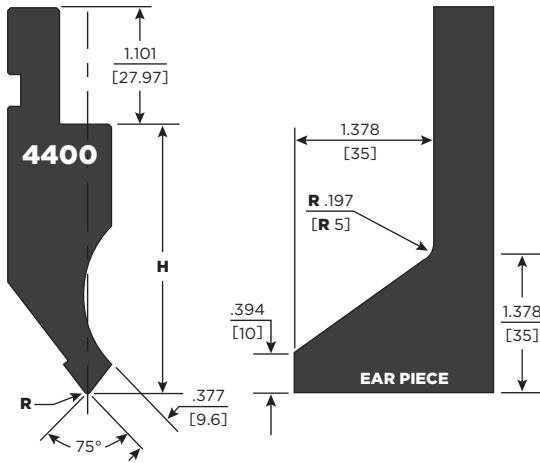
Part No.		A Angle	R Tip Radius inch [mm]	H Height inch [mm]	Max. Ton feet [m]	Weight lbs./inch [kg/mm]	LT	ST	XT
Straight	Beveled						32.87" [835mm]	16.34" [415mm]	32.87" [835mm]
426 SERIES – 30° ACUTE PUNCHES – SHORT									
42610c		30°	.008 [0.2]	2.646 [67.2]	30 [100]	0.51 [.009]			
42610	42610B		.030 [0.8]	2.579 [65.5]					

Part No.		A Angle	R Tip Radius inch [mm]	H Height inch [mm]	Max. Ton feet [m]	Weight lbs./inch [kg/mm]	LT	ST	XT
Straight	Beveled						32.87" [835mm]	16.34" [415mm]	32.87" [835mm]
414 SERIES – 60° ACUTE PUNCHES									
41440	41440B	60°	.188 [4.8]	2.607 [66.2]	30 [100]	1.01 [.018]	KG		
41460	41460B		.236 [6.0]	2.559 [65.0]					

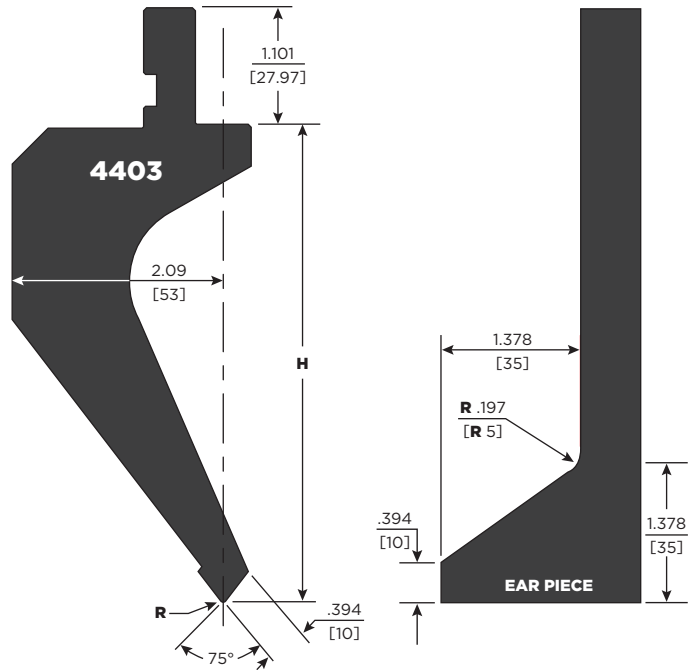
Note: Punch relief available at an additional cost.
Contact a Tooling Technician for pricing and lead times.

= 30 lbs. / 13.6kg or more

75° STANDARD



75° GOOSENECK



Part No.		A Angle	R Tip Radius inch [mm]	H Height inch [mm]	LT & ST	XT	Weight lbs./inch [kg/mm]	LT	ST	XT
Straight	Beveled				Max. Ton feet [m]			32.87" [835mm]	16.34" [415mm]	32.87" [835mm]
4400 SERIES — 75° STANDARD PUNCHES										
44000	44000B	75°	.030 [0.8]	2.662 [67.6]	30 [100]	14 [47]	0.86 [.015]			
44001	44001B		.060 [1.5]	2.645 [67.2]						
44003	44003B		.120 [3.0]	2.607 [66.2]						

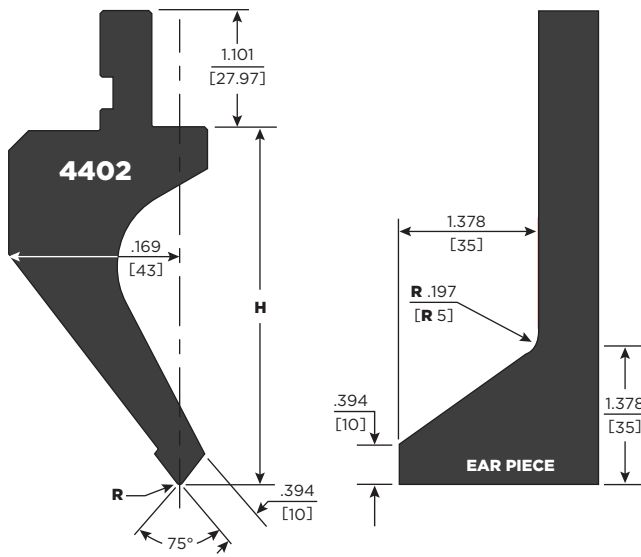
Part No.		A Angle	R Tip Radius inch [mm]	H Height inch [mm]	LT & ST	XT	Weight lbs./inch [kg/mm]	LT	ST	XT
Straight	Beveled				Max. Ton feet [m]			32.87" [835mm]	16.34" [415mm]	32.87" [835mm]
4403 SERIES — 75° GOOSENECK PUNCHES										
44030	44030B	75°	.030 [0.8]	4.724 [120.0]	30 [100]	15 [50]	1.68 [.030]			
44031	44031B		.060 [1.5]	4.707 [119.5]						
44033	44033B		.120 [3.0]	4.669 [118.6]						

Note: Punch relief available at an additional cost.
Contact a Tooling Technician for pricing and lead times.

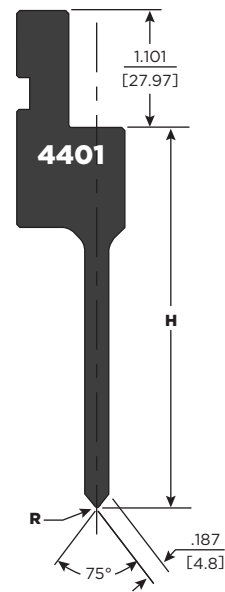
= 30 lbs. / 13.6kg or more



75° GOOSENECK



75° NARROW



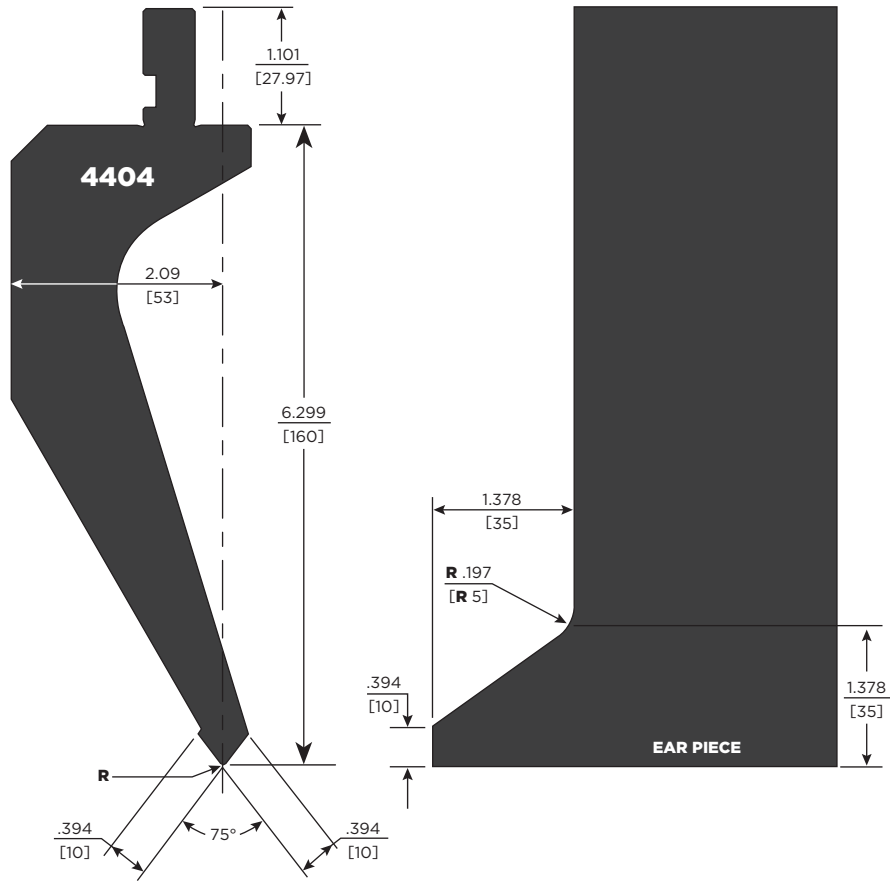
Part No.		A Angle	R Tip Radius inch [mm]	H Height inch [mm]	LT & ST	XT	Weight lbs./inch [kg/mm]	LT	ST	XT
Straight	Beveled				Max. Ton feet [m]			32.87" [835mm]	16.34" [415mm]	32.87" [835mm]
4402 SERIES — 75° GOOSENECK PUNCH										
44020	44020B	75°	.030 [0.8]	3.543 [90.0]	21 [70]	14 [47]	1.68 [.030]			
44021	44021B		.060 [1.5]	3.526 [89.5]						
44023	44023B		.120 [3.0]	3.488 [88.6]						

Part No.		A Angle	R Tip Radius inch [mm]	H Height inch [mm]	LT & ST	XT	Weight lbs./inch [kg/mm]	LT	ST	XT
Straight	Beveled				Max. Ton feet [m]			32.87" [835mm]	16.34" [415mm]	32.87" [835mm]
4401 SERIES — 75° NARROW PUNCH										
44010	44010B	75°	.030 [0.8]	3.740 [95.0]	15 [50]	15 [50]	0.70 [.012]			
44011	44011B		.060 [1.5]	3.722 [94.5]						
44013	44013B		.120 [3.0]	3.684 [93.6]						



Note: Sectionalized version does not include ear pieces (horns). Ear pieces (horns) available at an additional cost (44010). Punch relief available at an additional cost. Contact a Tooling Technician for pricing and lead times.

= 30 lbs. / 13.6kg or more


75° LARGE GOOSENECK



EUROPEAN TRADITIONAL

Part No.		A Angle	R Tip Radius inch [mm]	Height inch [mm]	LT & ST	XT	Weight lbs./inch [kg/mm]	LT	ST	XT	200mm
Straight	Beveled				Max. Ton feet [m]	32.87" [835mm]		16.34" [415mm]	32.87" [835mm]	7.87" [200mm]	
4404 SERIES — 75° LARGE GOOSENECK PUNCH											
44040	44040B	75°	.030 [0.8]	6.299 [160.0]	27 [89]	15 [50]	2.17 [.039]				

Note: Sectionalized version does not include ear pieces (horns). Ear pieces (horns) available at an additional cost (44010). Punch relief available at an additional cost. Contact a Tooling Technician for pricing and lead times

 = 30 lbs. / 13.6kg or more



HOW TO READ AN AIR BENDING FORCE CHART

The Air Bending Force Chart is a simple grid to help determine the correct V-opening to use. It is based on 90° bends and all numbers are estimations. Visit our YouTube channel to walk through using this chart.

- Tonnage calculation
- Minimum Flange (OD)
- Radius Produced



Scan QR Code to Watch the Video

AIR BENDING FORCE CHART
IMPERIAL TONNAGE • IMPERIAL V-OPENINGS

AIR BENDING FORCE CHART
METRIC TONNAGE • METRIC V-OPENINGS

STANDARD FORMULAS FOR SELECTING A V-OPENING
Material Thickness: 2.6mm or Less = T x 6
320° - 312° = T x 8
375° - 500° = T x 10
625°+ Thicker = T x 12

NOTE: Formulas and chart are for reference only.
T = Material Thickness; V = V-Opening; MF = Minimum Flange Length; IR = Inside Radius

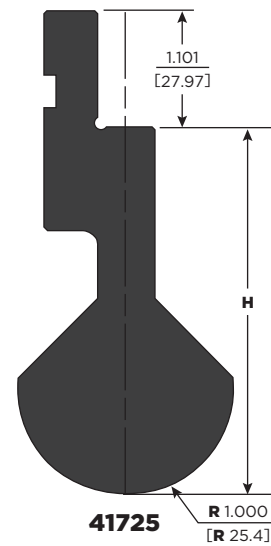
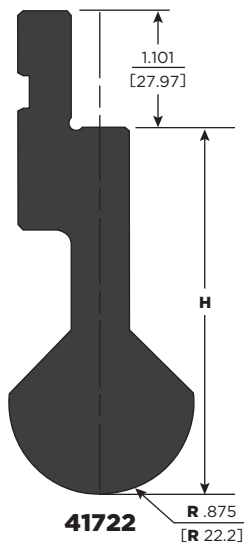
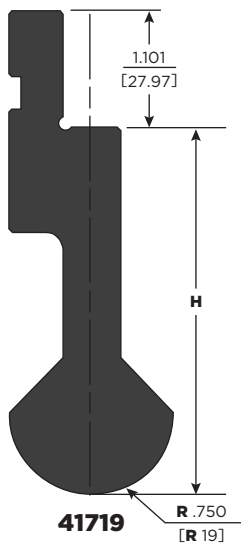
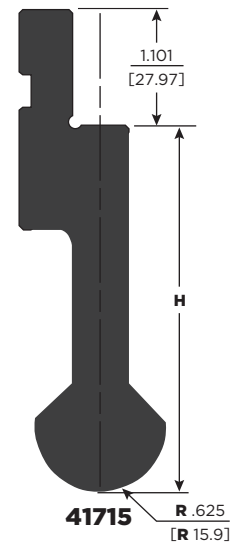
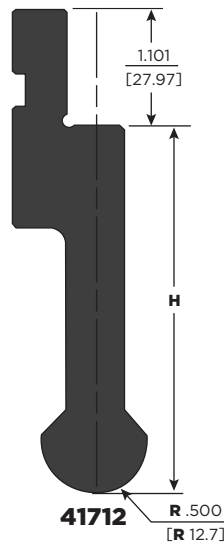
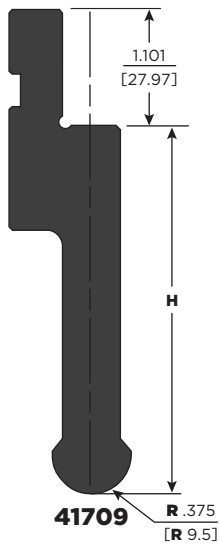
For more information, visit wilsontool.com, call our tooling technicians at 800-445-4518 or contact your sales engineer.

US Headquarters: bending@wilsontool.com | Canada: bendingcanada@wilsontool.com | Mexico: doblez@wilsontool.com

GAUGE	DEC. inch [mm]	V (in.)										
		MF	0.250	0.313	0.375	0.500	0.625	0.750	0.875	1.000	1.125	1.250
		IR	0.042	0.052	0.063	0.084	0.104	0.125	0.146	0.167	0.188	0.209
20	0.036 [.9]		2.9	2.2	1.7	1.2	1.0					
18	0.048 [1.2]		7.0	4.0	2.9	2.2	1.6	1.3				
16	0.060 [1.5]			7.8	5.6	3.6	2.7	2.2	1.7			
14	0.075 [1.9]				11.7	6.0	4.5	3.4	3.0	2.5	2.1	
13	0.090 [2.3]					12.2	6.8	5.4	4.3	3.7	3.3	2.9
12	0.105 [2.7]						10.1	7.4	6.3	5.4	4.4	4.0
11	0.120 [3]							10.5	8.8	7.2	6.2	5.4
10	0.135 [3.4]								11.3	9.6	8.4	7.0

EUROPEAN TRADITIONAL

LARGE RADIUS PUNCHES — ONE PIECE DESIGN



EUROPEAN TRADITIONAL

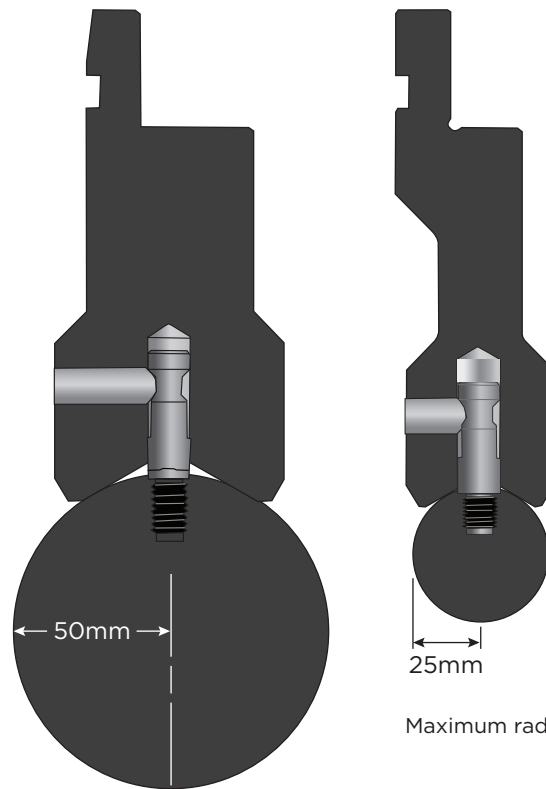
Part No.		H Height inch [mm]	Max. Ton feet [m]	Weight lbs./inch [kg/mm]	LT	ST	XT
Straight	Beveled				32.87" [835mm]	16.34" [415 mm]	32.87" [835mm]
41709	41709B	3.268 [83.0]	30 [100]	0.86 [.015]			
41712	41712B	3.504 [89.0]		1.01 [.018]			
41715	41715B	3.425 [87.0]		0.86 [.015]			
41719	41719B	3.583 [91.0]		1.29 [.023]			
41722	41722B	3.701 [94.0]					
41725	41725B	3.780 [96.0]					

Note: Sectionalized version does not include ear pieces (horns).
Ear pieces (horns) available at an additional cost. Additional radii available, please contact a Tooling Technician.

= 30 lbs. / 13.6kg or more



REPLACEABLE RADIUS PUNCHES



CAUTION: Do not load the radius tip into the holder while in the machine. Remove the holder from the machine to change radius.



Scan QR Code to Watch the Video

Maximum radius size shown on each holder.

Radius Part No.	Radius Size inch [mm]	Radius Weight lbs./inch [kg/mm]	Radius Price	Stem Bolt Part No.	Holder Part No.	Holder Width inch [mm]	Weight lbs./inch [kg/mm]	Holder Price	Assembled Height inch [mm]	Max. Ton feet [m]
REPLACEABLE RADIUS PUNCHES & HOLDERS						LENGTH: 19.685" [500mm]				
6R095-500	.375 [9.5]	0.18 [.003]		980101	408T35-500	1.3778 [35]	1.21 [.024]		4.055 [103]	21 [71]
6R127-500	.500 [12.7]	0.33 [.006]							4.324 [109.8]	
6R158-500	.625 [15.8]								4.593 [116.7]	
6R190-500	.750 [19.0]	0.51 [.009]		408T35-500B				4.863 [123.5]		
6R222-500	.875 [22.2]	0.70 [.012]						5.132 [130.4]		
6R254-500	1.000 [25.4]	1.01 [.018]		980102	408T55-500	2.165 [55]	1.92 [.034]	KG	5.401 [137.2]	
6R381-500	1.500 [38.1]	2.03 [.036]	KG						6.290 [159.8]	
6R508-500	2.000 [50.8] MTO	3.63 [.065]	KG						7.058 [179.3]	
REPLACEABLE RADIUS PUNCHES & HOLDERS						LENGTH: 9.84" [250mm]				
6R254-250	1.000 [25.4]	0.44 [.016]		980102	408T55-250	2.165 [55]	1.92 [.034]		5.213 [132.4]	21 [71]
6R381-250	1.500 [38.1]	2.03 [.036]							6.290 [159.8]	
6R508-250	2.000 [50.8]	3.63 [.065]	KG						7.058 [179.3]	

NOTE: The large radius assemblies shown above are not designed to stage bend. Contact a Tooling Technician if stage bending is needed. Make to order (MTO) sizes are available upon request.

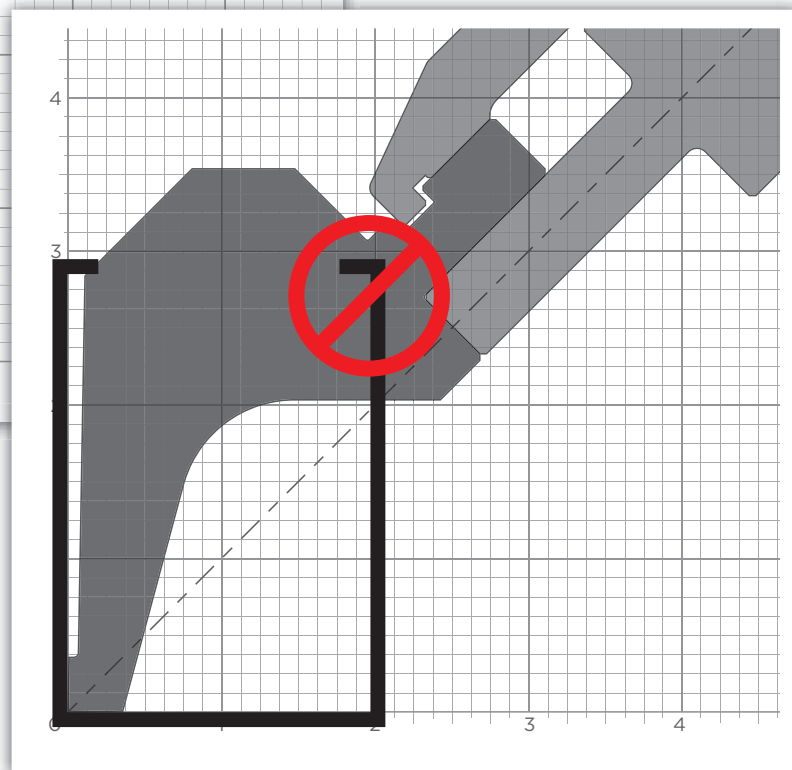
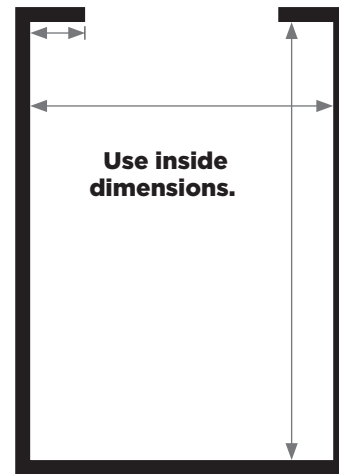
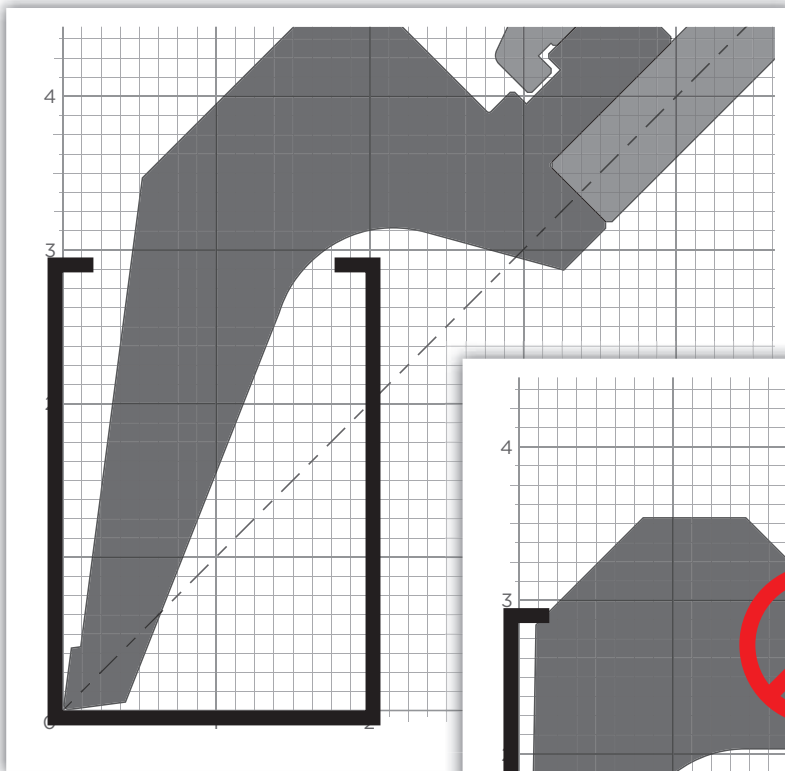
KG = 30 lbs. / 13.6kg or more

HOW TO USE A BEND LIMIT GRAPH

Although a bend limit graph won't help with bend sequencing, it will help determine what punch profile is best for you. Visit our YouTube channel for a step-by-step video on using these graphs.

- The graphs are 1:1
- Your part can be laid on top of the catalog page
- Use inside dimensions — always account for material thickness

This application works.



This application doesn't work.

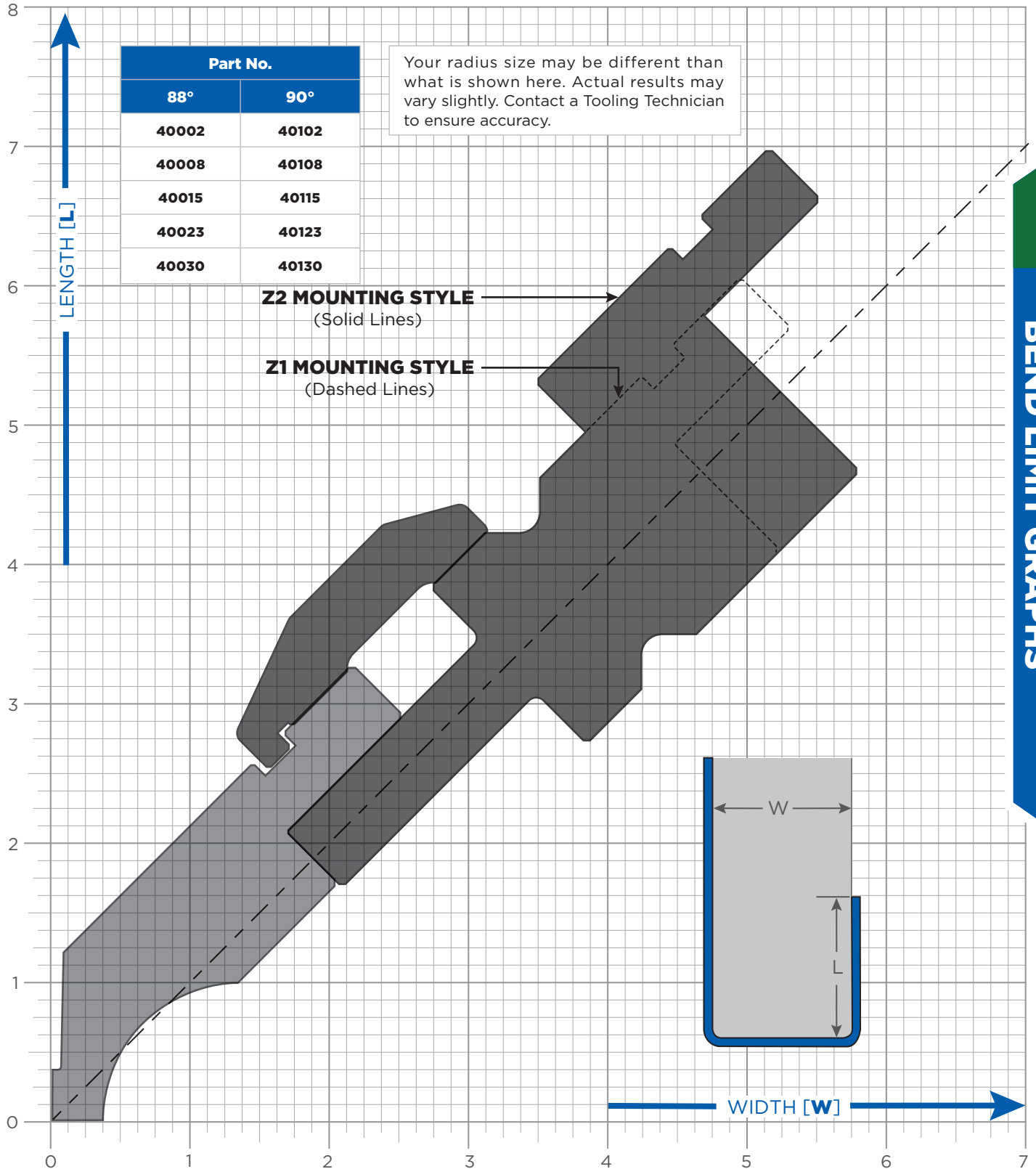


Scan QR Code to Watch the Video



STANDARD PUNCH

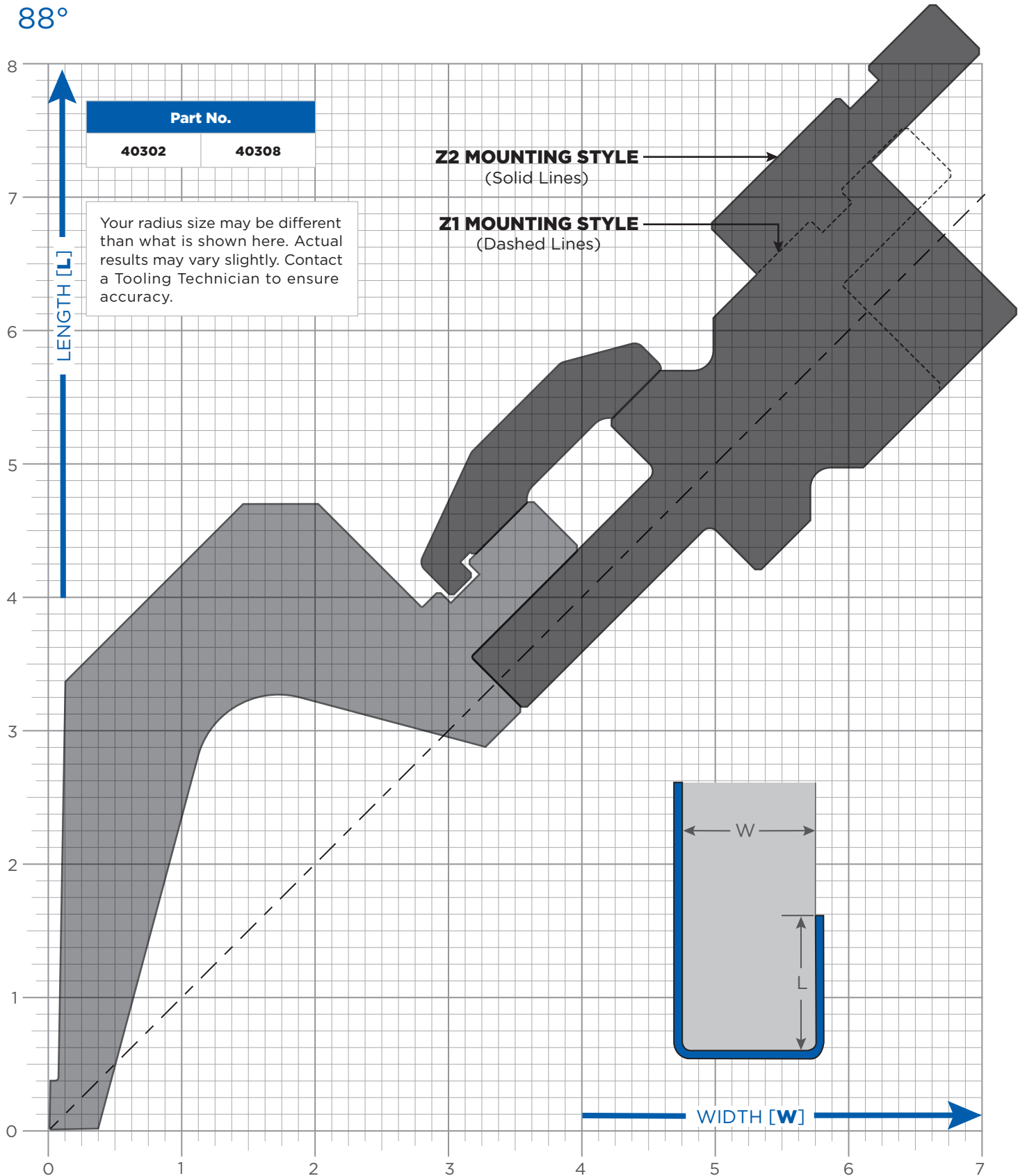
88° & 90°



GOOSENECK PUNCH

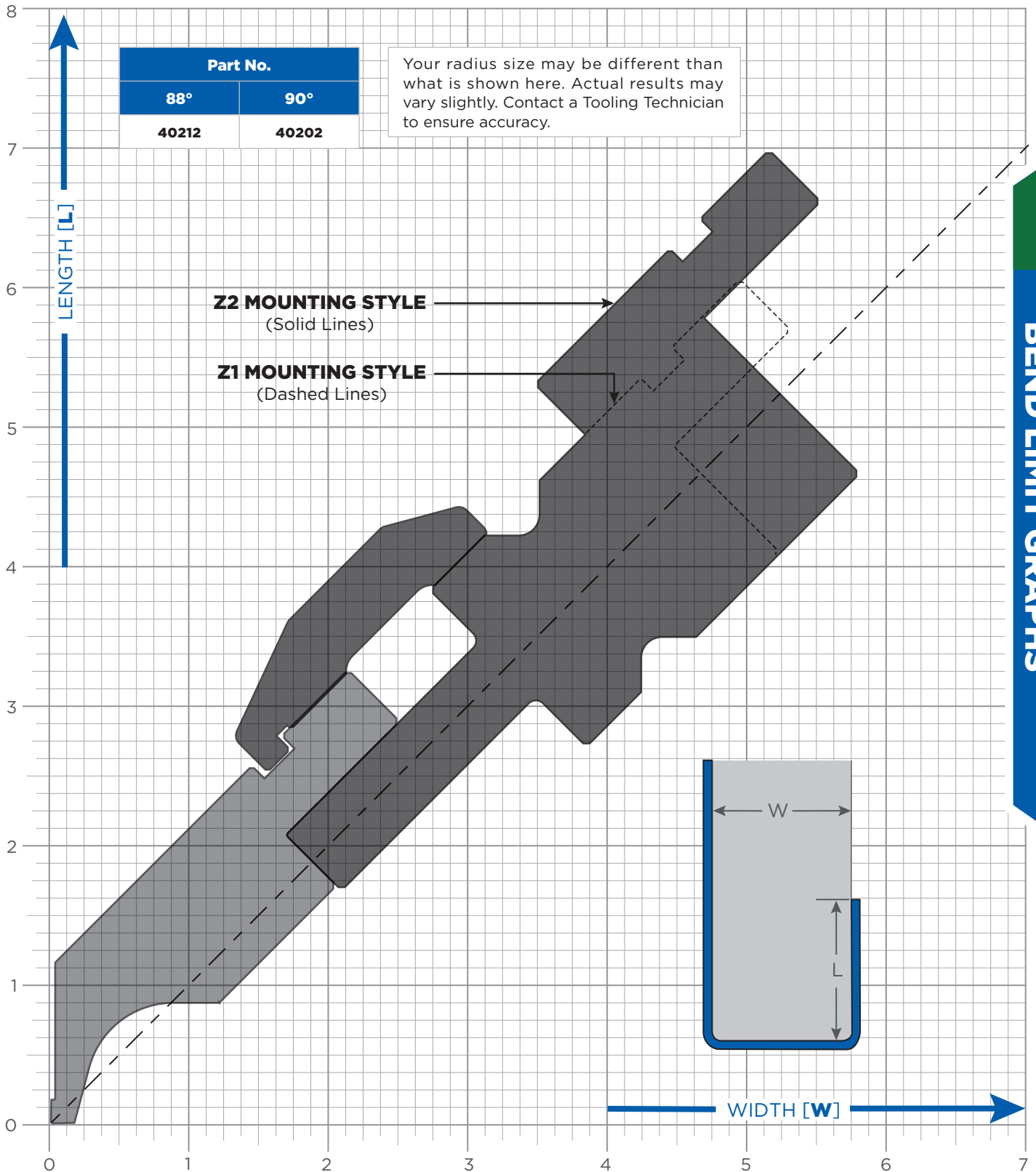
88°

BEND LIMIT GRAPHS



THIN TIP STANDARD PUNCH

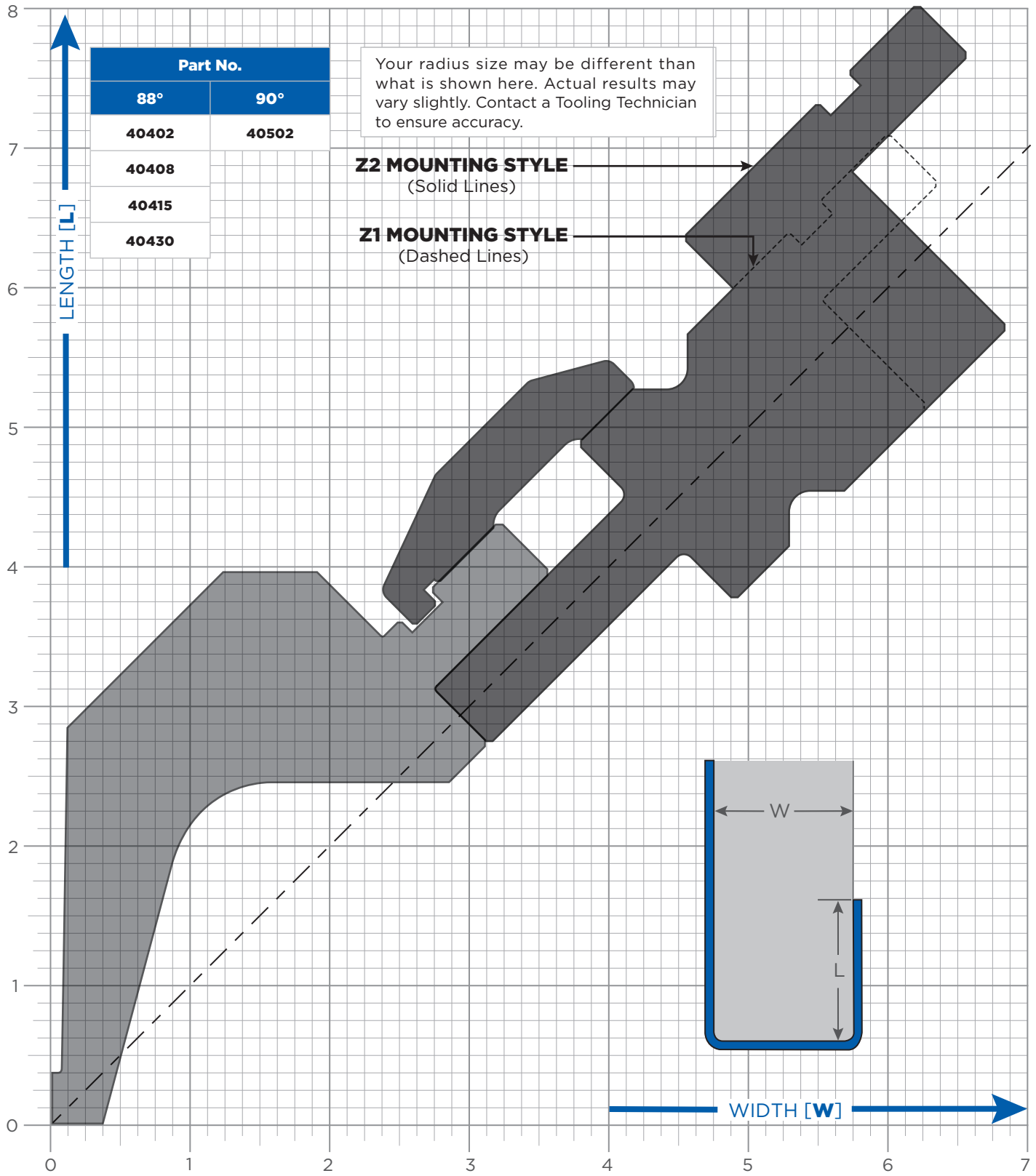
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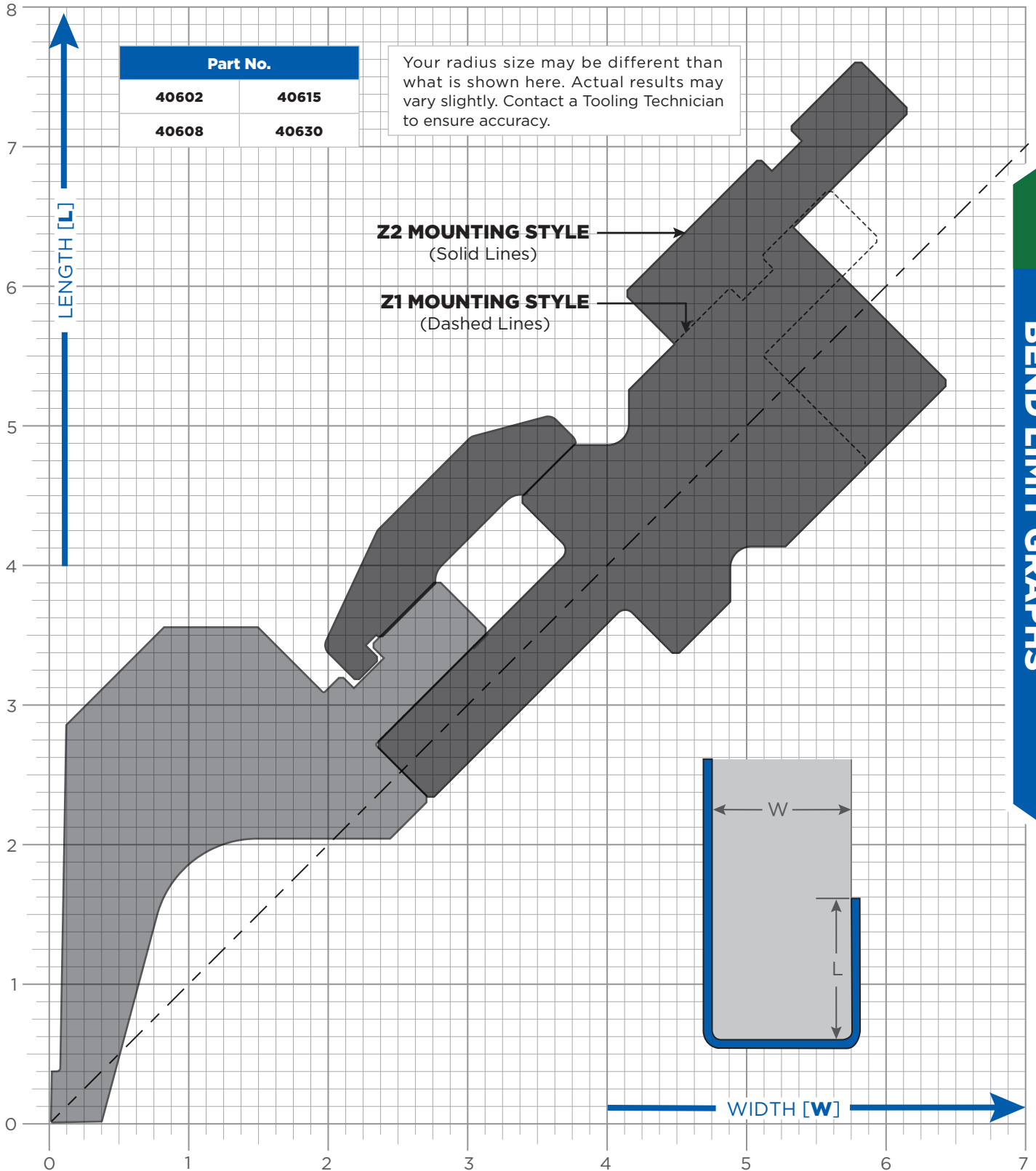
GOOSENECK PUNCH

88° & 90°

BEND LIMIT GRAPHS



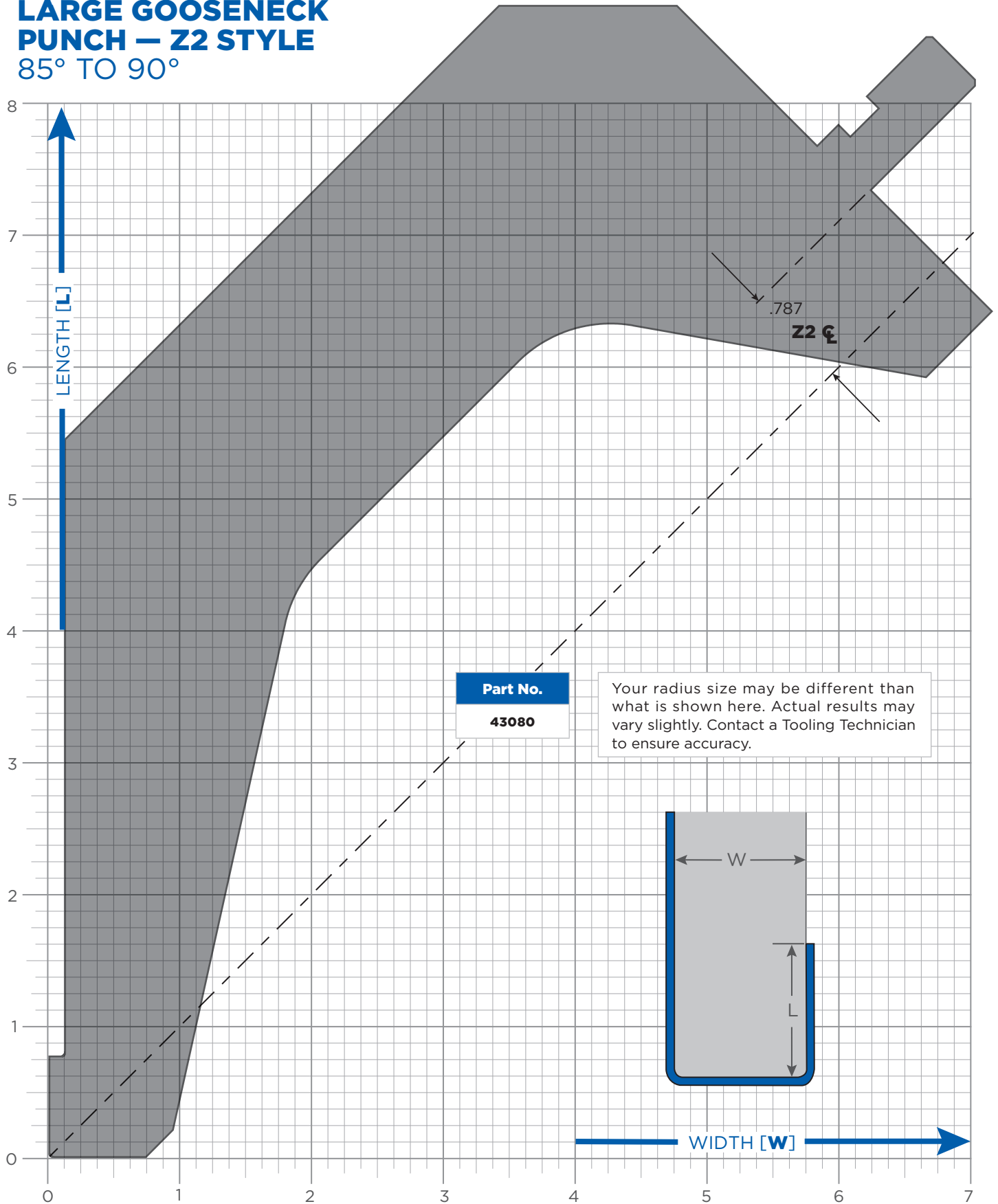
GOOSENECK PUNCH 88°



LARGE GOOSENECK PUNCH – Z2 STYLE

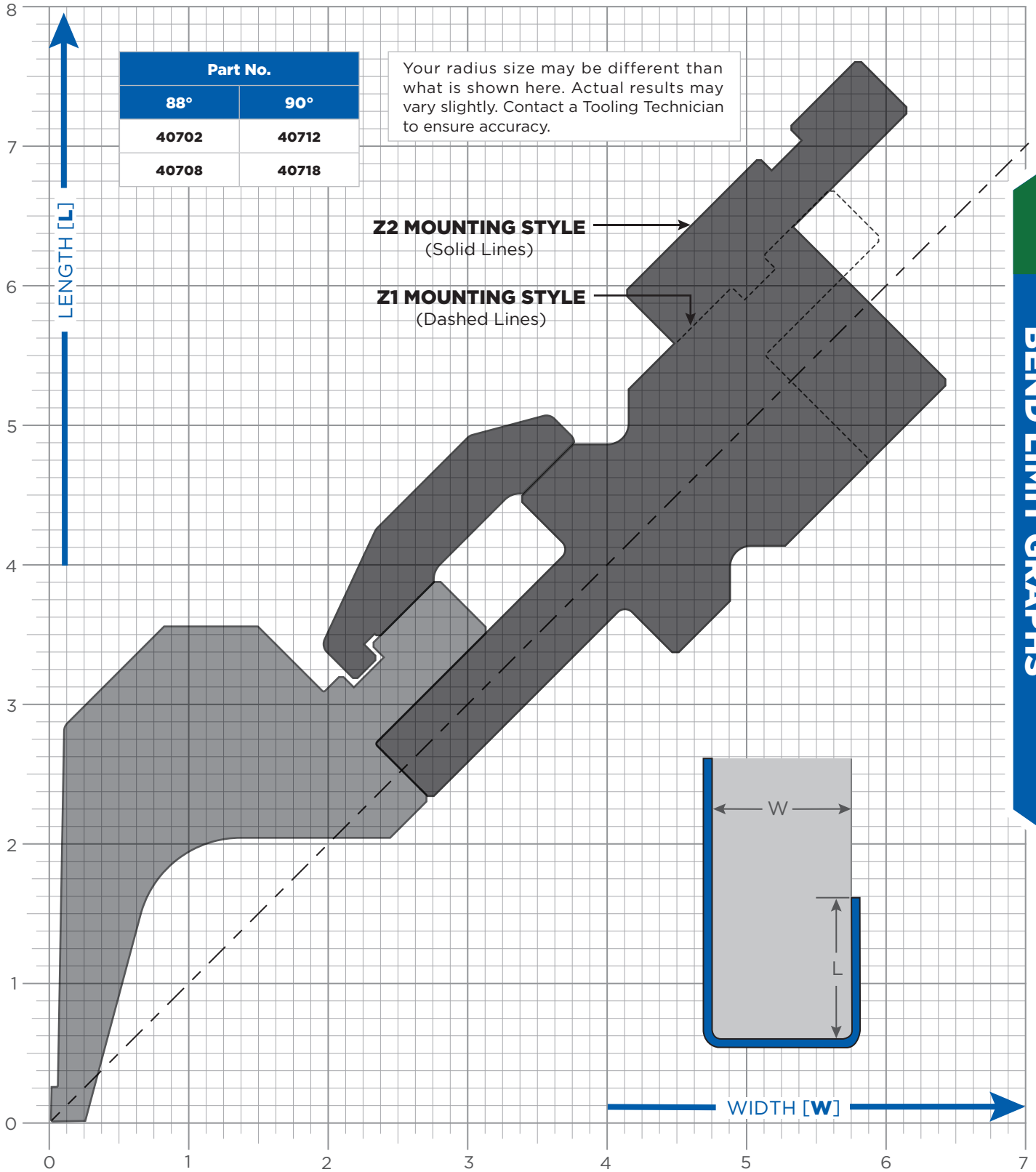
85° TO 90°

BEND LIMIT GRAPHS



THIN TIP GOOSENECK PUNCH

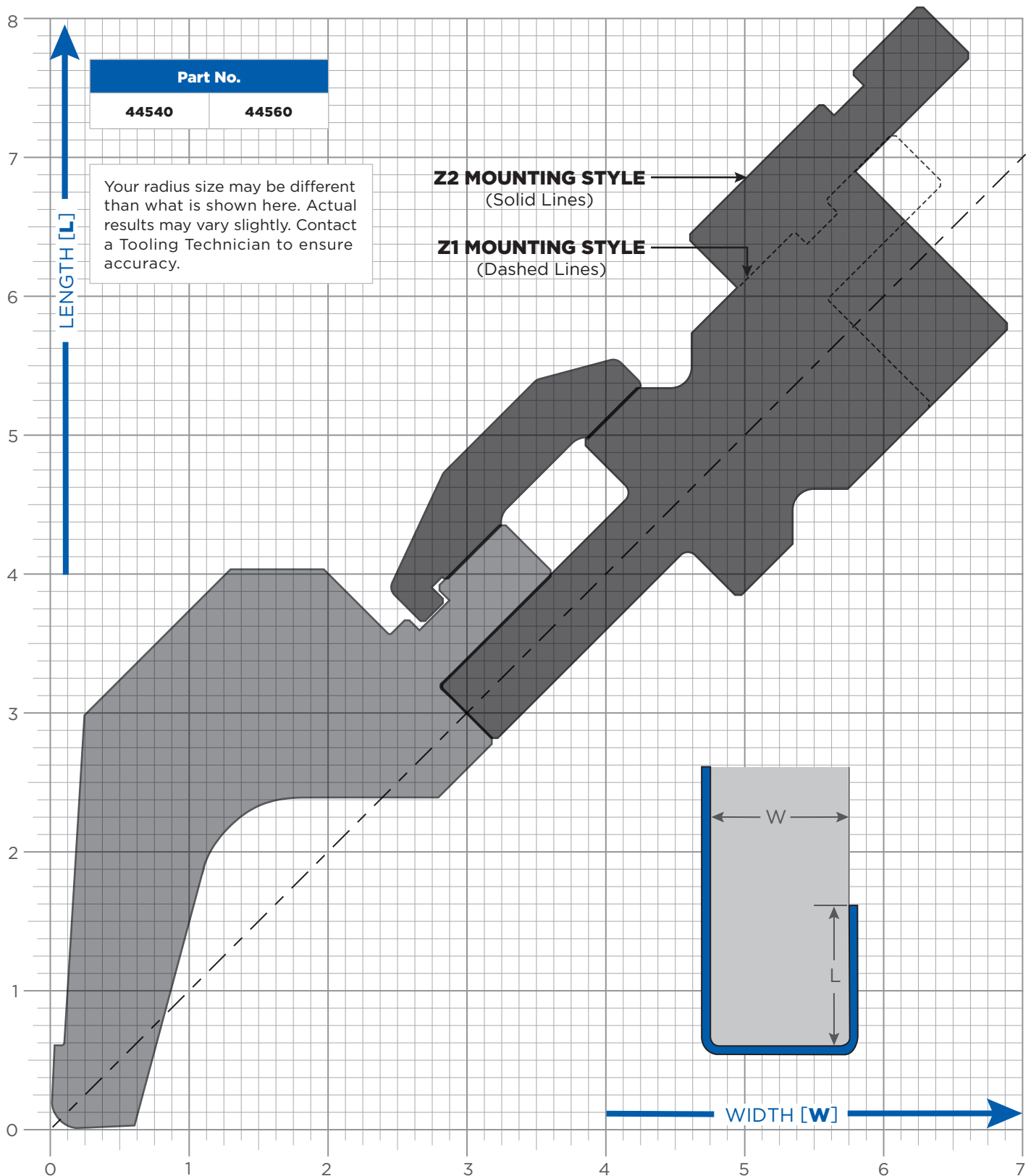
88° & 90°



GOOSENECK PUNCH

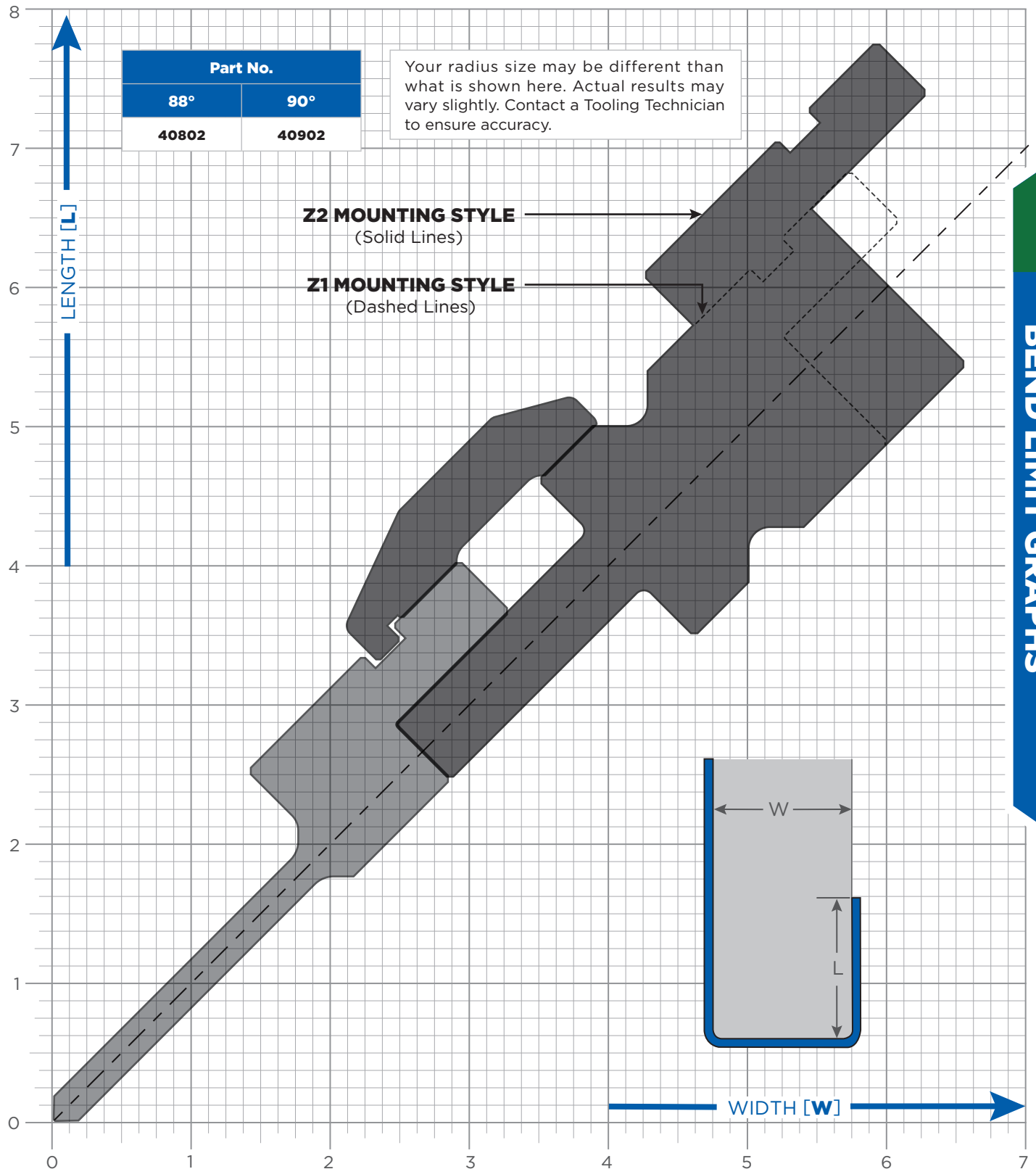
85°

BEND LIMIT GRAPHS



NARROW PUNCH

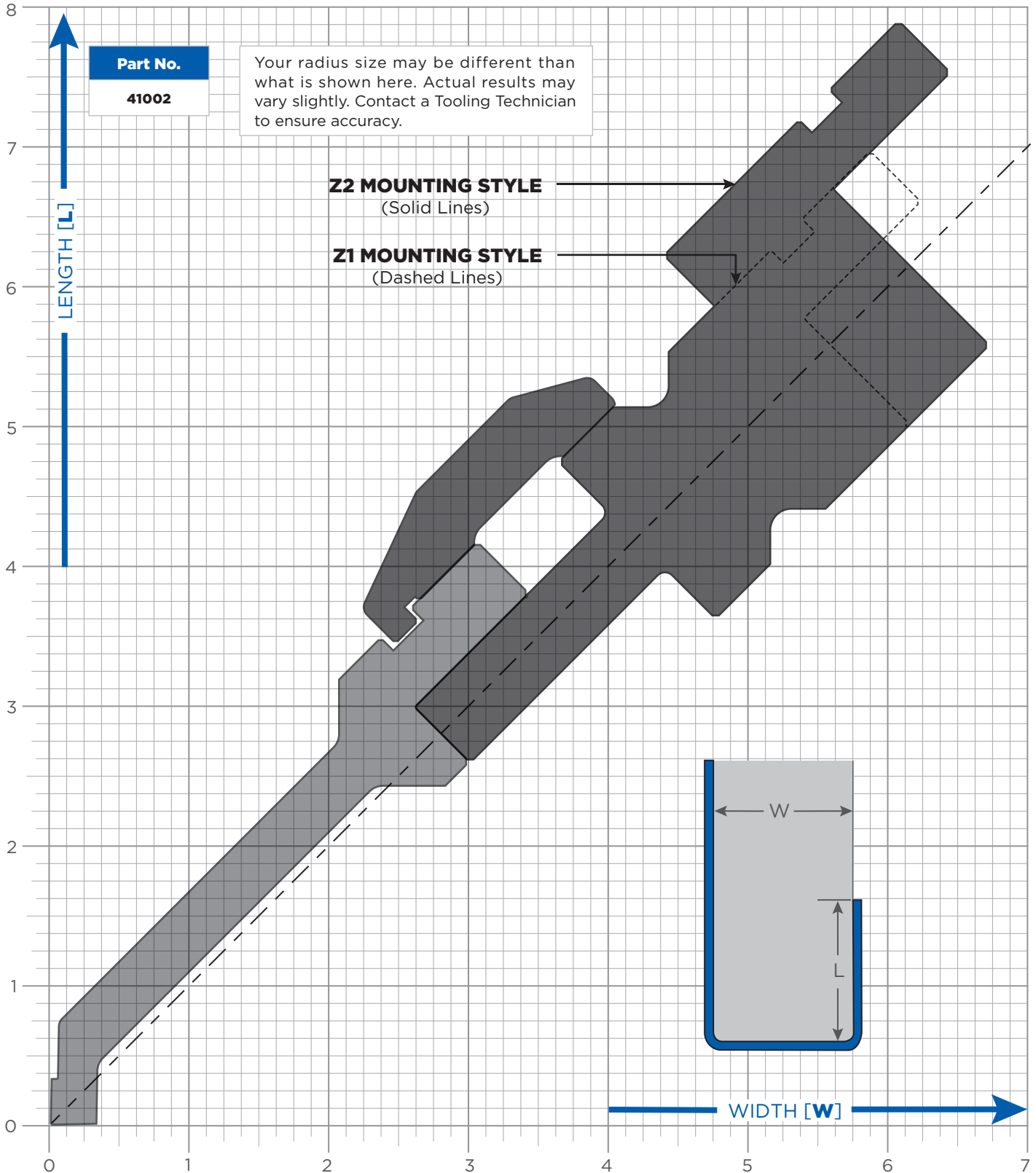
88° & 90°



SASH PUNCH

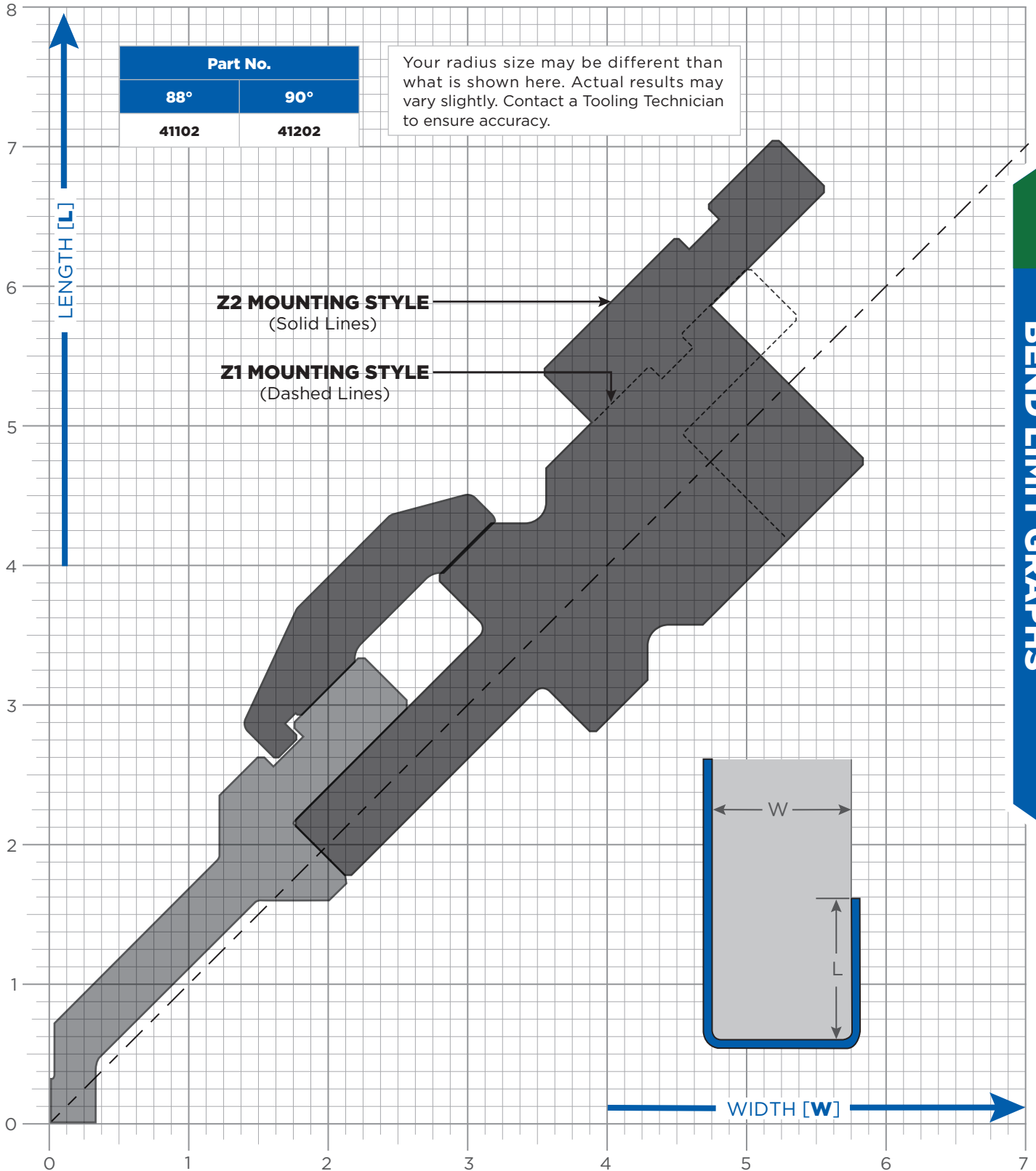
88°

BEND LIMIT GRAPHS



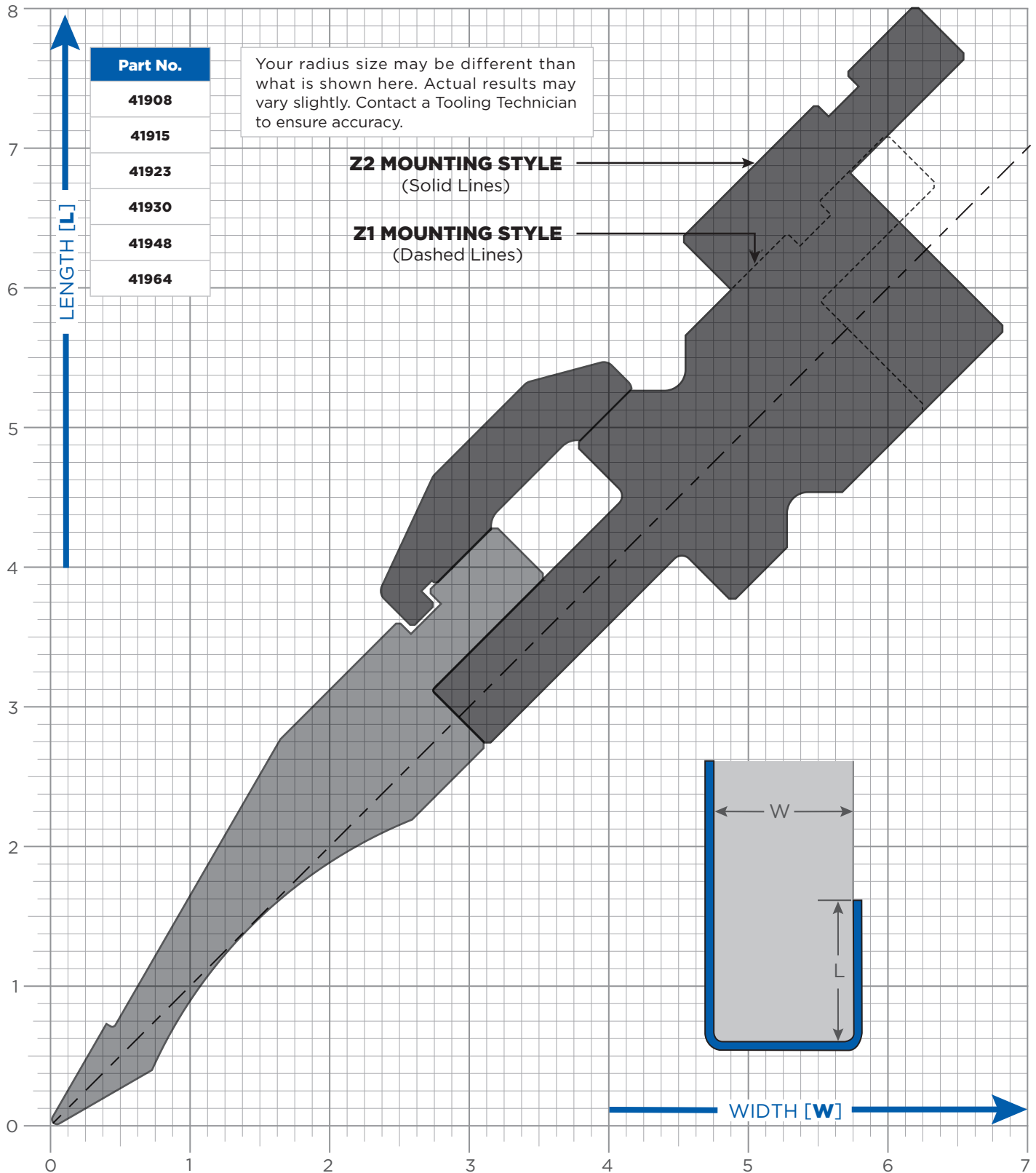
SASH PUNCH

88° & 90°



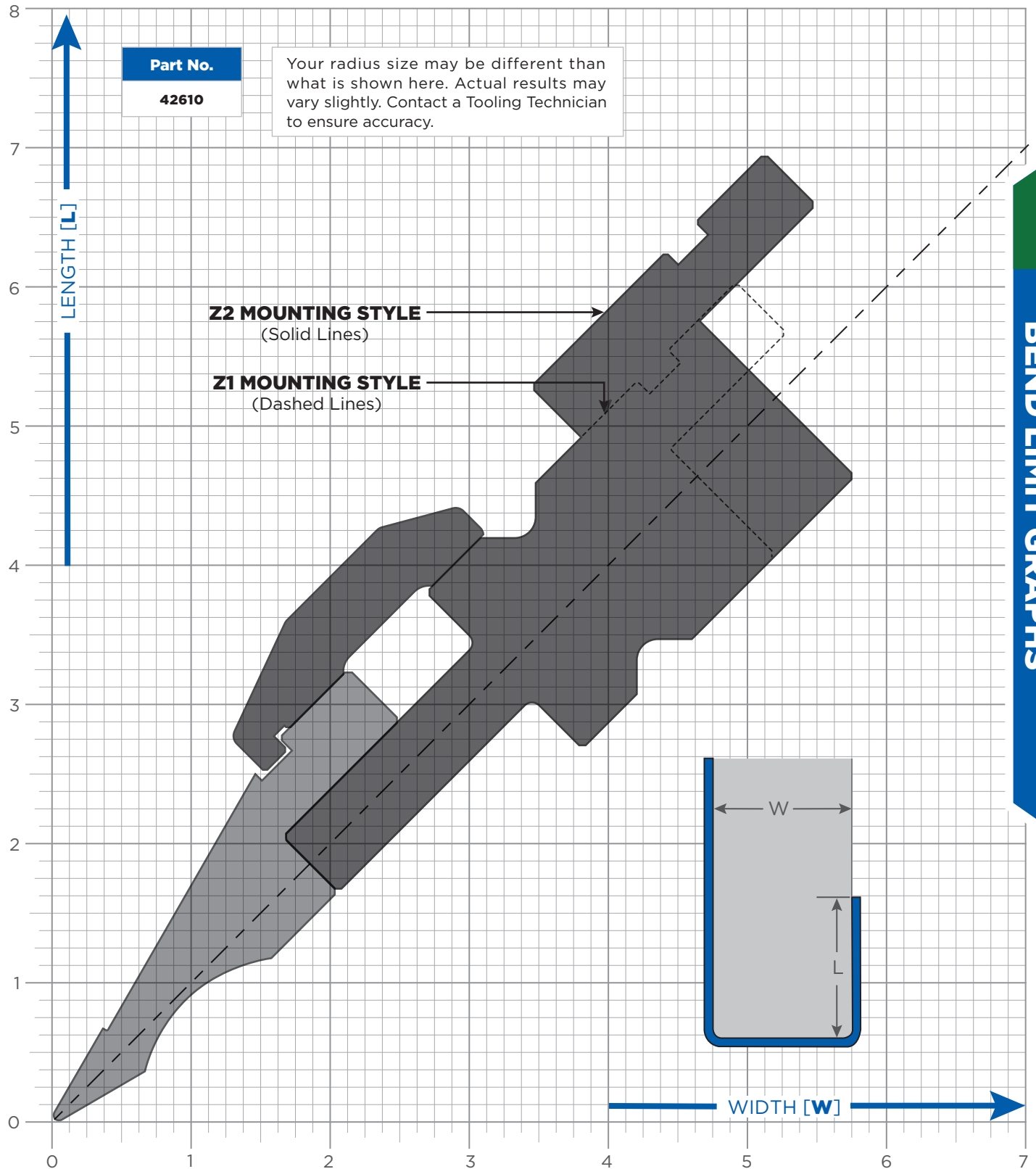
ACUTE ANGLE PUNCH

30°



ACUTE ANGLE PUNCH

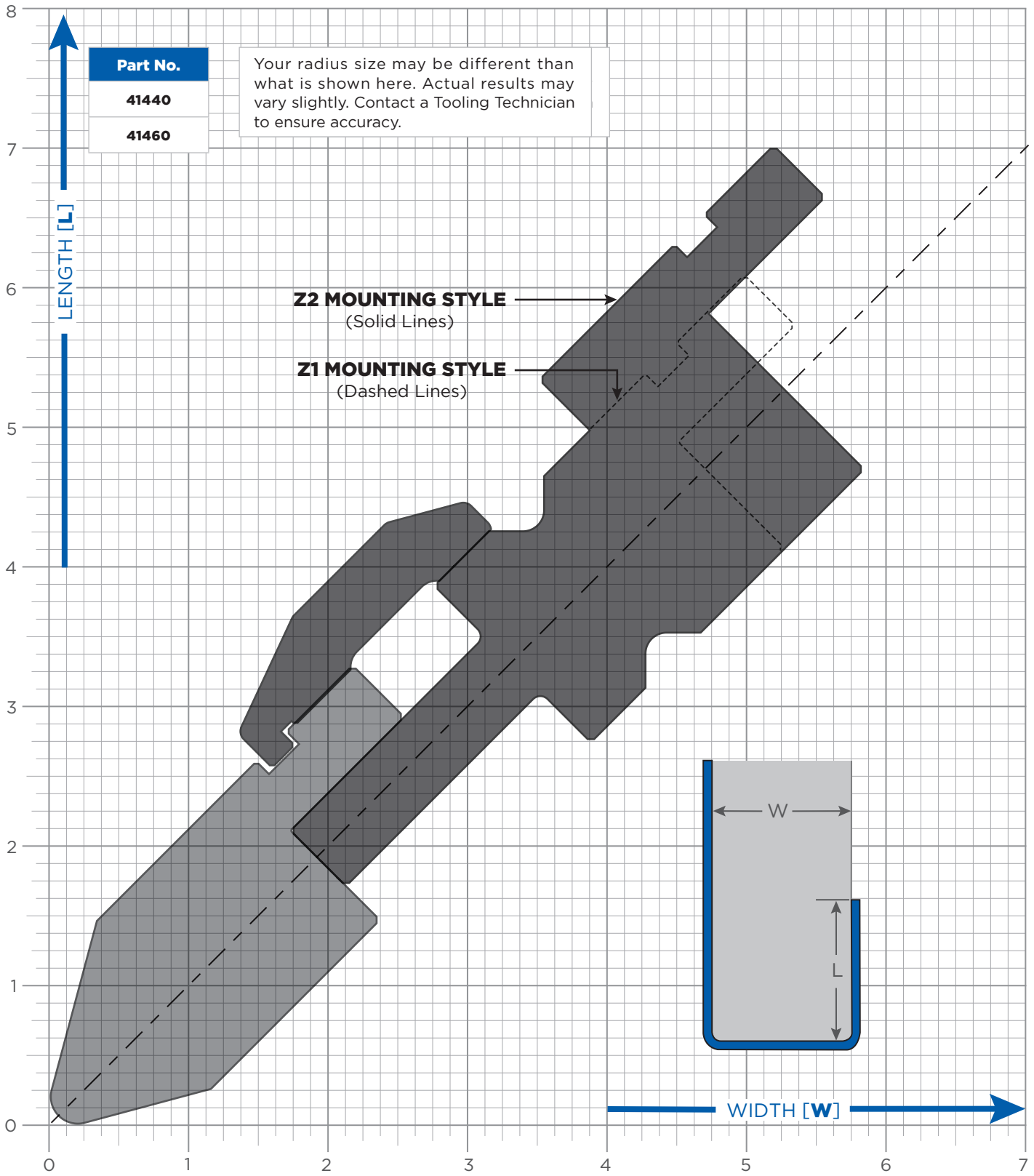
30°



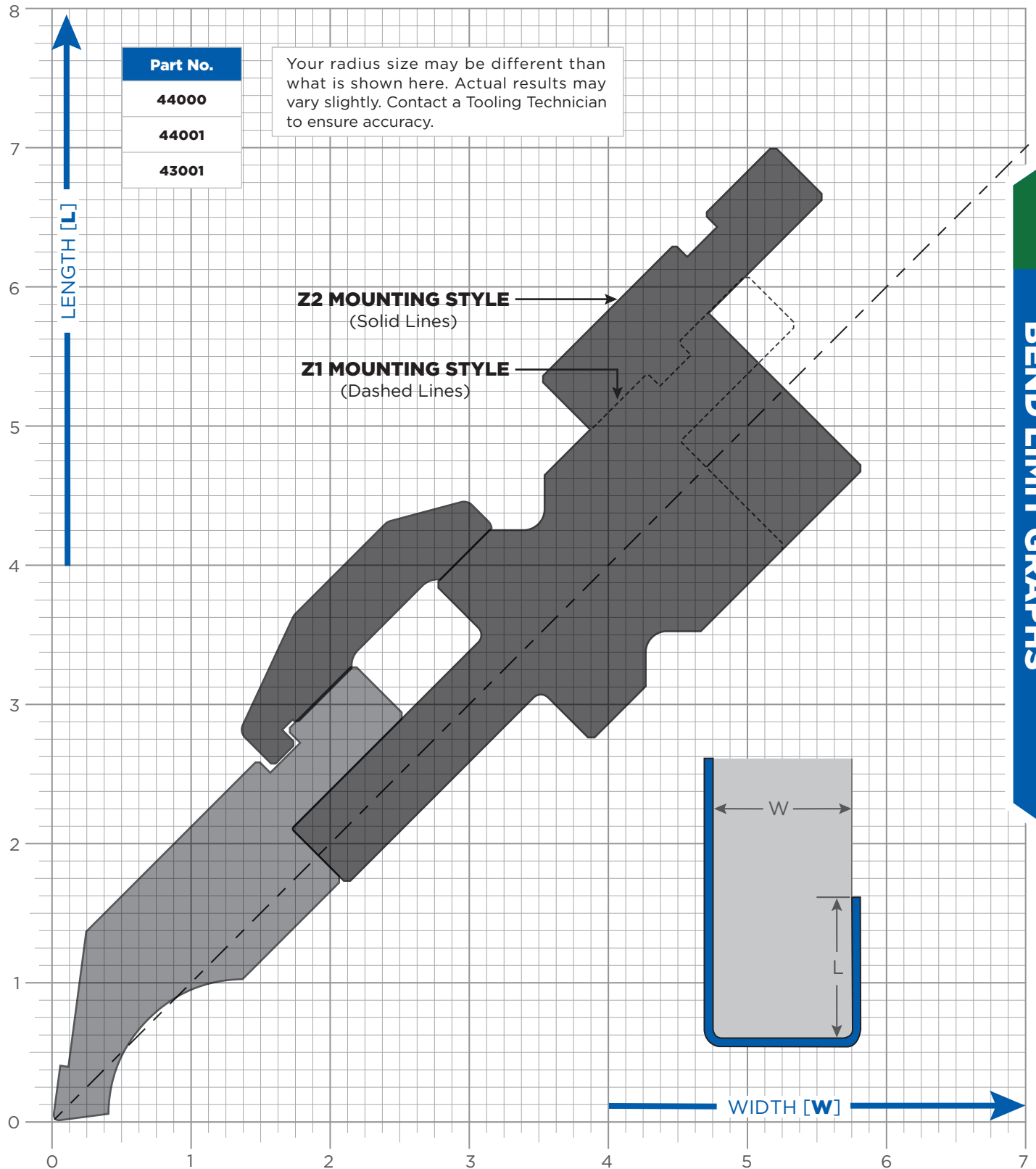
ACUTE PUNCH

60°

BEND LIMIT GRAPHS

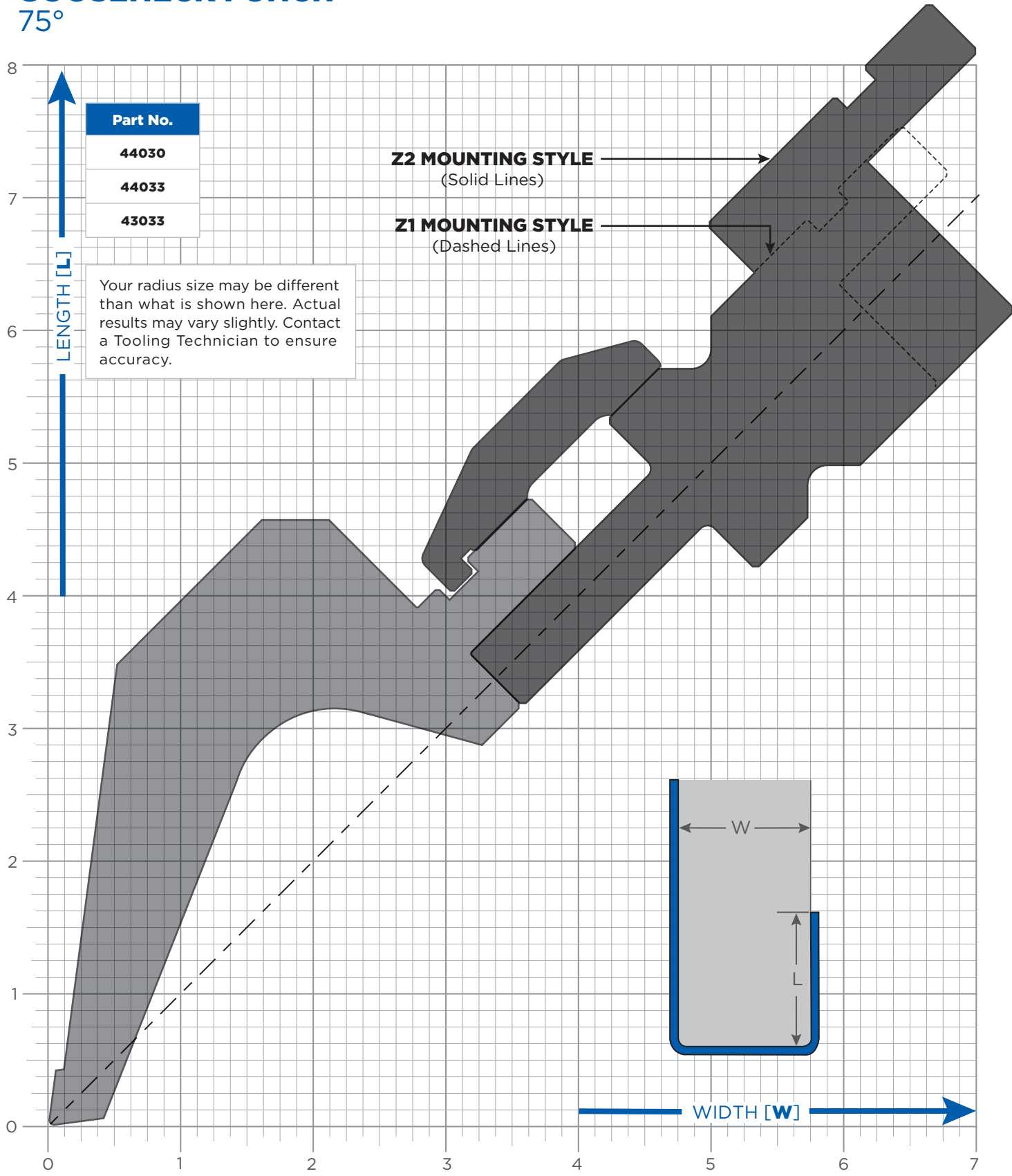


STANDARD PUNCH 75°

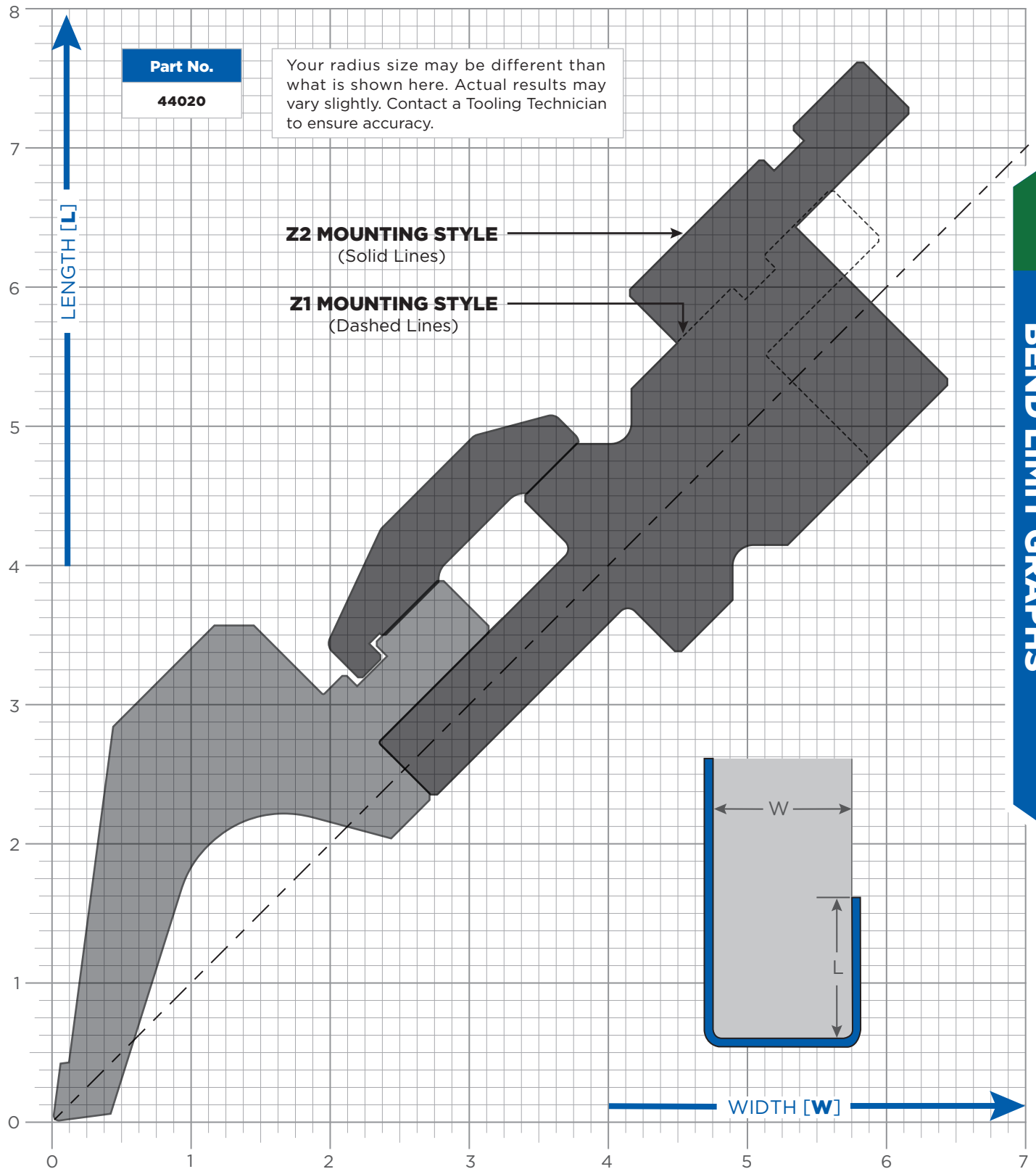


GOOSENECK PUNCH 75°

BEND LIMIT GRAPHS



GOOSENECK PUNCH 75°



GOOSENECK PUNCH 75°

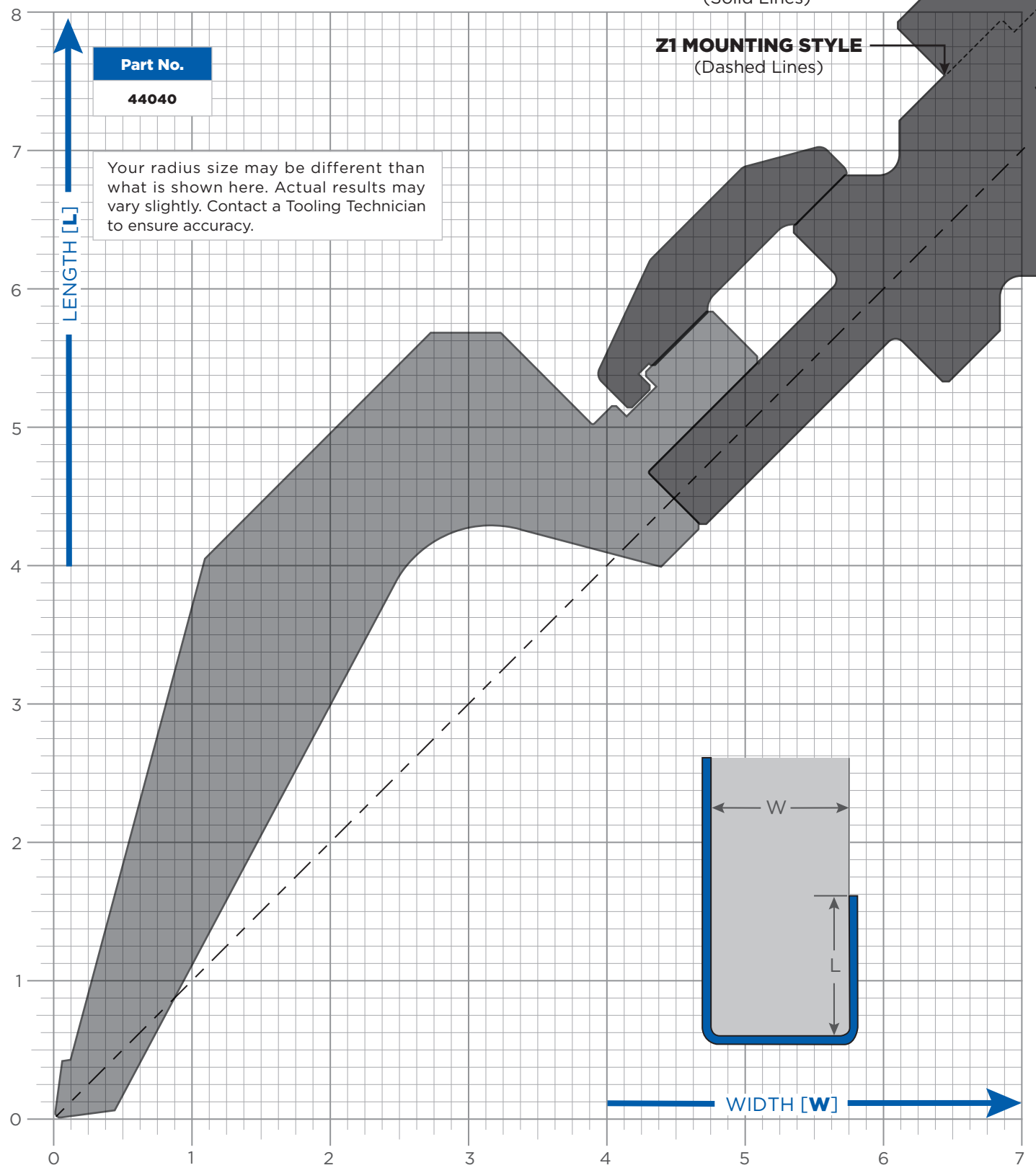
BEND LIMIT GRAPHS

Z2 MOUNTING STYLE
(Solid Lines)

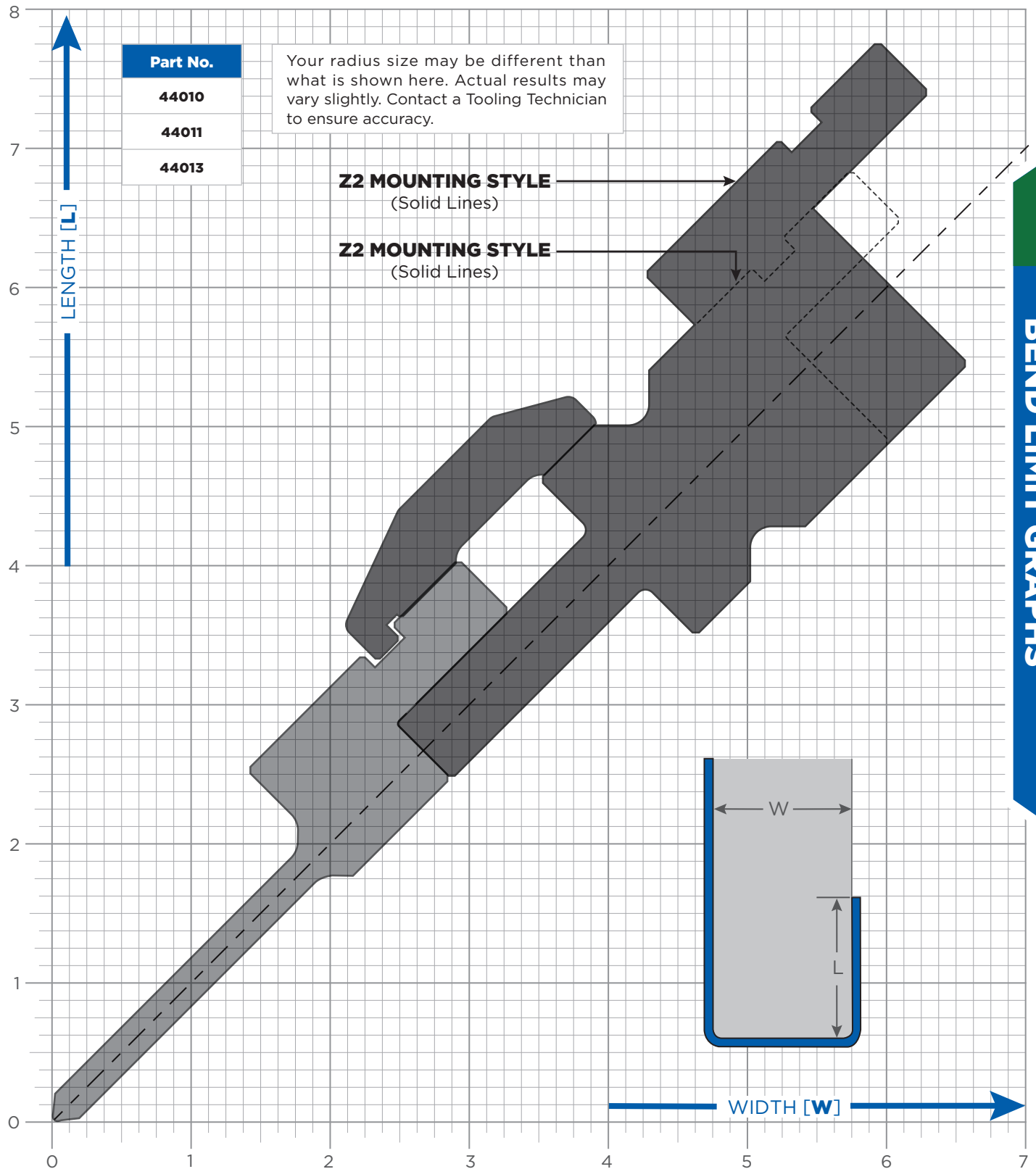
Z1 MOUNTING STYLE
(Dashed Lines)

Part No.
44040

Your radius size may be different than what is shown here. Actual results may vary slightly. Contact a Tooling Technician to ensure accuracy.



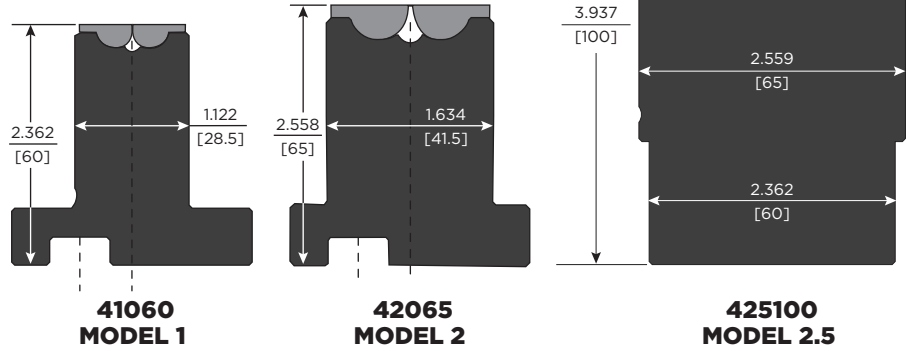
NARROW PUNCH 75°



V-SERIES BLACK (VSB) DIES – MODELS 1, 2 & 2.5



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V-SERIES BLACK (VSB) DIES

MODEL 1	SOLID		SECTIONAL	X1	X2
Length	9.84" [250mm]	19.68" [500mm]	21.65" [550mm]	10.83" [275mm]	10.83" [275mm]
Height	2.36" [60mm]	2.36" [60mm]	2.36" [60mm]	2.36" [60mm]	2.36" [60mm]
Assembly Part No.	41060-250	41060-500	41060-550	41060 x 1	41060 x 2
Spring	(20 qty.) 980682	(40 qty.) 980682	(44 qty.) 980682	(22 qty.) 980682	(22 qty.) 980682
Weight	8 lbs. [3.63kg]	15 lbs. [6.80kg]	17 lbs. [7.71kg]	8 lbs. [3.63kg]	8 lbs. [3.63kg]
Price					
Insert Part No.	(2 qty.) 980872A	(4 qty.) 980872A	980873A & 980874A	987158	987159

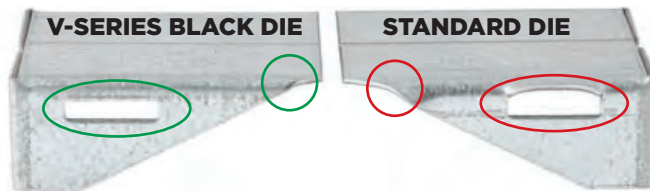
MODEL 2	SOLID		SECTIONAL	X1	X2
Length	9.84" [250mm]	19.68" [500mm]	21.65" [550mm]	10.83" [275mm]	10.83" [275mm]
Height	2.56" [65mm]	2.56" [65mm]	2.56" [65mm]	2.56" [65mm]	2.56" [65mm]
Assembly Part No.	42065-250	42065-500	42065-550	42065 x 1	42065 x 2
Spring	(20 qty.) 980683	(40 qty.) 980683	(44 qty.) 980683	(22 qty.) 980683	(22 qty.) 980683
Weight	10 lbs. [4.54kg]	17 lbs. [7.71kg]	18 lbs. [8.16kg]	9 lbs. [4.08kg]	9 lbs. [4.08kg]
Price					
Insert Part No.	(2 qty.) 980948	(4 qty.) 980948	980949 & 980950	987160	987161

MODEL 2.5	SOLID		SECTIONAL	X1	X2
Length	9.84" [250mm]	19.68" [500mm]	—	10.83" [275mm]	10.83" [275mm]
Height	3.94" [100mm]	3.94" [100mm]	—	3.94" [100mm]	3.94" [100mm]
Assembly Part No.	425100-250	425100-500	—	425100 x 1	425100 x 2
Spring	qty 20 980683	qty 40 980683	—	qty 22 980683	qty 22 980683
Weight	24 lbs. [10.78kg]	48 lbs. [21.58kg]	—	26 lbs. [11.79kg]	26 lbs. [11.79kg]
Price			—		
Insert Part No.	(2 qty.) 990646	(4 qty.) 990646	—	990644	990645



Model	Material Thickness inch [mm]	Min. Outside Flange inch [mm]	Ton/ Ft.	Min. Angle	Punch Radius Required @ Min. Angle	Min. Outside Radius @ Min. Angle inch [mm]	Max. Outside Radius @ 90° inch [mm]	US Short Ton/Ft.	Metric Tons/M	kN/M
V-SERIES BLACK (VSB) SPECIFICATIONS										
1	.018 [.45]	.118 [3.0]	1.8	34°	.054	.125 [3.17]	.175 [4.45]	38	112	1100
	.020 [.50]		1.8		.052					
	.024 [.60]		2		.047					
	.032 [.80]		2.5		.036					
	.035 [.90]		3.3		.031					
	.040 [1.0]		4							
	.048 [1.2]	5.8								
	.059 [1.5]	.165 [4.2]	9							
2	.075 [1.9]	.335 [8.5]	7	42°	.122	.216 [5.5]	.354 [9.0]	57	168	1650
	.105 [2.7]	.347 [8.8]	13		.112					
	.118 [3.0]	.366 [9.3]	19		.099					
	.126 [3.2]		22	.091						
	.134 [3.4]		25	55°	.082					
2.5	.079 [2.0]	.732 [18.6]	4	46°	.368	.447 [11.35]	.500 [12.7]	84	250	2450
	.157 [4.0]		16		.221	.378 [9.6]				
	.197 [5.0]		28	55°	.146	.343 [8.71]				

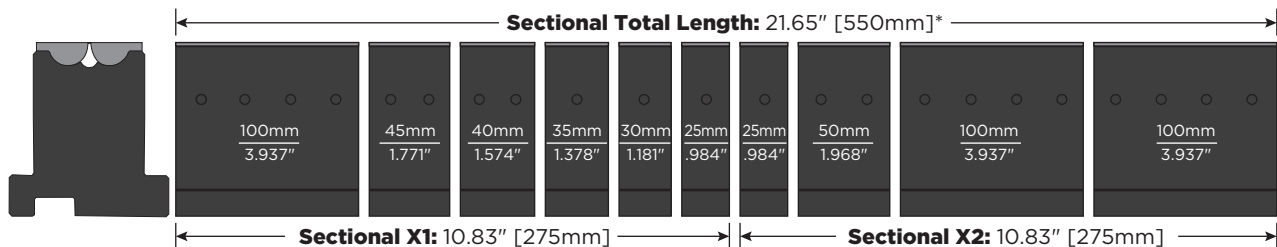
Model	Shoulder Radius inch [mm]	Desired Angle	Theoretical V inch [mm]	Center Line of Inserts inch [mm]
V-OPENING AND SHOULDER RADIUS DIMENSIONS				
1	.043 [1.1]	90°	.283 [7.2]	.315 [8]
		34°	.256 [6.5]	
2	.050 [1.3]	90°	.547 [13.9]	.591 [15]
		42°	.524 [13.3]	
2.5	.079 [2.0]	90°	1.037 [26.3]	1.102 [28]
		55°	1.007 [25.6]	



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

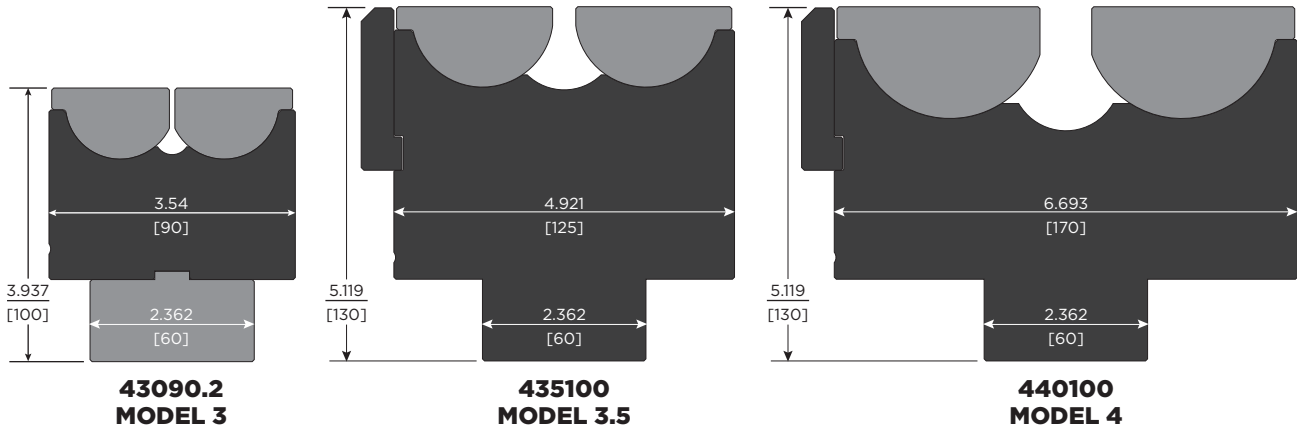
V-Series Black (VSB) Standard Lengths Models 1, 2 & 2.5

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



*550mm sectional length not available in Model 2.5

V-SERIES BLACK (VSB) DIES – MODELS 3, 3.5 & 4

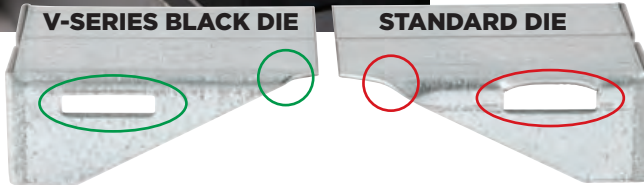


MODEL 3	SOLID		X1
Length	3.94" [100mm]	9.84" [250mm]	10.04" [255mm]
Height	3.94" [100mm]	3.94" [100mm]	3.94" [100mm]
Assembly Part No.	43090.2-100	43090.2-250	43090.2 x 1
Spring	(4 qty.) 987315	(8 qty.) 987315	(8 qty.) 987315
Weight	13 lbs. [5.90kg]	32 lbs. [14.16kg]	33 lbs. [14.97kg]
Price			
Insert Part No.	987163	980959	987162

MODEL 3.5	SOLID		X1
Length	3.94" [100mm]	9.84" [250mm]	10.04" [255mm]
Height	5.12" [130mm]	5.12" [130mm]	5.12" [130mm]
Assembly Part No.	435100-100	435100-250	435100 x 1
Spring	(4 qty.) 990656	(10 qty.) 990656	(10 qty.) 990656
Weight	23 lbs. [10.39kg]	58 lbs. [26.49kg]	58 lbs. [26.49kg]
Price			
Insert Part No.	(2 qty.) 990650	(2 qty.) 990651	(2 qty.) 990648

MODEL 4	SOLID		X1
Length	3.94" [100mm]	9.84" [250mm]	10.04" [255mm]
Height	5.12" [130mm]	5.12" [130mm]	5.12" [130mm]
Assembly Part No.	440100-100	440100-250	440100 x 1
Spring	(4 qty.) 990657	(10 qty.) 990657	(10 qty.) 990657
Weight	28 lbs. [12.53kg]	70 lbs. [31.40kg]	71 lbs. [31.95kg]
Price			
Insert Part No.	(2 qty.) 990653	(2 qty.) 990654	(2 qty.) 990652

Model	Material Thickness inch [mm]	Min. Outside Flange inch [mm]	Ton/ Ft.	Min. Angle	Punch Radius Required @ Min. Angle	Min. Outside Radius @ Min. Angle inch [mm]	Max. Outside Radius @ 90° inch [mm]	US Short Ton/Ft.	Metric Tons/M	kN/M
V-SERIES BLACK (VSB) SPECIFICATIONS										
3	.157 [4.0]	.886 [22.5]	12	65°	.078	.453 [11.5]	.625 [15.9]	84	204	2000
	.187 [4.75]		26		.094					
	.250 [6.35]		30		.125					
3.5	.236 [6.0]	1.476 [37.5]	15	75°	.031	.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°	.031	.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]				



Scan QR Code to Watch the Video

Model	Shoulder Radius inch [mm]	Desired Angle	Theoretical V inch [mm]	Center Line of Inserts inch [mm]
V-OPENING AND SHOULDER RADIUS DIMENSIONS				
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]	



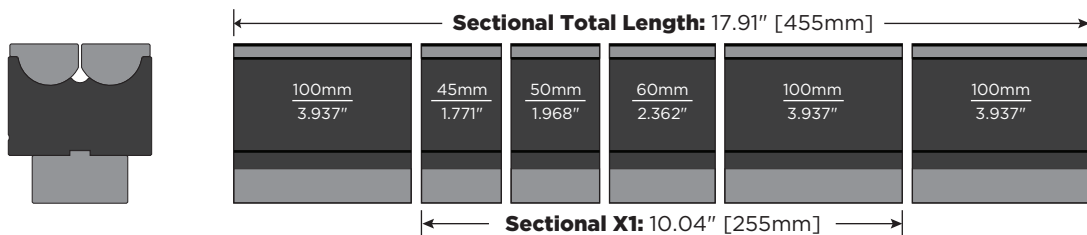
DESCRIPTION	Part No.
INSTALLATION TOOLS	
Spring Installation Tool Kit	981002
Spring Extension Wire (short)	981003
Spring Extension Wire (long)	981004

V-SERIES BLACK (VSB) DIES

V-Series Black (VSB) Standard Lengths

Models 3, 3.5 & 4

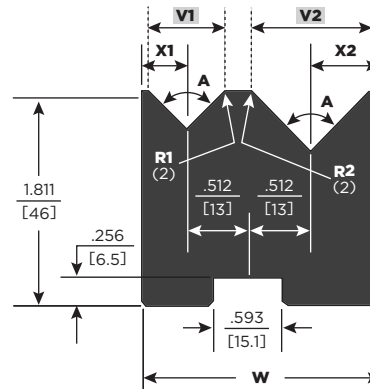
Solid Length Available: 9.84" [250mm] and 3.937" [100mm]



75°, 88° & 90° QUICK CHANGE 2V DIES



Scan QR Code to Watch the Video



EUROPEAN TRADITIONAL

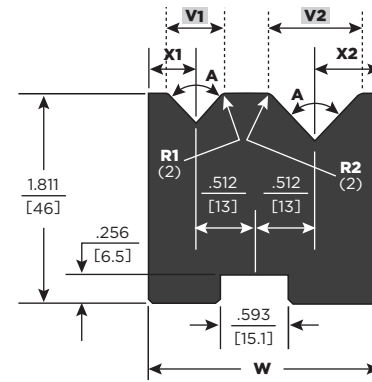
Part No.	A Angle	Max. Ton feet [m]	W Width inch [mm]	V1 inch [mm]	V2 inch [mm]	X1 inch [mm]	X2 inch [mm]	R1 inch [mm]	R2 inch [mm]	Weight lbs./inch [kg/mm]	LT	ST	XT
											32.87" [835mm]	16.34" [835mm]	32.87" [835mm]
75° QUICK CHANGE 2V DIES													
44100	75°	30 [100]	1.770 [45.0]	.394 [10.0]	.630 [16.0]	.304 [7.7]	.442 [11.2]	.098 [2.5]	.138 [3.5]	0.86 [0.15]			
44101			1.760 [44.7]	.236 [6.0]	.787 [20.0]	.206 [5.2]	.530 [13.5]	.059 [1.5]	.157 [4.0]				
44102			1.908 [48.5]	.394 [10.0]	.866 [22.0]	.304 [7.7]	.580 [14.7]	.098 [2.5]	.177 [4.5]				
44103			2.035 [51.7]	.472 [12.0]	.984 [25.0]	.354 [9.0]	.658 [16.7]	.118 [3.0]	.216 [5.5]				
88° QUICK CHANGE 2V DIES													
42004	88°	30 [100]	1.772 [45.0]	.551 [14.0]	.709 [18.0]	.335 [8.5]	.413 [10.5]	.019 [0.5]	.019 [0.5]	0.86 [0.15]			
42005			1.792 [45.5]	.472 [12.0]	.787 [20.0]	.295 [7.5]	.472 [12.0]	.019 [0.5]	.019 [0.5]				
42006			1.969 [50.0]	.630 [16.0]	.984 [25.0]	.374 [9.5]	.571 [14.5]	.031 [0.8]	.031 [0.8]				
42007		21 [70]	1.457 [37.0]	.236 [6.0]	.394 [10.0]	.177 [4.5]	.256 [6.5]	.016 [0.4]	.024 [0.6]	0.70 [0.12]			
42008		18 [60]	1.358 [34.5]	.158 [4.0]	.276 [7.0]	.138 [3.5]	.197 [5.0]	.016 [0.4]	.016 [0.4]				
42009		24 [80]	1.536 [39.0]	.315 [8.0]	.472 [12.0]	.217 [5.5]	.295 [7.5]	.019 [0.5]	.031 [0.8]				
90° QUICK CHANGE 2V DIES													
42000	90°	18 [60]	1.358 [34.5]	.158 [4.0]	.276 [7.0]	.138 [3.5]	.197 [5.0]	.016 [0.4]	.016 [0.4]	0.70 [0.12]			
42001		21 [70]	1.457 [37.0]	.236 [6.0]	.394 [10.0]	.177 [4.5]	.256 [6.5]	.016 [0.4]	.024 [0.6]				
42002		24 [80]	1.536 [39.0]	.315 [8.0]	.472 [12.0]	.217 [5.5]	.295 [7.5]	.019 [0.5]	.031 [0.8]	0.86 [0.15]			
42003		30 [100]	1.772 [45.0]	.551 [14.0]	.709 [18.0]	.335 [8.5]	.413 [10.5]	.019 [0.5]	.019 [0.5]				

Note: V-opening modifications and die relief available at an additional cost. Contact a Tooling Technician for pricing and lead times. Nitrex® standard on all 2V dies provides HRC-70.

= 30 lbs. / 13.6kg or more

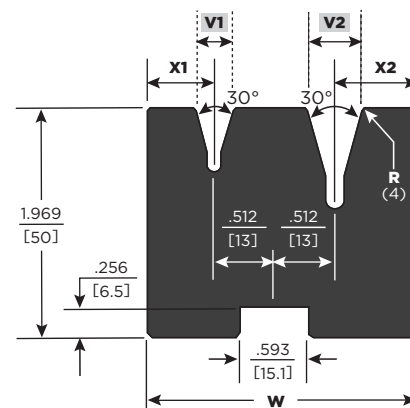


88° & 90° LARGE SHOULDER RADII QUICK CHANGE 2V DIES



Part No.	A Angle	Max. Ton feet [m]	W Width inch [mm]	V1 inch [mm]	V2 inch [mm]	X1 inch [mm]	X2 inch [mm]	R1 inch [mm]	R2 inch [mm]	Weight lbs./inch [kg/mm]	LT	ST	XT
											32.87" [835mm]	16.34" [835mm]	32.87" [835mm]
88° LARGE SHOULDER RADII QUICK CHANGE 2V DIES													
42012	88°	24 [80]	1.575 [40]	.236 [6.0]	.394 [10.0]	.236 [6.0]	.315 [8.0]	.059 [1.5]	.098 [2.5]	0.86 [0.15]			
42011		30 [100]	1.969 [50]	.472 [12.0]	.787 [20.0]	.394 [10.0]	.551 [14.0]	.118 [3.0]	.158 [4.0]	1.01 [0.18]			
90° LARGE SHOULDER RADII QUICK CHANGE 2V DIES													
42010	90°	24 [80]	1.575 [40]	.236 [6.0]	.394 [10.0]	.236 [6.0]	.315 [8.0]	.059 [1.5]	.098 [2.5]	0.86 [0.15]			

30° ACUTE ANGLE QUICK CHANGE 2V DIES

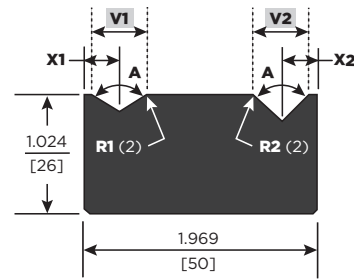


Part No.	A Angle	Max. Ton feet [m]	W Width inch [mm]	V1 inch [mm]	V2 inch [mm]	X1 inch [mm]	X2 inch [mm]	R1 inch [mm]	R2 inch [mm]	Weight lbs./inch [kg/mm]	LT	ST	XT
											32.87" [835mm]	16.34" [835mm]	32.87" [835mm]
30° ACUTE ANGLE QUICK CHANGE 2V DIES													
42020	30°	9 [30]	1.969 [50]	.236 [6.0]	.394 [10.0]	.354 [9.0]	.591 [15.0]	.039 [1.0]	.039 [1.0]	1.01 [0.18]			
42021		9 [30]	2.303 [58.5]	.315 [8.0]	.472 [12.0]	.571 [14.5]	709 [18.0]	.039 [1.0]	.039 [1.0]	1.29 [0.23]			

Note: V-opening modifications and die relief available at an additional cost. Contact a Tooling Technician for pricing and lead times. Nitrex® standard on all 2V dies provides HRC-70.

= 30 lbs. / 13.6kg or more

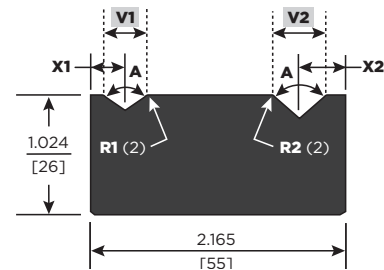
BOLT DOWN 2V DIES OLD STYLE



Part No.	A Angle	Max. Ton feet [m]	V1 inch [mm]	V2 inch [mm]	X1 inch [mm]	X2 inch [mm]	R1 inch [mm]	R2 inch [mm]	Weight lbs./inch [kg/mm]	LT	ST
										32.87" [835mm]	16.34" [835mm]
BOLT DOWN 2V DIES - OLD STYLE											
42030	90°	18 [60]	.158 [4.0]	.276 [7.0]	.138 [3.5]	.197 [5.0]	.016 [0.4]	.016 [0.4]	0.70 [.012]		
42031		21 [70]	.236 [6.0]	.394 [10.0]	.177 [4.5]	.256 [6.5]	.016 [0.4]	.024 [0.6]			
42032		24 [80]	.315 [8.0]	.472 [12.0]	.217 [5.5]	.295 [7.5]	.020 [0.5]	.031 [0.8]			
42033		30 [100]	.551 [14.0]	.709 [18.0]	.335 [8.5]	.413 [10.5]	.020 [0.5]	.020 [0.5]			
42034	88°	30 [100]	.551 [14.0]	.709 [18.0]	.335 [8.5]	.413 [10.5]	.020 [0.5]	.020 [0.5]			
42035		30 [100]	.472 [12.0]	.787 [20.0]	.295 [7.5]	.472 [12]	.020 [0.5]	.020 [0.5]			
42036		21 [70]	.630 [16.0]	.984 [25.0]	.374 [9.5]	.571 [14.5]	.031 [0.8]	.031 [0.8]			

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LARGE SHOULDER RADII 2V DIES OLD STYLE

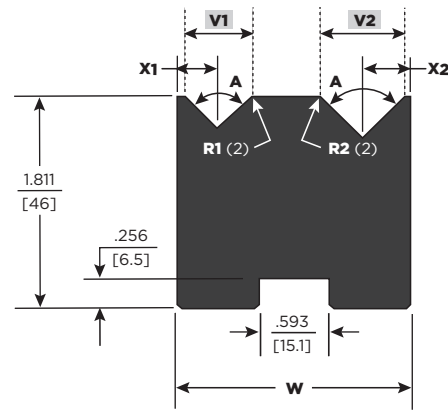


Part No.	A Angle	Max. Ton feet [m]	V1 inch [mm]	V2 inch [mm]	X1 inch [mm]	X2 inch [mm]	R1 inch [mm]	R2 inch [mm]	Weight lbs./inch [kg/mm]	LT	ST
										32.87" [835mm]	16.34" [835mm]
LARGE SHOULDER RADII 2V DIES - OLD STYLE											
42040	90°	24 [80]	.236 [6.0]	.394 [10.0]	.236 [6.0]	.394 [10.0]	.059 [1.5]	.098 [2.5]	0.70 [.012]		
42041	88°	30 [100]	.472 [12.0]	.787 [20.0]	.394 [10.0]	.591 [15.0]	.118 [3.0]	.157 [4.0]			

Note: All mounting hardware is included. V-opening modifications and die relief available at an additional cost. Contact a Tooling Technician for pricing and lead times. Nitrex® standard on all 2V dies provides HRC-70.



LARGE SHOULDER RADII 2V DIES SECTIONALIZED – OLD STYLE

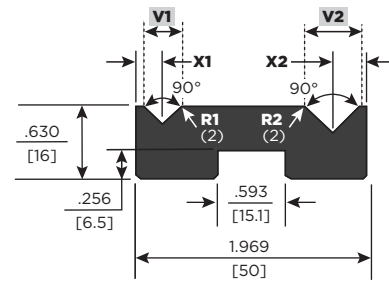


Part No.	A Angle	Max. Ton feet [m]	W Width inch [mm]	V1 inch [mm]	V2 inch [mm]	X1 inch [mm]	X2 inch [mm]	R1 inch [mm]	R2 inch [mm]	Weight lbs./inch [kg/mm]	XT
											32.87" [835mm]
LARGE SHOULDER RADII 2V DIES - SECTIONALIZED - OLD STYLE											
42050	90°	18 [60]	1.969 [50]	.158 [4.0]	.276 [7.0]	.138 [3.5]	.197 [5.0]	.016 [0.4]	.016 [0.4]	2.17 [.039]	1.01 [.018]
42051		21 [70]	1.969 [50]	.236 [6.0]	.394 [10.0]	.177 [4.5]	.256 [6.5]	.016 [0.4]	.023 [0.6]		
42052		21 [70]	1.969 [50]	.315 [8.0]	.472 [12.0]	.217 [5.5]	.295 [7.5]	.020 [0.5]	.031 [0.8]		
42053		30 [100]	1.969 [50]	.551 [14.0]	.709 [18.0]	.335 [8.5]	.413 [10.5]	.020 [0.5]	.020 [0.5]		
42070		24 [80]	2.165 [55]	.236 [6.0]	.394 [10.0]	.236 [6.0]	.394 [10.0]	.059 [1.5]	.098 [2.5]		
42054	88°	30 [100]	1.969 [50]	.551 [14.0]	.709 [18.0]	.335 [8.5]	.413 [10.5]	.020 [0.5]	.020 [0.5]		
42055			1.969 [50]	.472 [12.0]	.787 [20.0]	.295 [7.5]	.472 [12.0]	.020 [0.5]	.020 [0.5]		
42056			1.969 [50]	.630 [16.0]	.984 [25.0]	.374 [9.5]	.571 [14.5]	.031 [0.8]	.031 [0.8]		
42071			2.165 [55]	.472 [12.0]	.787 [20.0]	.394 [10.0]	.591 [15.0]	.118 [3.0]	.157 [4.0]		

EUROPEAN TRADITIONAL

Note: V-opening modifications and die relief available at an additional cost. Contact a Tooling Technician for pricing and lead times. Nitrex® standard on all 2V dies provides HRC-70.

LOW PROFILE 2V DIES SECTIONALIZED – OLD STYLE



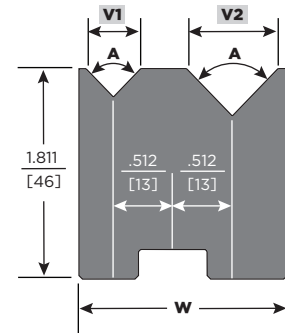
Part No.	A Angle	Max. Ton feet [m]	V1 inch [mm]	V2 inch [mm]	X1 inch [mm]	X2 inch [mm]	R1 inch [mm]	R2 inch [mm]	Weight lbs./inch [kg/mm]	XT
										32.87" [835mm]
LOW PROFILE 2V DIES – SECTIONALIZED – OLD STYLE										
42061	90°	21 [70]	.236 [6.0]	.394 [10.0]	.177 [4.5]	.256 [6.5]	.016 [0.4]	.023 [0.6]	0.33 [.006]	
42062			.315 [8.0]	.472 [12.0]	.217 [5.5]	.295 [7.5]	.019 [0.5]	.031 [0.8]		

Note: V-opening modifications and die relief available at an additional cost. Contact a Tooling Technician for pricing and lead times. Nitrex® standard on all 2V dies provides HRC-70.

EUROPEAN TRADITIONAL

URETHANE 2V DIES

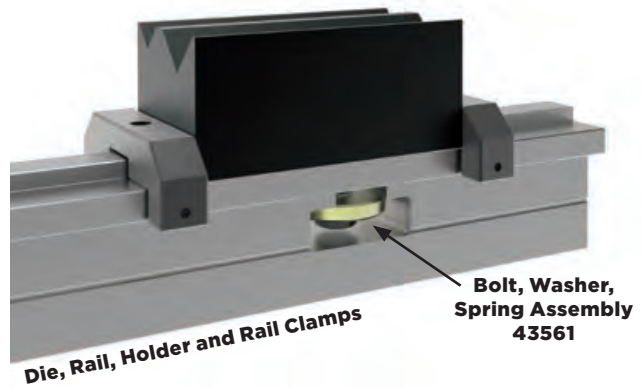
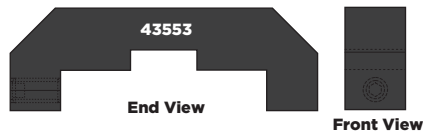
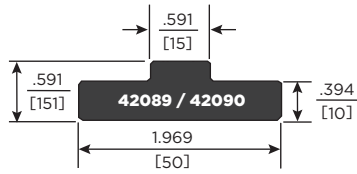
Durometer Rating is 75



Part No.	A Angle	V1 inch [mm]	V2 inch [mm]	H Height inch [mm]	W Width inch [mm]	Weight lbs./inch [kg/mm]	L	S
							32.87" [835mm]	16.34" [415mm]
URETHANE 2V DIES								
42001ue	90°	.23 [6]	.39 [10]	1.81 [46]	1.77 [45]	0.18 [.003]		
42002ue		.31 [8]	.47 [12]	1.81 [46]	1.77 [45]			
42004ue	88°	.55 [14]	.70 [18]	1.81 [46]	2.36 [60]			
42005ue		.47 [12]	.78 [20]	1.81 [46]	2.36 [60]			
42006ue		.63 [16]	.98 [25]	1.81 [46]	2.61 [66.5]			
42021ue	30°	.31 [8]	.47 [12]	1.81 [46]	2.36 [60]			

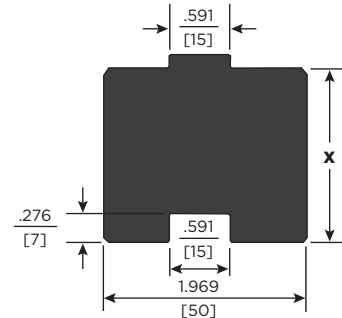


2V DIE RAILS & RAIL CLAMP



Part No.	Description	Weight lbs./[kg]	L	S
			32.87" [835mm]	16.34" [415mm]
42089	Die Rail [28-32 HRC]	0.33 lbs./inch [.006 kg/mm]		
42090	Die Rail [48-54 HRC]			
43561	Bolt, Washer, Spring Assembly	2 [.9]		
43553	Rail Clamp	1 [.45]		

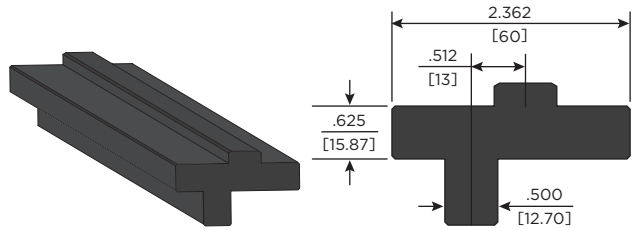
2V DIE STACKING RAILS



Part No.	Height Range	Weight lbs./inch [kg/mm]	L	S	X
			32.87" [835mm]	16.34" [415mm]	32.87" [835mm]
42091	X = .575 - 1.250	1.01 [.018]			
42092	X = 1.251 - 2.000	1.68 [.030]			
42093	X = 2.001 - 2.750				

= 30 lbs. / 13.6kg or more

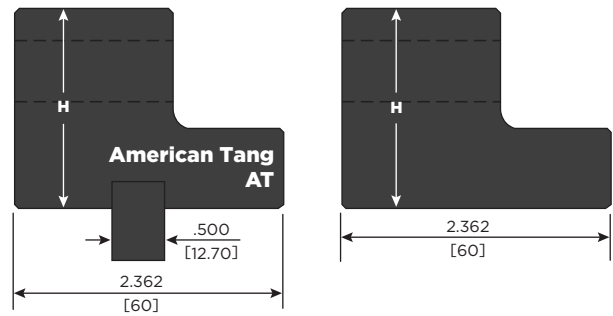
AMERICAN TO EUROPEAN RAIL ADAPTER



Part No.	Max. Ton feet [m]	Weight lbs./inch [kg/mm]	L	S
			32.87" [835mm]	16.34" [415mm]
FOR QUICK CHANGE 2V DIES				
53090	30 [100]	0.70 [.012]		

EUROPEAN TRADITIONAL

2V DIE HOLDERS

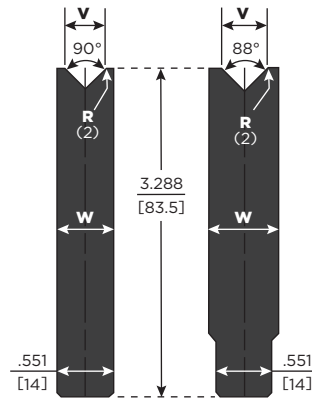


Part No.	H Height inch [mm]	Weight lbs./inch [kg/mm]	L	S
			32.76" [832mm]	16.22" [412mm]
43021 AT	1.536 [39]	0.70 [.012]		
43022 AT	1.772 [45]	0.86 [.015]		
43023 AT	2.953 [75]	1.29 [.023]	KG	
43021	1.536 [39]	0.70 [.012]		
43022	1.772 [45]	0.86 [.015]		
43023	2.953 [75]	1.29 [.023]	KG	

KG = 30 lbs. / 13.6kg or more



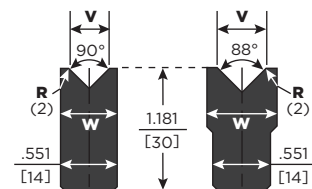
88° & 90° QUICK CHANGE 1V DIES



Part No.	Angle	Max. Ton feet [m]	W Width inch [mm]	V inch [mm]	R Radius inch [mm]	Weight lbs./inch [kg/mm]	LT	ST	XT
							32.87" [835mm]	16.34" [415mm]	32.87" [835mm]
88° QUICK CHANGE 1V DIES									
42120	88°	30 [100]	.551 [14.0]	.236 [6.0]	.059 [1.5]	0.51 [.009]			
42121			.551 [14.0]	.315 [8.0]	.059 [1.5]				
42122			.551 [14.0]	.394 [10.0]	.078 [2.0]				
42104			.669 [17.0]	.472 [12.0]	.098 [2.5]	0.70 [.012]			
42105			.709 [18.0]	.551 [14.0]	.098 [2.5]				
90° QUICK CHANGE 1V DIES									
42100	90°	30 [100]	.551 [14.0]	.236 [6.0]	.059 [1.5]	0.51 [.009]			
42101			.551 [14.0]	.315 [8.0]	.059 [1.5]				
42102			.551 [14.0]	.394 [10.0]	.078 [2.0]				
42103			.669 [17.0]	.472 [12.0]	.098 [2.5]	0.70 [.012]			

Note: Quick Change 1V Dies require die holder #43030 or #43530. V-opening modifications and die relief available at an additional cost. Contact a Tooling Technician for pricing and lead times. Nitrex® standard on all 1V dies provides HRC-70.

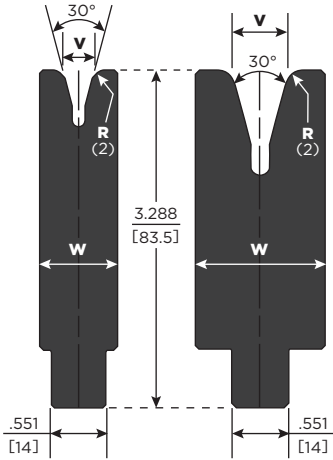
88° & 90° LOW PROFILE QUICK CHANGE 1V DIES



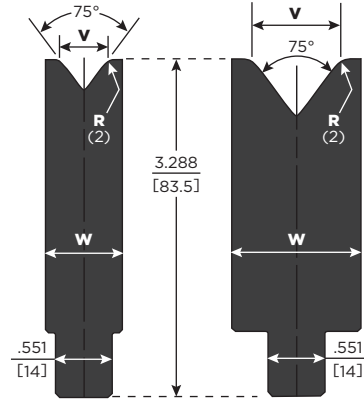
Part No.	Angle	Max. Ton feet [m]	W Width inch [mm]	V inch [mm]	R Radius inch [mm]	Weight lbs./inch [kg/mm]	S	X
							16.34" [415mm]	32.87" [835mm]
88° LOW PROFILE QUICK CHANGE 1V DIE								
42114	88°	30 [100]	.69 [17.0]	.472 [12.0]	.098 [2.5]	0.18 [.003]		
90° LOW PROFILE QUICK CHANGE 1V DIES								
42110	90°	30 [100]	.551 [14.0]	.236 [6.0]	.059 [1.5]	0.18 [.003]		
42111			.551 [14.0]	.315 [8.0]	.059 [1.5]			
42112			.551 [14.0]	.394 [10.0]	.078 [2.0]			

Note: Low Profile Quick Change 1V Dies require die holder #43030 or 43530. Nitrex® standard on all 1V dies provides HRC-70.

30° ACUTE ANGLE QUICK CHANGE 1V DIES



75° QUICK CHANGE 1V DIES



EUROPEAN TRADITIONAL

Part No.	Angle	Max. Ton feet [m]	W Width inch [mm]	V inch [mm]	R Radius inch [mm]	Weight lbs./inch [kg/mm]	LT	ST	XT
							32.87" [835mm]	16.34" [415mm]	32.87" [835mm]
30° QUICK CHANGE 1V DIES									
42200	30°	22 [76]	.630 [16.0]	.236 [6.0]	.118 [3.0]	0.51 [.009]			
42201		27 [90]	.748 [19.0]	.315 [8.0]	.118 [3.0]				
42202		30 [100]	.945 [24.0]	.394 [10.0]	.118 [3.0]	0.70 [.012]			
42203		30 [100]	1.102 [28.0]	.472 [12.0]	.197 [5.0]				
42204		30 [100]	1.260 [32.0]	.551 [14.0]	.197 [5.0]	.086 [0.15]			
42205		30 [100]	1.417 [36.0]	.630 [16.0]	.197 [5.0]				

Part No.	A Angle	Max. Ton feet [m]	W Width inch [mm]	V inch [mm]	R Radius inch [mm]	Weight lbs./inch [kg/mm]	LT	ST	XT	
							32.87" [835mm]	16.34" [415mm]	32.87" [835mm]	
75° QUICK CHANGE 1V DIES										
44200	75°	30 [100]	.551 [14.0]	.118 [3.0]	.016 [0.4]	0.51 [.009]				
44201			.551 [14.0]	.236 [6.0]	.059 [1.5]					
44202			.669 [17.0]	.394 [10.0]	.098 [2.5]	0.70 [.012]				
44203			.748 [19.0]	.472 [12.0]	.118 [3.0]					
44204			.945 [24.0]	.630 [16.0]	.138 [3.5]	0.86 [.015]				
44205			1.102 [28.0]	.787 [20.0]	.157 [4.0]					
44206			1.260 [30.0]	.866 [22.0]	.177 [4.5]	1.01 [.018]				
44207			1.417 [36.0]	.984 [25.0]	.216 [5.5]	1.06 [.019]				

Note: V-opening modifications and die relief available at an additional cost. Contact a Tooling Technician for pricing and lead times. Nitrex® standard on all Quick Change 1V dies provides HRC-70.



QUICK CHANGE IV DIE WEDGE BLOCK



Top View

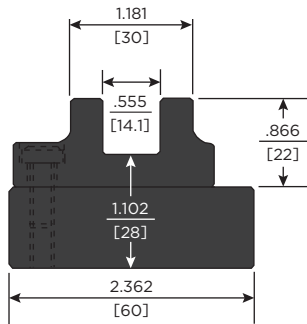


Side View



Part No.	Price
43559	

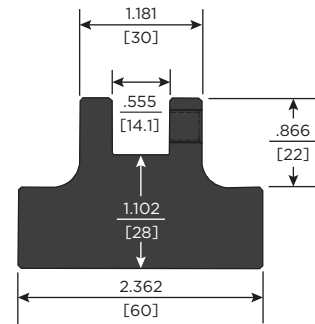
QUICK CHANGE IV DIE HOLDERS



Two Piece Design
(No Set Screw for Mounting)

Part No.	Weight lbs./inch [kg/mm]	L	S
		32.87" [835mm]	16.34" [415mm]
TWO PIECE DESIGN			
43030	0.86 [.015]		

Tangs for American or WT Style tooling can be added to the base of this die holder.

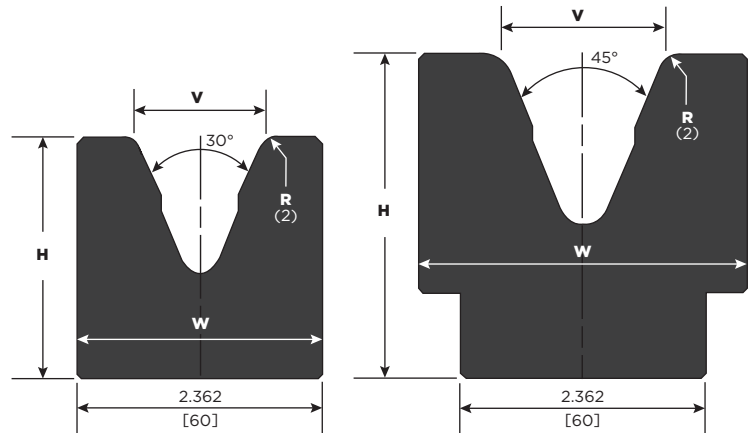








One Piece Design
(With Set Screw for Mounting)

Part No.	Weight lbs./inch [kg/mm]	L	S
		32.87" [835mm]	16.34" [415mm]
ONE PIECE DESIGN			
43530	0.86 [.015]		

Tangs for American or WT Style tooling can be added to the base of this die holder.


30° & 45° ACUTE ANGLE LARGE 1V DIES



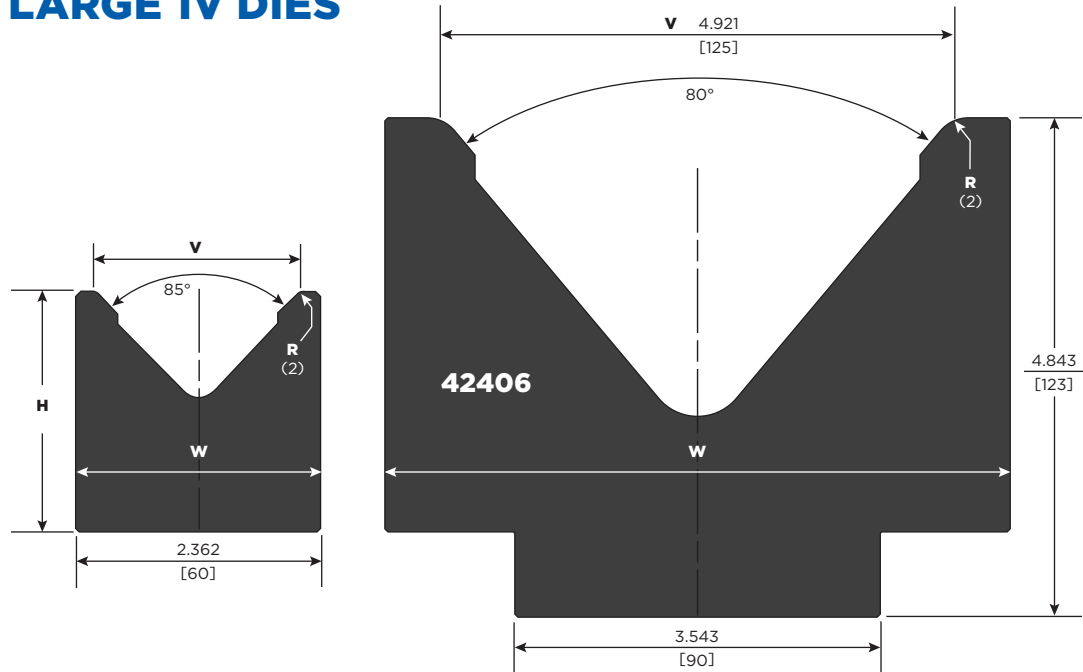
Part No.	A Angle	Max. Ton feet [m]	W Width inch [mm]	H Height inch [mm]	V inch [mm]	R Radius inch [mm]	Weight lbs./inch [kg/mm]	LT	ST
								32.87" [835mm]	16.34" [415mm]
30° ACUTE ANGLE LARGE 1V DIES									
42300	30°	24 [80]	2.362 [60.0]	2.362 [60.0]	.709 [18.0]	.118 [3.0]	1.54 [.027]		
42301		18 [60]	2.362 [60.0]	2.559 [65.0]	.984 [25.0]	.157 [4.0]			
45° ACUTE ANGLE LARGE 1V DIES									
42302	45°	12 [40]	2.362 [60.0]	2.362 [60.0]	1.260 [32.0]	.196 [5.0]	1.29 [.023]		
42303		21 [70]	3.150 [80.0]	3.150 [80.0]	1.575 [40.0]	.196 [5.0]	2.17 [.039]		
42304		21 [70]	3.740 [95.0]	3.740 [95.0]	1.969 [50.0]	.236 [6.0]	2.93 [.052]		

Tangs for American or WT-Style tooling can be added to the base of these dies.

Note: Acute Angle Large 1V Dies may require die holder #43040. Check height against machine stroke prior to ordering. V-opening modifications and die relief available at an additional cost. Contact a Tooling Technician for pricing and lead times. Nitrex® standard on all large 1V dies provides HRC-70.

 = 30 lbs. / 13.6kg or more

80° & 85° LARGE 1V DIES



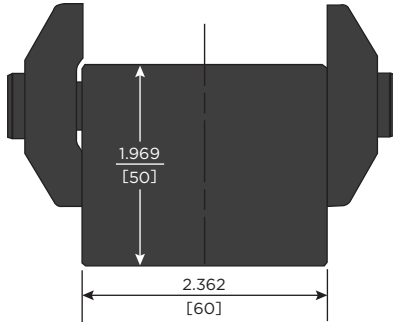
Part No.	A Angle	Max. Ton feet [m]	W Width inch [mm]	H Height inch [mm]	V inch [mm]	R Radius inch [mm]	Weight lbs./inch [kg/mm]	LT	ST
								32.87" [835mm]	16.34" [415mm]
85° LARGE 1V DIES									
42400	85°	30 [100]	2.362 [60.0]	2.362 [60.0]	1.260 [32.0]	.157 [4.0]	1.54 [.027]		
42401			2.362 [60.0]	2.362 [60.0]	1.575 [40.0]	.157 [4.0]	.129 [.023]		
42402			2.362 [60.0]	2.362 [60.0]	1.968 [50.0]	.157 [4.0]			
42403			3.150 [80.0]	2.953 [75.0]	2.480 [63.0]	.196 [5.0]	1.92 [.034]		
42404			3.740 [95.0]	3.740 [95.0]	3.150 [80]	.236 [6.0]	2.77 [.049]		
42405			4.724 [120.0]	4.331 [110.0]	3.937 [100]	.275 [7.0]	3.87 [.069]		
80° LARGE 1V DIE									
42406	80°	30 [100]	6.063 [154.0]	4.843 [123.0]	4.921 [125]	.354 [9.0]	5.36 [.096]	—	


Tangs for American or WT-Style tooling can be added to the base of these dies.

Note: Large 1V Dies may require die holder #43040. Check height against machine stroke prior to ordering. V-opening modifications and die relief available at an additional cost. Contact a Tooling Technician for pricing and lead times. Nitrex® standard on all large 1V dies provides HRC-70.

= 30 lbs. / 13.6kg or more

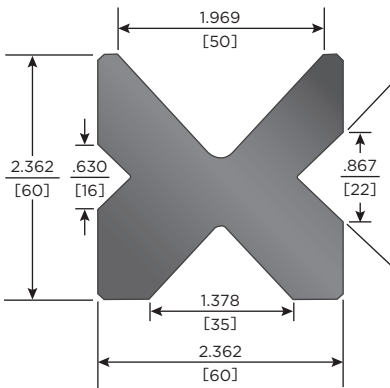
1V DIE HOLDER



Part No.	Weight lbs./inch [kg/mm]	L	S
		32.87" [835mm]	16.34" [415mm]
43040	1.68 [.030]		


Note: Large 1V Dies may require die holder #43040. Check height against machine stroke prior to ordering. Please check width of lower beam of press brake prior to ordering die #42406. V-opening modifications and die relief available at an additional cost. Contact a Tooling Technician for pricing and lead times. Tangs for American or WT-Style tooling can be added to the base of this die holder.

4-WAY DIE



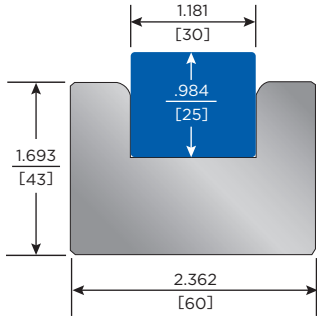
Part No.	V-Opening inch [mm]		Angle	Max. Ton feet [m]
42340c	V1	.630 [16]	88°	30 [100]
	V2	1.378 [35]	85°	
	V3	.867 [22]	88°	
	V4	1.969 [50]	85°	

Note: 4-Way Die is hardened, but does not have Nitrex® surface enhancement.

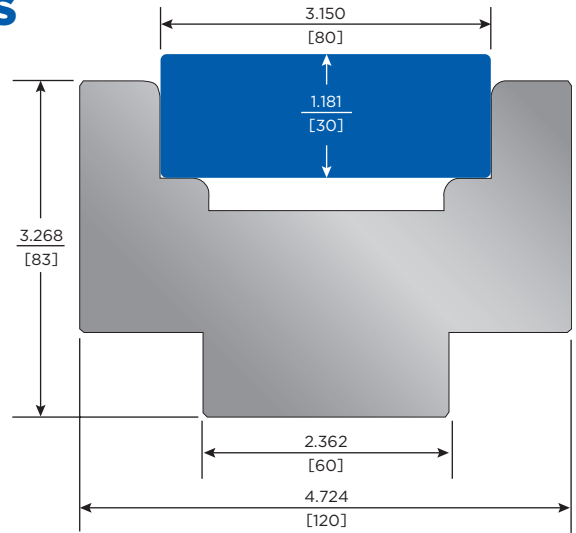
 = 30 lbs. / 13.6kg or more

URETHANE DIE HOLDERS & PADS

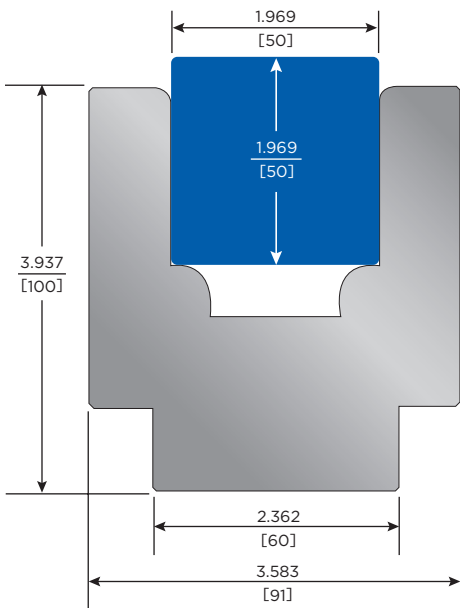
All urethane die holders are machined from 6061-T6 aluminum. Urethane holders may require die holder #43040. Check height against machine stroke prior to ordering. Tangs for American or WT-Style tooling can be added to the base of these urethane die holders.



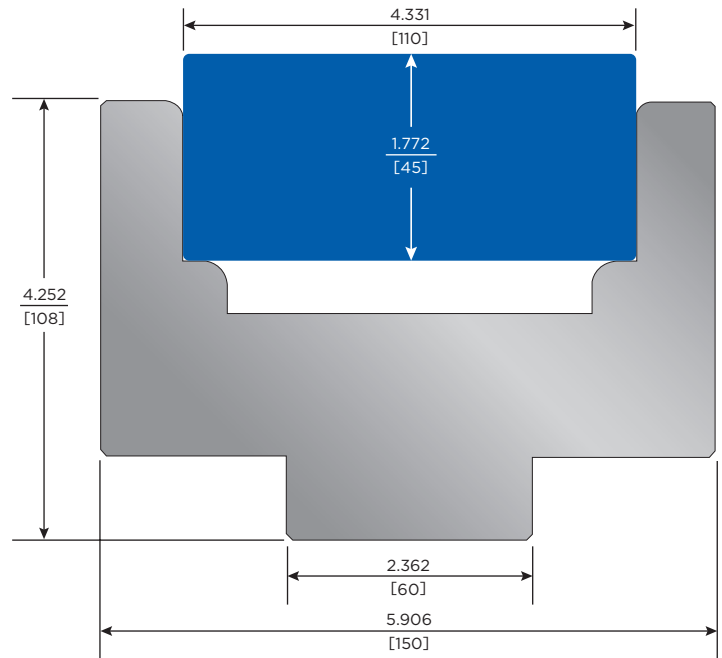
Part No.	Description	Shore Hardness	L	S
			32.87" [835mm]	16.34" [415mm]
42501	Holder	—		
42511	Pad	80A/Red		
42521	Pad	90A/Blue		



Part No.	Description	Shore Hardness	L	S
			32.87" [835mm]	16.34" [415mm]
42503	Holder	—		
42513	Pad	80A/Red		
42523	Pad	90A/Blue		



Part No.	Description	Shore Hardness	L	S
			32.87" [835mm]	16.34" [415mm]
42502	Holder	—		
42512	Pad	80A/Red		
42522	Pad	90A/Blue		



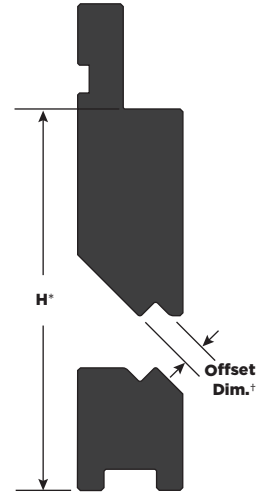
Part No.	Description	Shore Hardness	L	S
			32.87" [835mm]	16.34" [415mm]
42504	Holder	—		
42514	Pad	80A/Red		
42524	Pad	90A/Blue		

EUROPEAN TRADITIONAL

RAIL STYLE OFFSET TOOLS (NON-QUICK CHANGE)



Scan QR Code to Watch the Video



EUROPEAN TRADITIONAL

Part No.		Max. Ton feet [m]	Max. Material	H* Height inch [mm]	Offset Dim.† inch [mm]	Effective V	Weight lbs./inch [kg/mm]	LT	ST	XT	
Straight	Beveled							32.87" [835mm]	16.34" [415mm]	32.87" [835mm]	
RAIL STYLE OFFSET TOOLS (NON-QUICK CHANGE)											
43100	43100B	30 [100]	20g	3.701 [94.0]	.125 [3.2]	.177"	1.29 [.023]				
43101	43101B		18g	3.657 [92.9]	.188 [4.8]	.266"					
43102	43102B		16g	3.612 [91.8]	.250 [6.4]	.354"					
43103	43103B		14g	3.569 [90.7]	.312 [7.9]	.441"					
43104	43104B		13g	3.524 [89.5]	.375 [9.5]	.530"					
43105	43105B		12g	3.480 [88.9]	.438 [11.1]	.619"					1.54 [.027]
43106	43106B		12g	3.436 [87.3]	.500 [12.7]	.707"					

*Dimensions are for shut height.

†Offset height may vary as much as -.020" (0.5mm) after bending. All angles will be obtuse. Special offset sizes are available at additional cost. Nitrex® (HRC-70) standard on all dies. Max. Material listed will not yield a 90° bend, but is safe to use for obtuse bending.

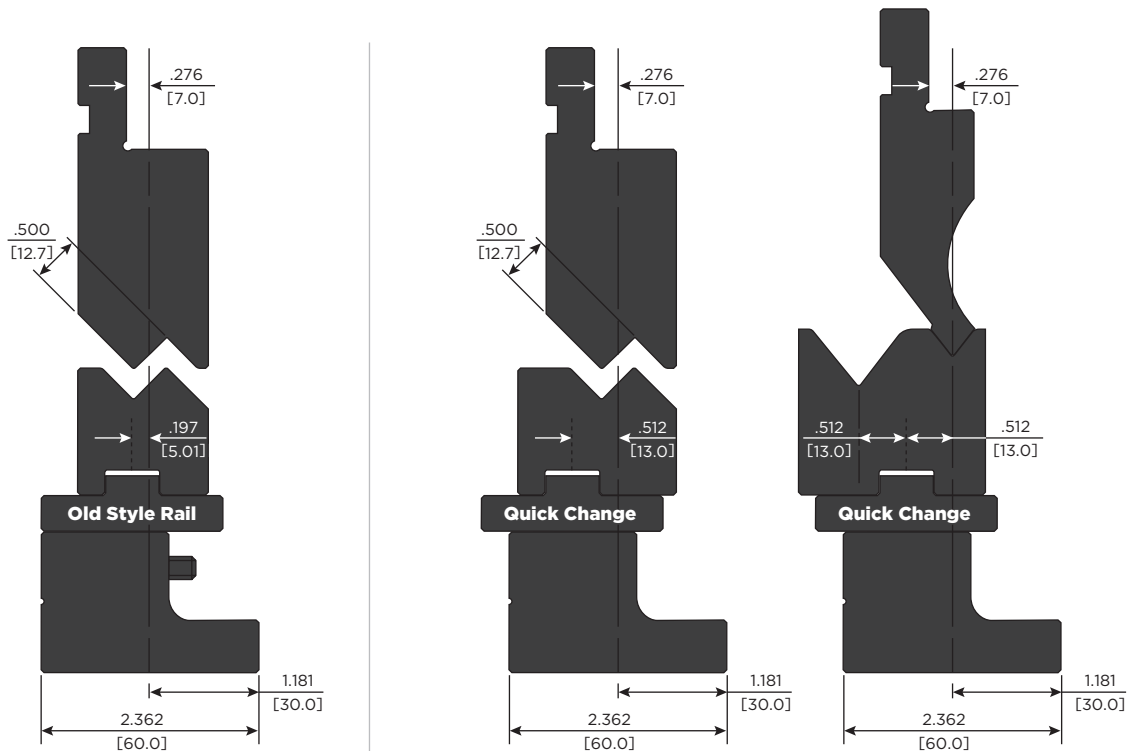
= 30 lbs. / 13.6kg or more



TRUE QUICK CHANGE TOOLS

Interchangeable with Quick Change 2V Dies without the need for re-centering.


(Dies can be used with existing punches — the punch does not change.)



Rail Needs Alignment

No Rail Alignment Needed

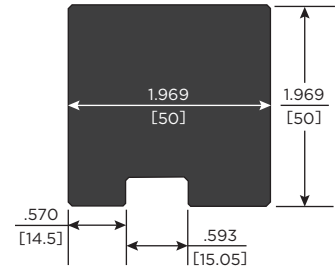
Can be run on the same rail as a Quick Change 2V Die

Part No. Punch & Die Assembly		Max. Ton feet [m]	Max. Material	Offset Dim.+ inch [mm]	Effective V inch [mm]	Assembly Weight lbs./inch [kg/mm]	LT	ST	XT	Die Only		
Straight	Beveled						32.87" [835mm]	16.34" [415mm]	32.87" [835mm]	Part No.	Weight lbs./inch [kg/mm]	Price
43100xxQC	43100xxBQC	30 [100]	20g	.125 [3.2]	.177 [4.5]	1.25 [0.23]				43534xxQC	0.51 [0.009]	
43101xxQC	43101xxBQC		18g	.188 [4.8]	.266 [6.8]					43536xxQC		
43102xxQC	43102xxBQC		16g	.250 [6.4]	.354 [9.0]					43538xxQC		
43103xxQC	43103xxBQC		14g	.312 [7.9]	.441 [11.2]	1.54 [0.27]				43540xxQC	0.70 [0.012]	
43104xxQC	43104xxBQC		13g	.375 [9.5]	.530 [13.5]					43542xxQC		
43105xxQC	43105xxBQC		12g	.438 [11.1]	.619 [15.7]					43544xxQC		
43106xxQC	43106xxBQC		12g	.500 [12.7]	.707 [18.0]					43546xxQC		

EUROPEAN TRADITIONAL

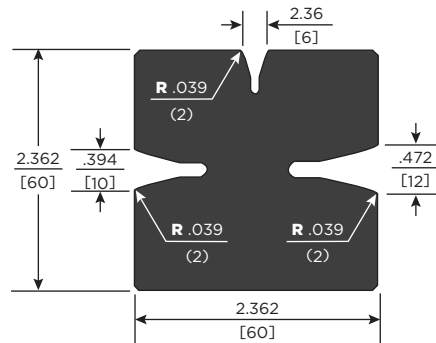
RAIL STYLE FLATTENING DIE – QUICK CHANGE

Part No.	Max. Ton feet [m]	Weight lbs./inch [kg/mm]	LT	ST	XT
			32.87" [835mm]	16.34" [415mm]	32.87" [835mm]
42312	30 [100]	0.86 [.015]			



Note: Designed to run with standard 2V Quick Change die system. Custom heights available for stage bending. Contact a Tooling Technician for pricing and lead times. Nitrex® standard on all Quick Change dies provides HRC-70.

3V FLATTENING DIE



Part No.	Max. Ton feet [m]	V1 inch [mm]	V2 inch [mm]	V3 inch [mm]	Weight lbs./inch [kg/mm]	LTR	STR
						32.87" [835mm]	16.34" [415mm]
42310	30 [100]	.236 [6.0]	.394 [10.0]	.472 [12.0]	1.54 [.027]	KG	
42310R							

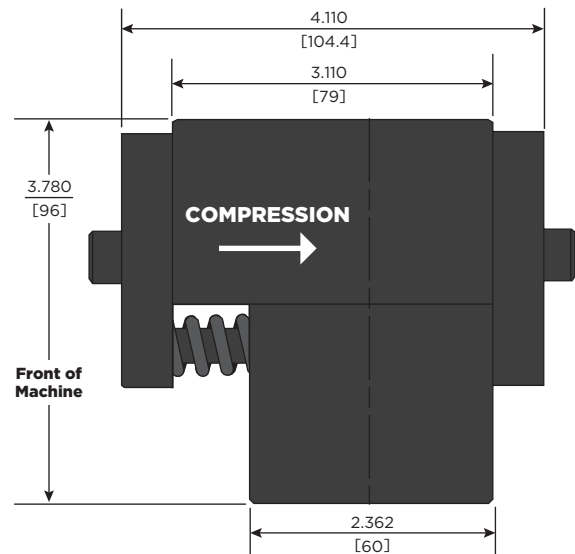
Nitrex® standard on all dies provides HRC-70.

THRUST ABSORBING FLATTENING DIE

Part No.	Max. Ton feet [m]	Weight lbs./inch [kg/mm]	L	S
			32.87" [835mm]	16.34" [415mm]
42311	30 [100]	3.59 [.064]	KG	KG

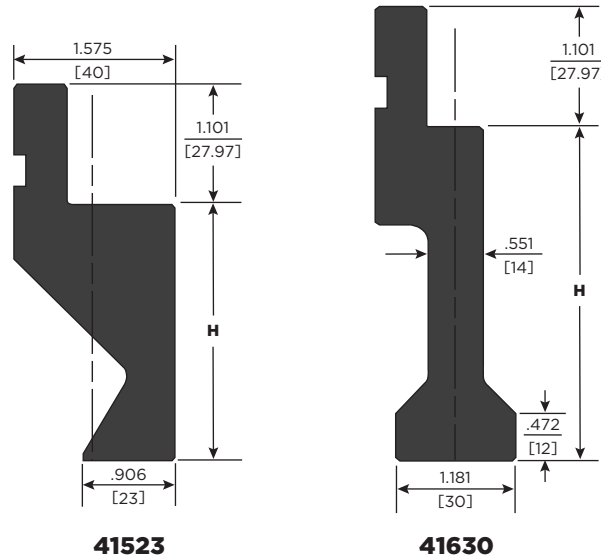
Nitrex® standard on all dies provides HRC-70.

Tangs for American or WT-Style tooling can be added to the base of this die.



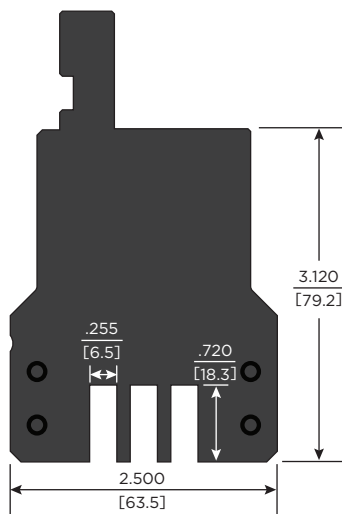
KG = 30 lbs. / 13.6kg or more

FLATTENING PUNCHES



Part No.		H Height inch [mm]	Max. Ton feet [m]	Weight lbs./inch [kg/mm]	LT	ST
Straight	Beveled				32.87" [835mm]	16.34" [415mm]
41523	41523B	2.559 [65.0]	30 [100]	1.01 [.018]		
41630	41630B	3.307 [84.0]				

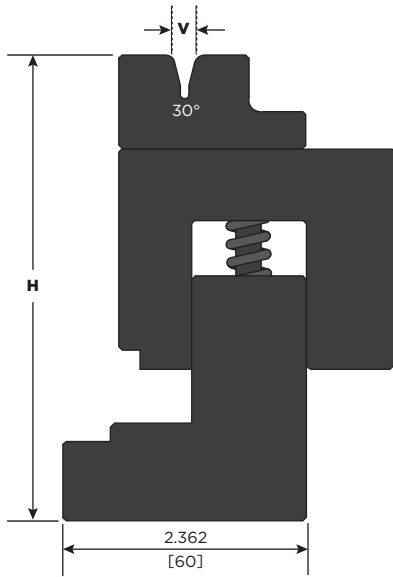
LETTER STAMP



Part No.		Description	Size	Price
Straight	Beveled			
4LSP25	4LSP25B	Punch Character Holder	—	
	6898	Characters (requires 26/row)	3/32"	
	6896	Characters (requires 20/row)	1/8"	

= 30 lbs. / 13.6kg or more

TWO STAGE HEMMING DIES

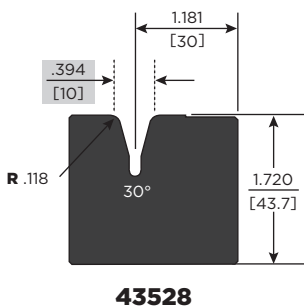
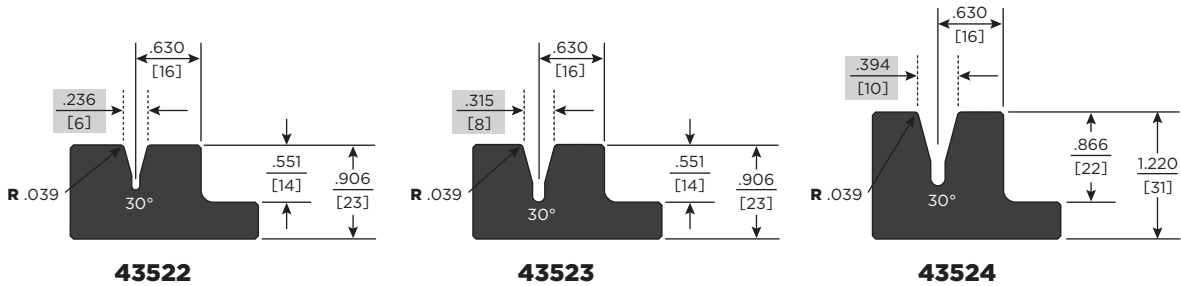


Part No.	V inch [mm]	H Height inch [mm]	Max. Ton feet [m]	Max. Material	Weight lbs./inch [kg/mm]	LT	ST
						32.87" [835mm]	16.34" [415mm]
42601	.236 [6.0]	4.587 [116.5]	20 [67]	20 GA. CRS	2.77 [.049]		
42602	.315 [8.0]	4.587 [116.5]	20 [67]	16 GA. CRS			
42603	.394 [10.0]	4.902 [124.5]	20 [67]	14 GA. CRS			
42608	.394 [10.0]	5.402 [137.2]	25 [83]	14 GA. CRS	3.09 [.055]		

Tangs for American or WT-Style tooling can be added to the base of this die.

EUROPEAN TRADITIONAL

REPLACEMENT V-BLOCKS FOR HEMMING DIES



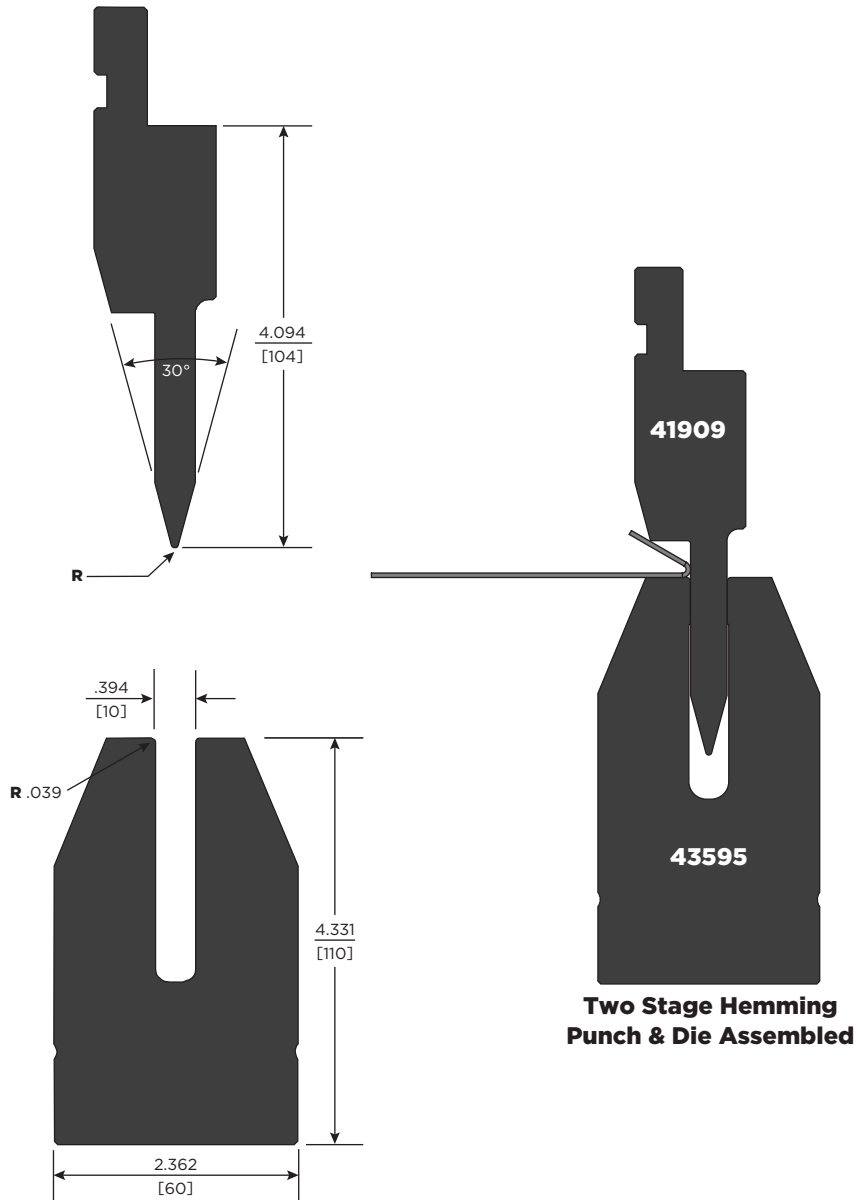
Part No.	Max. Ton feet [m]	Max. Material	V inch [mm]	Weight lbs./inch [kg/mm]	LT	ST
					32.87" [835mm]	16.34" [415mm]
43522	20 [67]	20 GA. CRS	.236 [6.0]	0.33 [.006]		
43523	20 [67]	16 GA. CRS	.315 [8.0]			
43524	20 [67]	14 GA. CRS	.394 [10.0]			
43528	25 [83]	14 GA. CRS	.394 [10.0]	1.01 [.018]		

Nitrex® (HRC-70) standard on all dies.

= 30 lbs. / 13.6kg or more



TWO STAGE HEMMING PUNCH & DIE



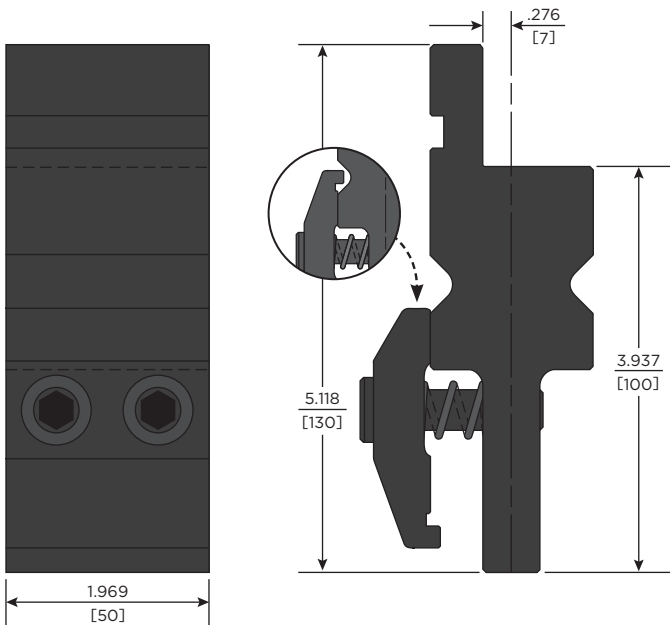
EUROPEAN TRADITIONAL

Part No.		Max. Ton feet [m]	R Radius inch [mm]	Height inch [mm]	Weight lbs./inch [kg/mm]	LT	ST	XT
Straight	Beveled					32.87" [835mm]	16.34" [415mm]	32.87" [835mm]
41909	41909B	30 [100]	.030 [.8]	4.094 [104]	1.01 [.018]			
43595			.039 [1]	4.331 [110]	2.17 [.039]			—

16 ga. Stainless Steel maximum material. Nitrex® (HRC-70) standard on all dies.

= 30 lbs. / 13.6kg or more

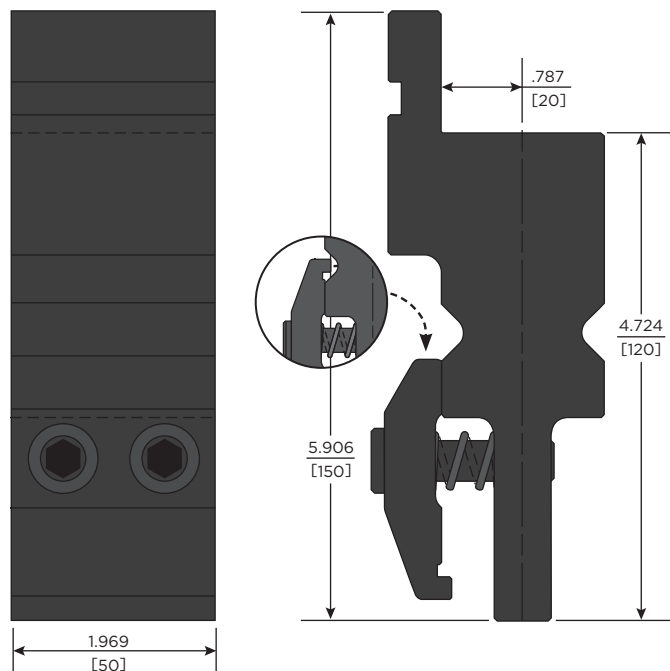
Z1 NARROW PUNCH HOLDER



Part No.		Max. Ton	Weight	Price
Straight	Beveled	feet [m]	lbs. [kg]	
Z1 NARROW PUNCH HOLDER				
43000	43000B	30 [100]	4 [1.48]	

The clamp plate included with this punch holder will accommodate a punch with or without a safety groove.

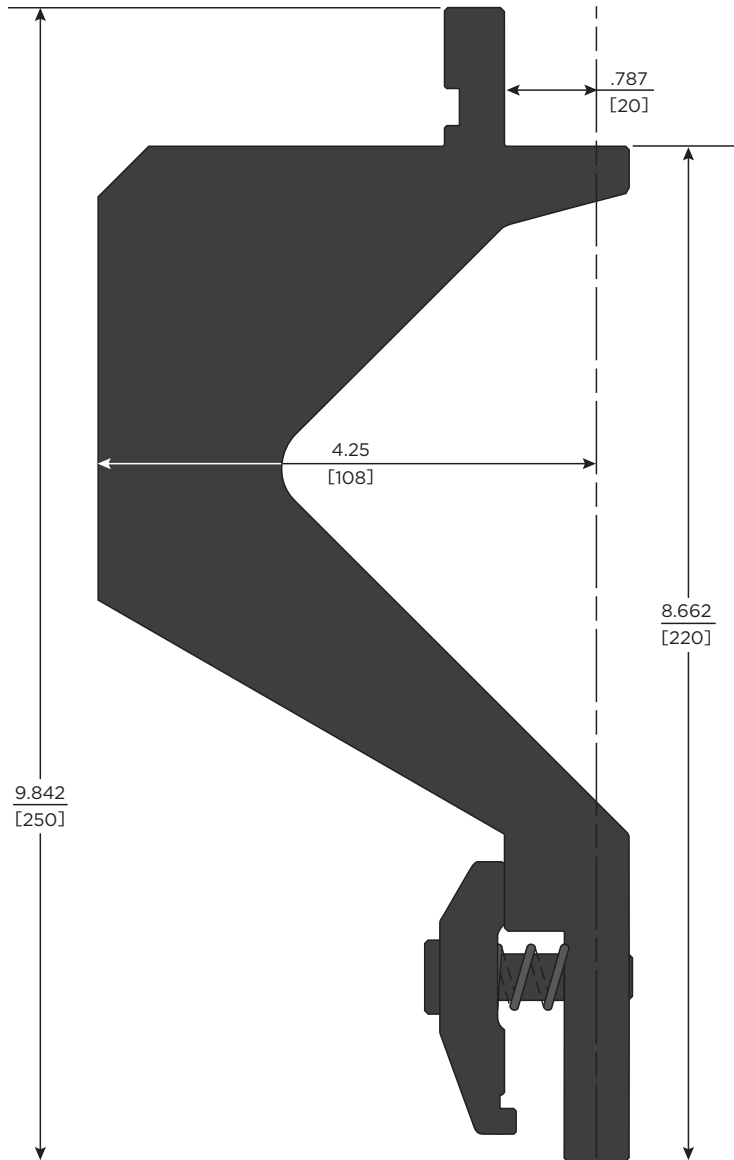
Z2 NARROW PUNCH HOLDER



Part No.		Max. Ton	Weight	Price
Straight	Beveled	feet [m]	lbs. [kg]	
Z2 NARROW PUNCH HOLDER				
43001	43001B	30 [100]	5 [1.97]	

The clamp plate included with this punch holder will accommodate a punch with or without a safety groove.

Z2 DEEP PUNCH HOLDER



43002
Z2 Punch Holder

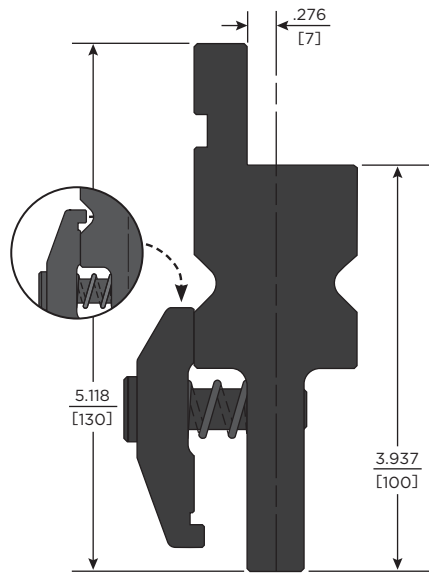
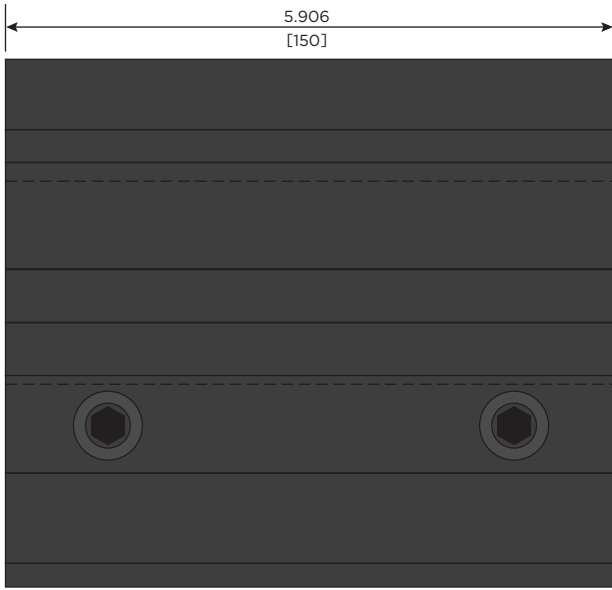


980079
Z1 Conversion Kit

Part No.	Max. Ton feet [m]	Weight lbs. [kg]	Length inch [mm]	Price
43002	15 [50]	29 [13.13]	5.906 [150]	
980079	Z1 Conversion Kit	5 [1.9]	5.906 [150]	

Punch holder #43002 is designed for Z2 style upper beams, but may be modified for a Z1 center by using Kit #980079.

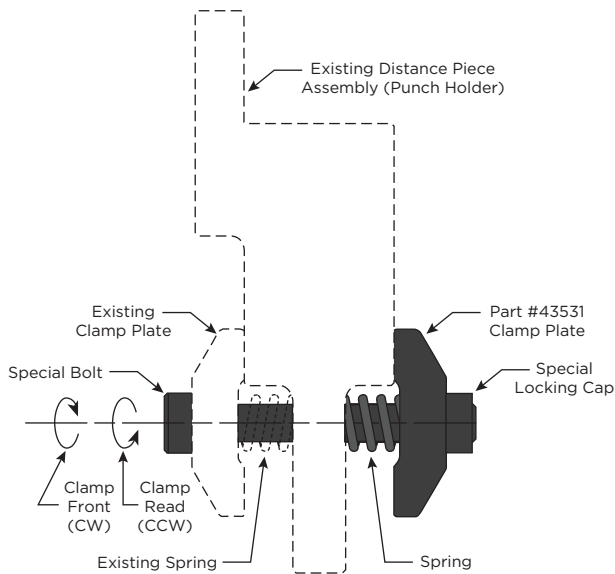
STACKING PUNCH HOLDER



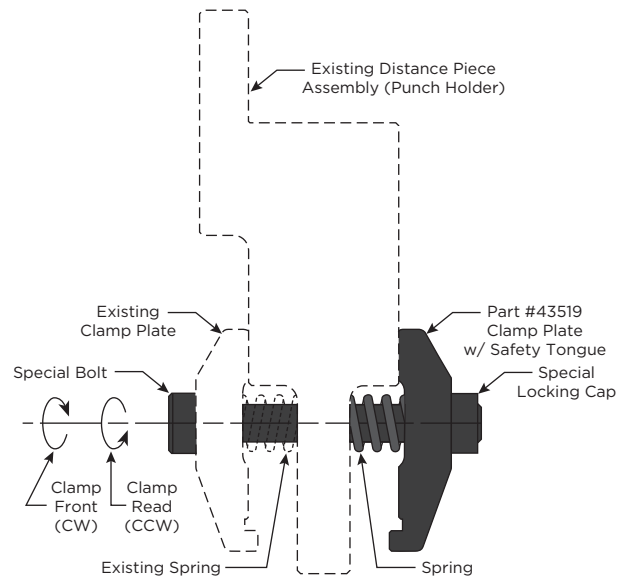
Part No.	Max. Ton feet [m]	Weight lbs. [kg]	Price
43003	30 [100]	10 [4.32]	

The clamp plate included with this punch holder will accommodate a punch with or without a safety groove. Beveled tang available upon request.

DUAL CLAMPING KITS



42710 Shown

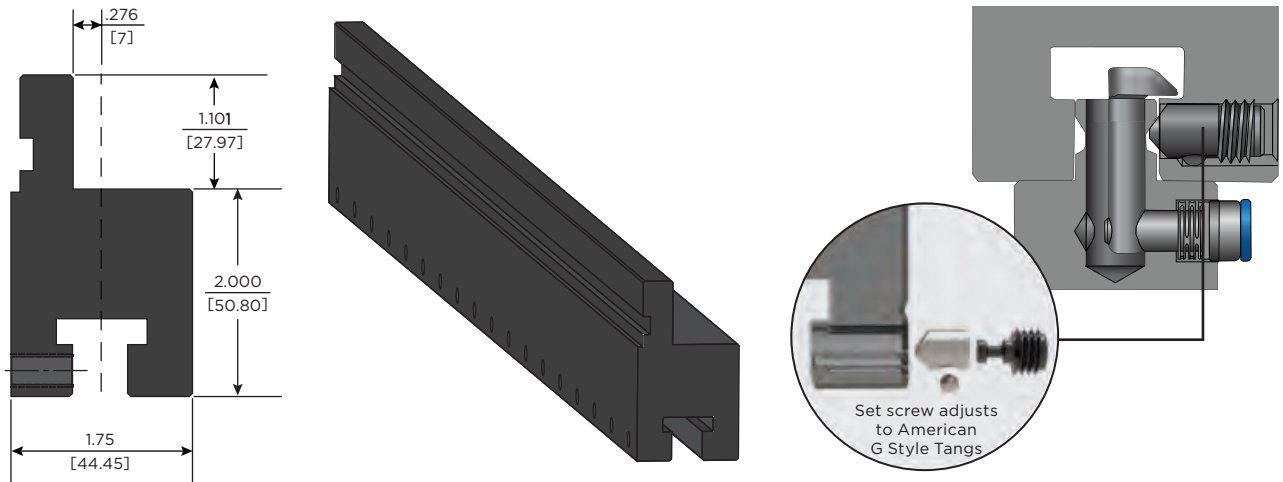


42720 Shown

Part No.	Description	Weight lbs. [kg]	Price
42710	Flat Clamp Kit	2 [0.83]	
43531	Flat Clamp Plate	2 [0.69]	

Part No.	Description	Weight lbs. [kg]	Price
42720	Safety Clamp Kit	3 [0.99]	
43519	Safety Clamp Plate	2 [0.85]	

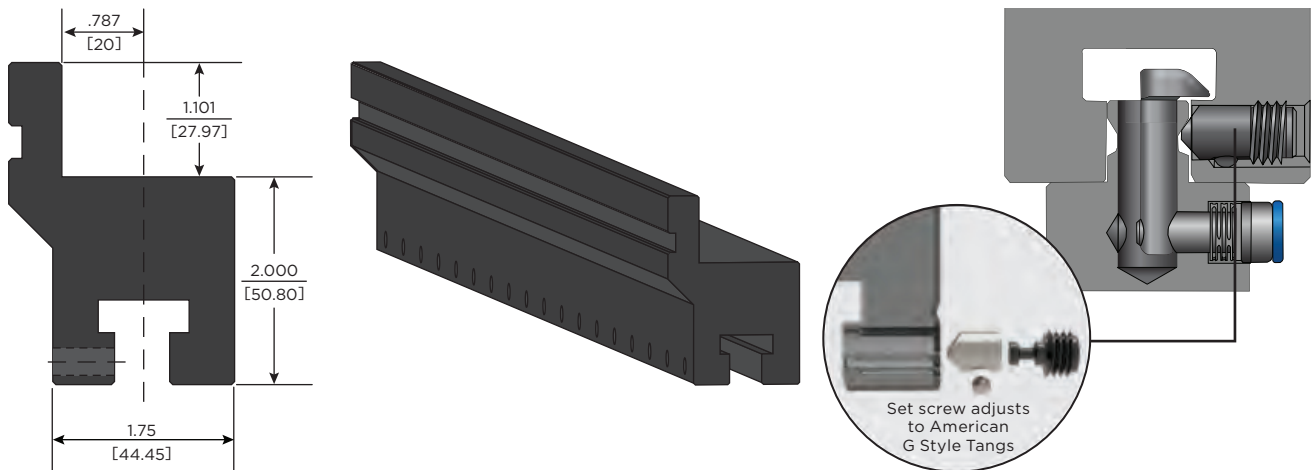
EUROPEAN Z1 TO AMERICAN PUNCH ADAPTER



Part No.	Max. Ton feet [m]	Weight lbs./inch [kg/mm]	L	S	X
			36" [915mm]	18" [457mm]	36" [915mm]
43851 (Straight)	30 [100]	1.01 [.018]			
43861 (Groove)	30 [100]	1.01 [.018]			

All holders include clamping set screws every 2" [50.8mm]. All tonnages are based on direct load and do not apply for thrusting applications. #43851 is a self-seating punch holder for American G Style Punches.

EUROPEAN Z2 TO AMERICAN PUNCH ADAPTER

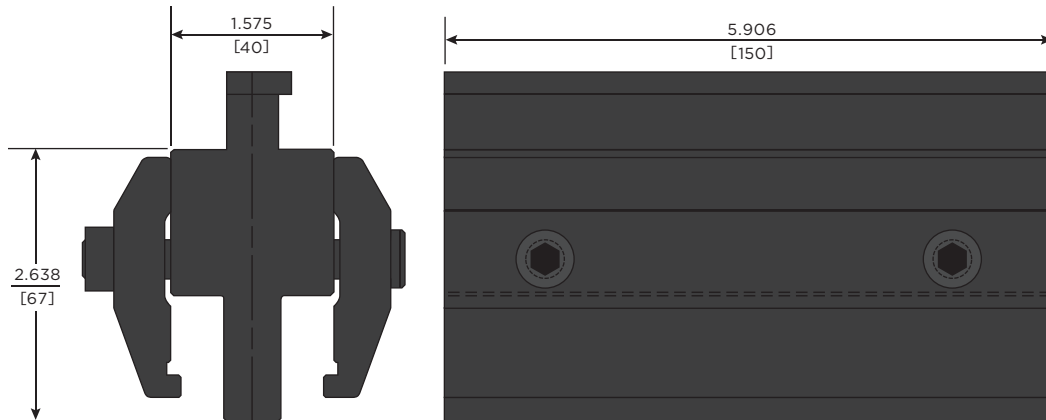


Part No.	Max. Ton feet [m]	Weight lbs./inch [kg/mm]	L	S	X
			36" [915mm]	18" [457mm]	36" [915mm]
43852 (Straight)	30 [100]	1.16 [.021]			
43862 (Groove)	30 [100]	1.16 [.021]			

All holders include clamping set screws every 2" [50.8mm]. All tonnages are based on direct load and do not apply for thrusting applications. #43852 is a self-seating punch holder for American G Style Punches.

= 30 lbs. / 13.6kg or more

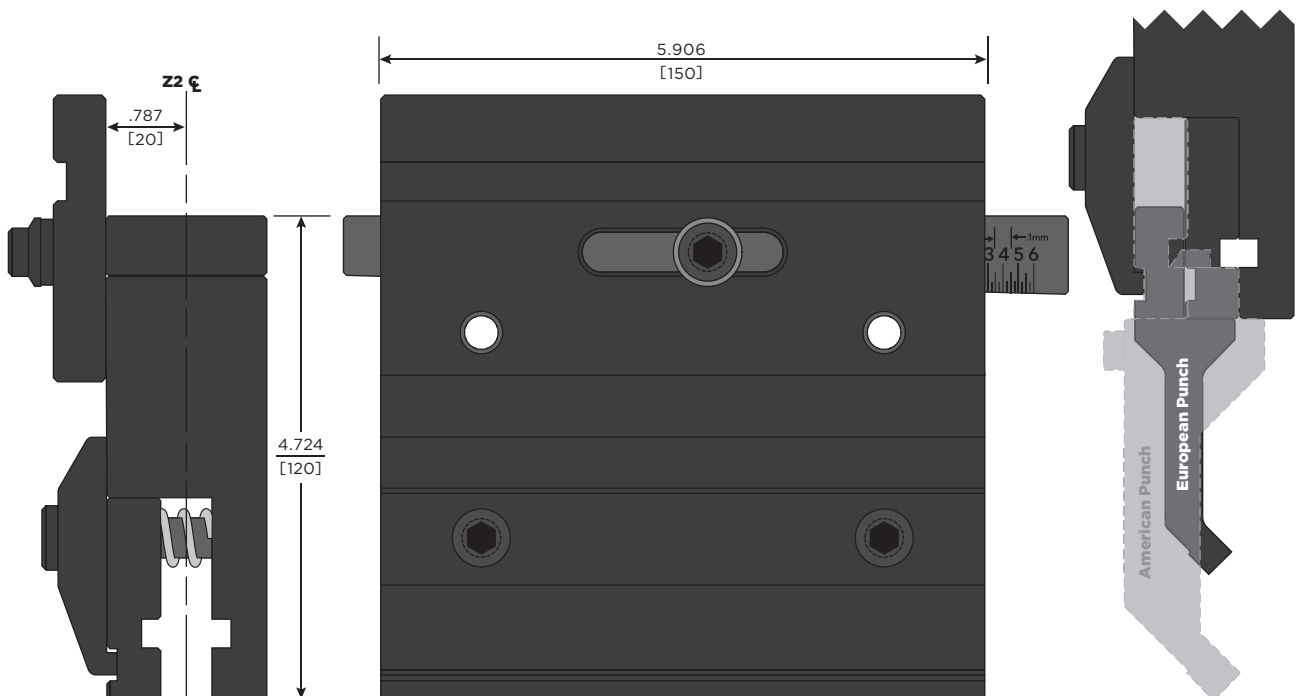
AMERICAN TO EUROPEAN PUNCH ADAPTER



Part No.	Description	Max. Ton feet [m]	Weight lbs. [kg]	5.096" [150mm]
43004	American to European Punch Adapter	30 [100]	10 [4.17]	

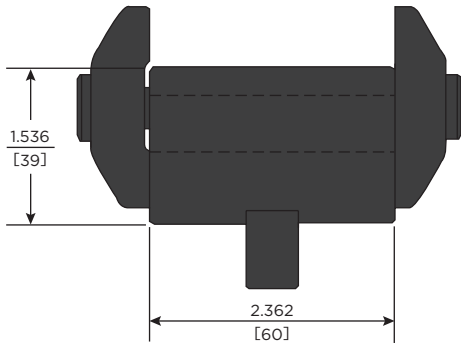
For Conventional Press Brakes without punch holder height adjustment.


Z2 SERIES W/DUAL AMERICAN & EUROPEAN CLAMPING



Part No.	Description	Max. Ton feet [m]	Weight lbs. [kg]	5.096" [150mm]
43853	Z2 Series with Dual American & European Clamping	30 [100]	15 [6.5]	

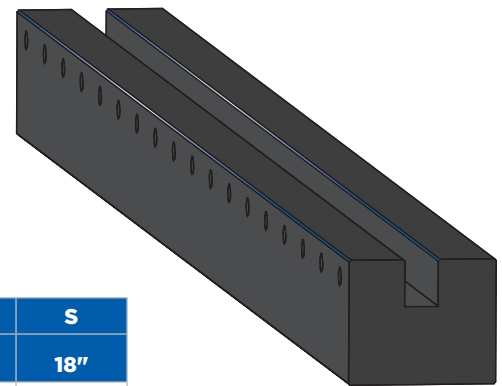
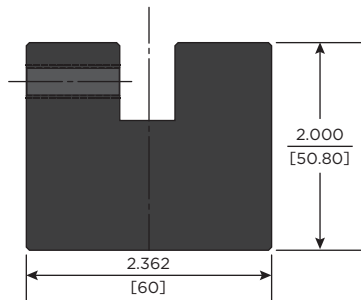
AMERICAN TO EUROPEAN DIE ADAPTER





Part No.	Description	Max. Ton/ft.	Weight lbs./inch [kg/mm]	L	S
				32.87"	16.34"
43006	American to European Die Holder	40	1.54 [.027]		

Please verify press brake tongue slot width when ordering

EUROPEAN TO AMERICAN DIE ADAPTER



Part No.	Description	Max. Ton/ft.	Weight lbs./inch [kg/mm]	L	S
				36"	18"
43590	European to American Die Holder	40	1.54 [.027]		

 = 30 lbs. / 13.6kg or more

EUROPEAN STAGED TOOLING

REDUCE YOUR SETUP TIME AND INCREASE EFFICIENCY WITH STAGED TOOLING

As smaller press brake runs become more routine, valuable production time is often lost on performing multiple setups. Significantly improve productivity by minimizing setup time with staged bending solutions from Wilson Tool International. Our progressive approach to press brake tooling can improve workflow and help make even complex short runs more cost effective.

Punches are commonly loaded into a segmented holder. This allows for shorter punches to be used for box bending since the punch holder creates space for the part, and also increases the height of the punch. All punches are available with a straight or beveled tang.



Scan QR Code to
Watch the Video

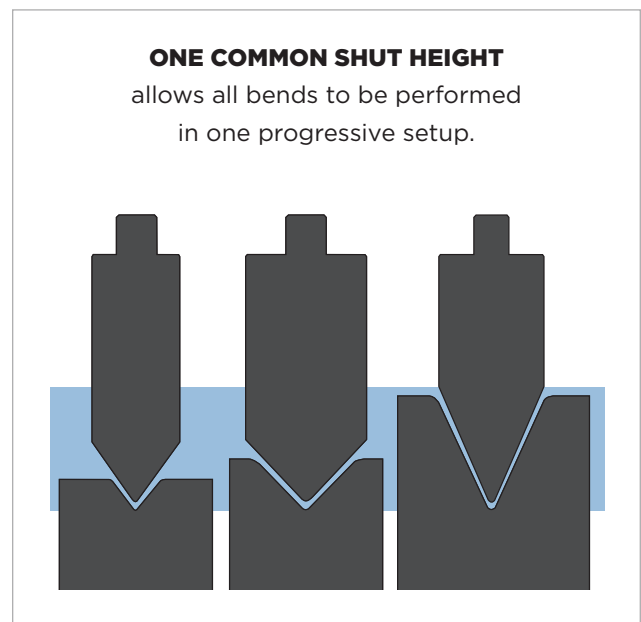


WHAT IS “STAGED” TOOLING?

By creating multiple tooling setups with a common shut height, operators can carry out multiple bends on a single setup. All bends on a part are performed in succession, eliminating the need for constant tool changeovers and part handling, saving you time and effort.

The Wilson Tool Advantage

- **Standardized Common Shut Height:** Tooling is designed to work together for easy and efficient staged bending.
- **Versatile Tooling Options:** Goosenecks, offsets and flattening tools can be staged side-by-side.
- **Out-of-the-Box Solution:** No need for custom modifications or additional setup time.



Scan
QR Code
to Watch
the Video



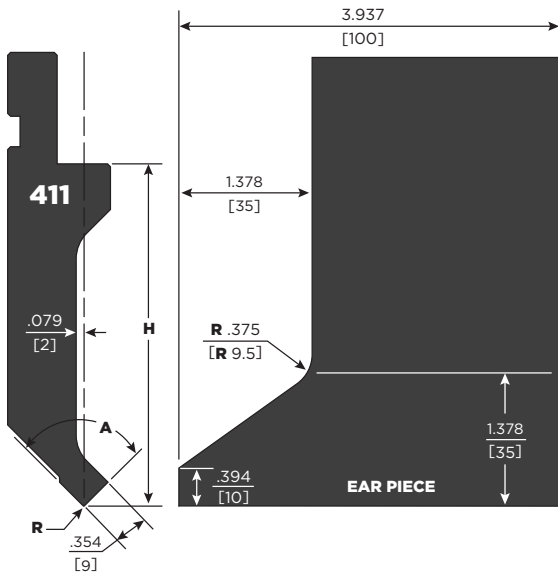
Benefits of Staged Bending

- **Reduced Setup Time:** Minimize downtime and maximize production
- **Increased Efficiency:** Streamline your workflow and improve productivity
- **Improved Quality:** Reduce part handling and potential damage
- **Lower Costs:** Reduce labor costs

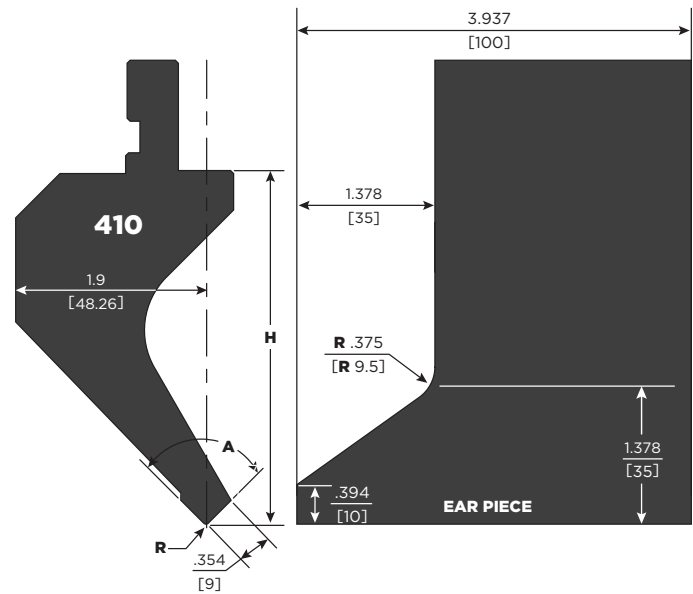
Ready to Revolutionize Your Press Brake Operations?

Contact us today to learn how staged bending can help you achieve your goals.

88° & 90° SASH



88° & 90° GOOSENECK



EUROPEAN STAGED

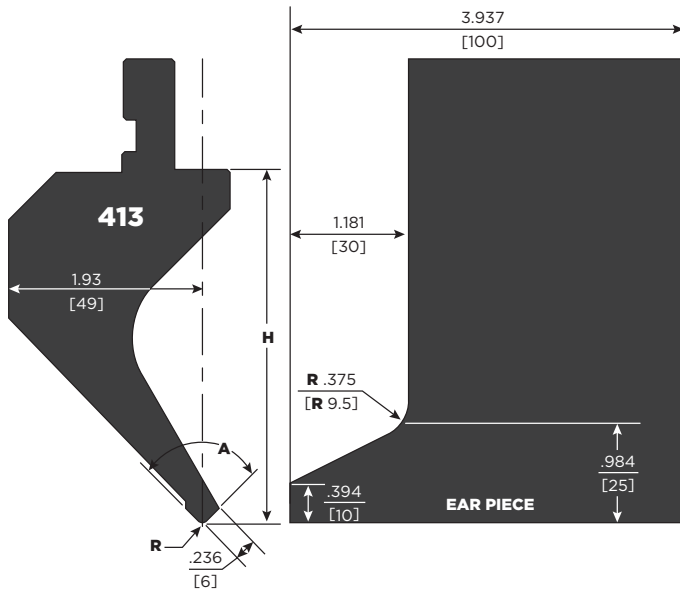
90mm TALL PUNCHES — STAGED TOOLING

Part No.		R inch [mm]	A	H inch [mm]	LT & ST	XT	Weight lbs./inch [kg/mm]	LT	ST	XT
Straight	Beveled				Max. Ton feet [m]	32.87" [835mm]		16.34" [415mm]	32.87" [835mm]	
411 SERIES — 90° & 88° SASH PUNCHES										
41190002		.008 [0.2]		3.540 [89.9]						
41190008		.030 [0.8]		3.530 [89.7]						
411c	411c	.060 [1.5]	90°	3.519 [89.4]	30 [100]	12 [40]	.86 [.015]			
		.090 [2.3]		3.506 [89.0]						
		.120 [3.0]		3.494 [88.8]						
41188002	411c	.008 [0.2]	88°	3.540 [89.9]	30 [100]	12 [40]				
41188008		.030 [0.8]		3.529 [89.6]						
411c		.060 [1.5]		3.517 [89.3]						
		.090 [2.3]		3.504 [89.0]						
		.120 [3.0]		3.491 [88.7]						
410 SERIES — 90° & 88° GOOSENECK PUNCHES										
41090002		.008 [0.2]		3.540 [89.9]						
41090008		.030 [0.8]		3.530 [89.7]						
41090015	410c	.060 [1.5]	90°	3.519 [89.4]	21 [70]	14 [47]	1.29 [.23]			
410c		.090 [2.3]		3.506 [89.0]						
		.120 [3.0]		3.494 [88.8]						
40602	40602B	.008 [0.2]	88°	3.540 [89.9]	21 [70]	14 [47]				
40608	40608B	.030 [0.8]		3.529 [89.6]						
40615	40615B	.060 [1.5]		3.517 [89.3]						
410c	410c	.090 [2.3]		3.504 [89.0]						
40630	40630B	.120 [3.0]		3.491 [88.7]						

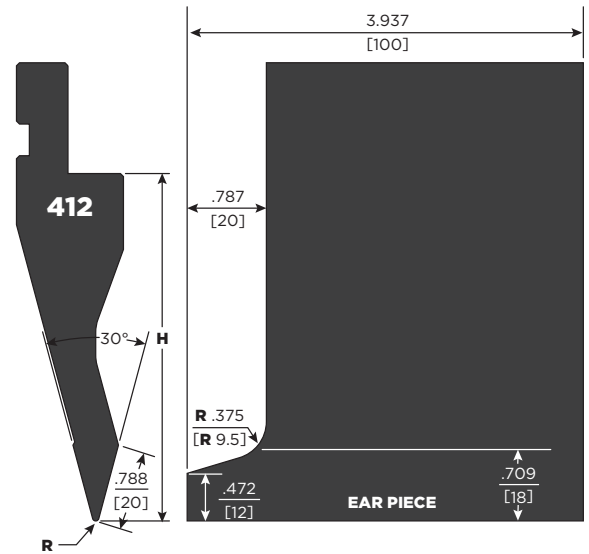
= 30 lbs. / 13.6kg or more



88° & 90° THIN TIP GOOSENECK



30° ACUTE

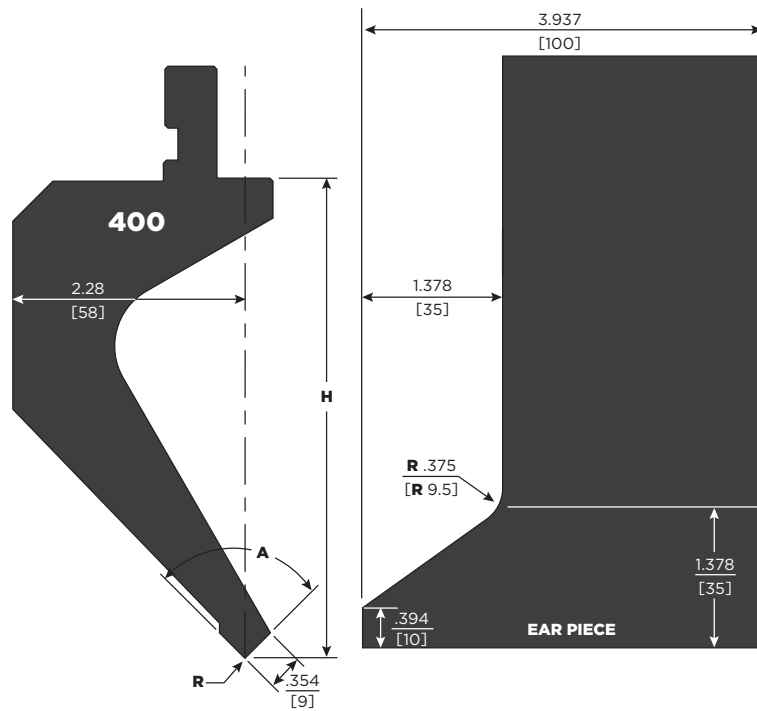


90mm TALL PUNCHES — STAGED TOOLING										
Part No.		R inch [mm]	A	H inch [mm]	LT & ST	XT	Weight lbs./inch [kg/mm]	LT	ST	XT
Straight	Beveled				Max. Ton feet [m]			32.87" [835mm]	16.34" [415mm]	32.87" [835mm]
413 SERIES — 90° & 88° THIN TIP GOOSENECK PUNCHES										
40712	40712B	.008 [0.2]	90°	3.540 [89.9]	15 [50]	9 [30]	1.29 [.23]			
40718	40718B	.030 [0.8]		3.530 [89.7]						
413c	413c	.060 [1.5]		3.519 [89.4]						
		.090 [2.3]		3.506 [89.0]						
		.120 [3.0]		3.494 [88.8]						
40702	40702B	.008 [0.2]	88°	3.540 [89.9]	15 [50]	9 [30]	1.29 [.23]			
40708	40708B	.030 [0.8]		3.529 [89.6]						
413c	413c	.090 [2.3]		3.504 [89.0]						
		.120 [3.0]		3.491 [88.7]						
412 SERIES — 30° ACUTE PUNCHES										
412c	412c	.008 [0.2]	30°	3.479 [88.4]	30 [100]	6 [20]	.86 [.015]			
41230008		.030 [0.8]		3.453 [87.7]						



EUROPEAN STAGED


= 30 lbs. / 13.6kg or more

88° & 90° GOOSENECK



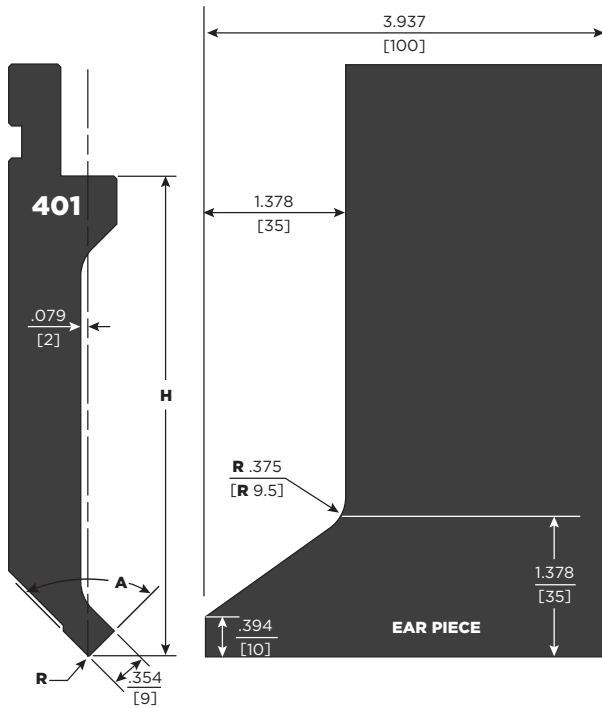
120mm TALL PUNCHES – STAGED TOOLING

Part No.		R inch [mm]	A	H inch [mm]	LT & ST	XT	Weight lbs./inch [kg/mm]	LT	ST	XT
Straight	Beveled				Max. Ton feet [m]	32.87" [835mm]		16.34" [415mm]	32.87" [835mm]w	
400 SERIES – 90° & 88° GOOSENECK PUNCHES										
400c	400c	.008 [0.2]	90°	4.721 [119.9]	15 [50]	9 [30]	1.68 [.030]			
		.030 [0.8]		4.711 [119.7]						
		.060 [1.5]		4.700 [119.4]						
		.090 [2.3]		4.687 [119.0]						
		.120 [3.0]		4.675 [118.8]						
40302	40302B	.008 [0.2]	88°	4.721 [119.9]	15 [50]	9 [30]	1.68 [.030]			
40308	40308B	.030 [0.8]		4.711 [119.6]						
400c	400c	.060 [1.5]		4.698 [119.3]						
		.090 [2.3]		4.685 [119.0]						
		.120 [3.0]		4.672 [118.7]						

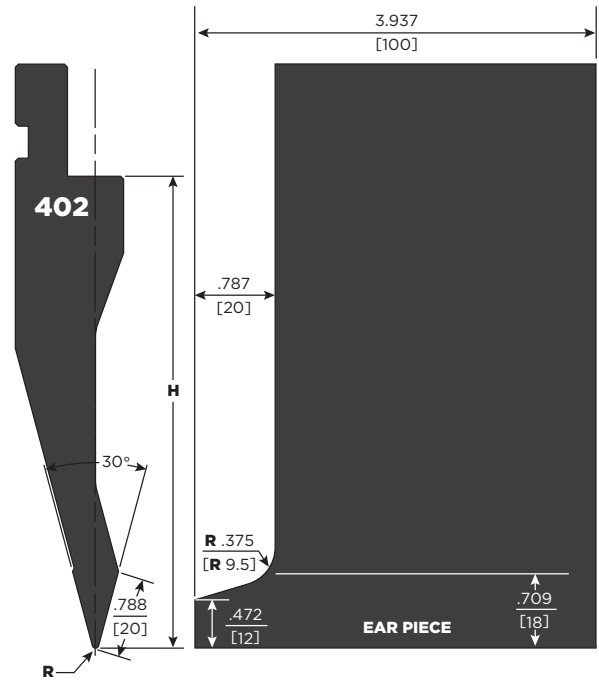
 = 30 lbs. / 13.6kg or more



88° & 90° SASH



30° ACUTE

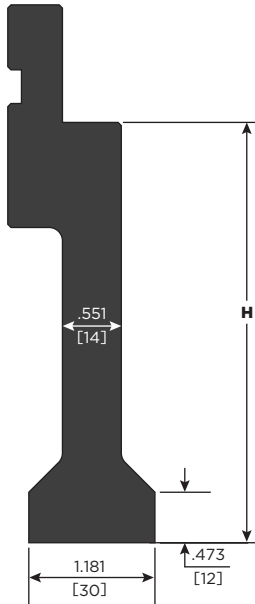


120mm TALL PUNCHES – STAGED TOOLING

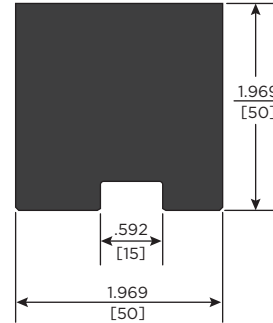
Part No.		R inch [mm]	A	H inch [mm]	LT & ST	XT	Weight lbs./inch [kg/mm]	LT	ST	XT
Straight	Beveled				Max. Ton feet [m]	32.87" [835mm]		16.34" [415mm]	32.87" [835mm]	
401 SERIES – 90° & 88° SASH PUNCHES										
401c	401c	.008 [0.2]	90°	4.721 [119.9]	30 [100]	12 [40]	1.09 [.019]			
		.030 [0.8]		4.711 [119.7]						
		.060 [1.5]		4.700 [119.4]						
		.090 [2.3]		4.687 [119.0]						
		.120 [3.0]	4.675 [118.8]							
		.008 [0.2]	88°	4.721 [119.9]	30 [100]	12 [40]				
		.030 [0.8]		4.711 [119.6]						
		.060 [1.5]		4.698 [119.3]						
.090 [2.3]	4.685 [119.0]									
.120 [3.0]	4.672 [118.7]									
402 SERIES – 30° ACUTE PUNCHES										
402c	402c	.008 [0.2]	30°	4.701 [119.4]	30 [100]	6 [20]	0.99 [.018]			
		.030 [0.8]		4.634 [117.7]						

= 30 lbs. / 13.6kg or more


FLATTENING PUNCH



FLATTENING DIE




FLATTENING PUNCHES – STAGED TOOLING

Part No.		Staging Family	H Height inch [mm]	Max. Ton feet [m]	Weight lbs./inch [kg/mm]	L	S	X
Straight	Beveled					32.87" [835mm]	16.34" [415mm]	32.87" [835mm]
FLATTENING PUNCH								
41400000	414c	90mm	3.150 [80.0]	30 [100]	1.01 [.018]			
40400001	404c	120mm	4.330 [110.0]					

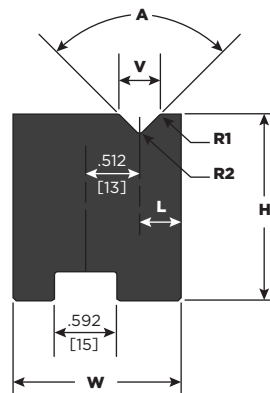
FLATTENING DIES – STAGED TOOLING



Part No.	Max. Ton feet [m]	Weight lbs./inch [kg/mm]	LT	ST	XT
			32.87" [835mm]	16.34" [415mm]	32.87" [835mm]
FLATTENING DIE					
42312	30 [100]	.86 [.015]			

 = 30 lbs. / 13.6kg or more




QUICK CHANGE 90° & 88° DIES

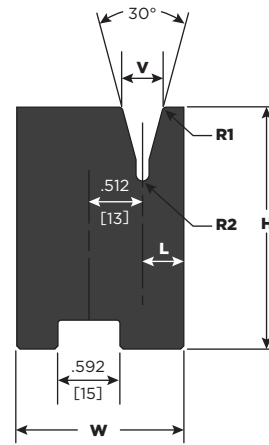


QUICK CHANGE DIES — STAGED TOOLING												
Part No.	V inch [mm]	R1 inch [mm]	R2 inch [mm]	L inch [mm]	W inch [mm]	H inch [mm]	Max. Ton inch [mm]	Weight lbs./inch [kg/mm]	L	S	X	
									32.87" [835mm]	16.34" [835mm]	32.87" [835mm]	
QC STAGED 90° DIES												
45090006	.236 [6.0]	.024 [0.6]	.008 [0.2]	.394 [10.0]	1.594 [40.5]	1.693 [43.0]	30 [100]	.86 [.015]				
45090008	.315 [8.0]	.031 [0.8]		.394 [10.0]	1.594 [40.5]	1.732 [44.0]						
45090010	.394 [10.0]	.039 [1.0]		.394 [10.0]	1.594 [40.5]	1.772 [45.0]						
45090012	.472 [12.0]	.039 [1.0]		.492 [12.5]	1.693 [43.0]	1.811 [46.0]						
QC STAGED 88° DIES												
45088006	.236 [6.0]	.024 [0.6]	.008 [0.2]	.394 [10.0]	1.594 [40.5]	1.697 [43.1]	30 [100]	.86 [.015]				
45088008	.315 [8.0]	.031 [0.8]		.394 [10.0]	1.594 [40.5]	1.738 [44.1]						
45088010	.394 [10.0]	.039 [1.0]		.394 [10.0]	1.594 [40.5]	1.779 [45.2]						
45088012	.472 [12.0]	.039 [1.0]		.394 [10.0]	1.693 [43.0]	1.819 [46.2]						
45088016	.630 [16.0]	.059 [1.5]		.492 [12.5]	1.791 [45.5]	1.901 [48.3]		1.01 [.018]				
45088020	.787 [20.0]	.079 [2.0]		.591 [15.0]	1.791 [45.5]	1.983 [50.4]						
45088024	.945 [24.0]	.098 [2.5]		.689 [17.5]	1.890 [48.0]	2.064 [52.4]						
45088030	1.181 [30.0]	.118 [3.0]		.886 [22.5]	2.087 [53.0]	2.186 [55.5]				1.29 [.23]		

EUROPEAN STAGED

 = 30 lbs. / 13.6kg or more

QUICK CHANGE 30° DIES



EUROPEAN STAGED

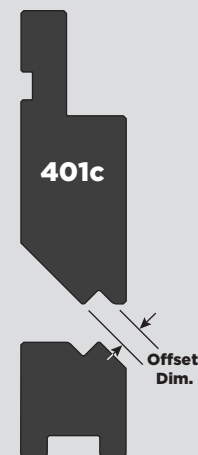
QUICK CHANGE DIES – STAGED TOOLING

Part No.	V inch [mm]	R1 inch [mm]	R2 inch [mm]	L inch [mm]	W inch [mm]	H inch [mm]	Max. Ton feet [mm]	Weight lbs./inch [kg/mm]	L	S	X
									32.87" [835mm]	16.34" [835mm]	32.87" [835mm]
QC STAGED 30° DIES											
45030006	.236 [6.0]	.039 [1.0]	.063 [1.6]	.394 [10.0]	1.594 [40.5]	2.016 [51.2]	30 [100]	.86 [.015]			
45030008	.315 [8.0]	.039 [1.0]	.063 [1.6]	.394 [10.0]	1.594 [40.5]	2.163 [54.9]	30 [100]	1.01 [.018]			
45030010	.394 [10.0]	.039 [1.0]	.063 [1.6]	.394 [10.0]	1.594 [40.5]	2.310 [58.7]	23 [77]				
45030012	.472 [12.0]	.039 [1.0]	.063 [1.6]	.492 [12.5]	1.693 [43.0]	2.456 [62.4]	20 [67]	.86 [.015]			
45030016	.630 [16.0]	.063 [1.6]	.094 [2.4]	.591 [15.0]	1.791 [45.5]	2.750 [69.9]	18 [60]	1.29 [.023]			
45030020	.787 [20.0]	.079 [2.0]	.094 [2.4]	.689 [17.5]	1.890 [48.0]	3.044 [77.3]	15 [50]	1.54 [.027]			
45030024	.945 [24.0]	.098 [2.5]	.094 [2.4]	.787 [20.0]	1.988 [50.5]	3.338 [84.8]	15 [50]	1.68 [.030]			

STAGED OFFSET TOOLS

Let us know what size, angle, staged height family and length needed and we will make it.

Contact our expert Tooling Technicians at bending@wilsontool.com or 800-445-4518.

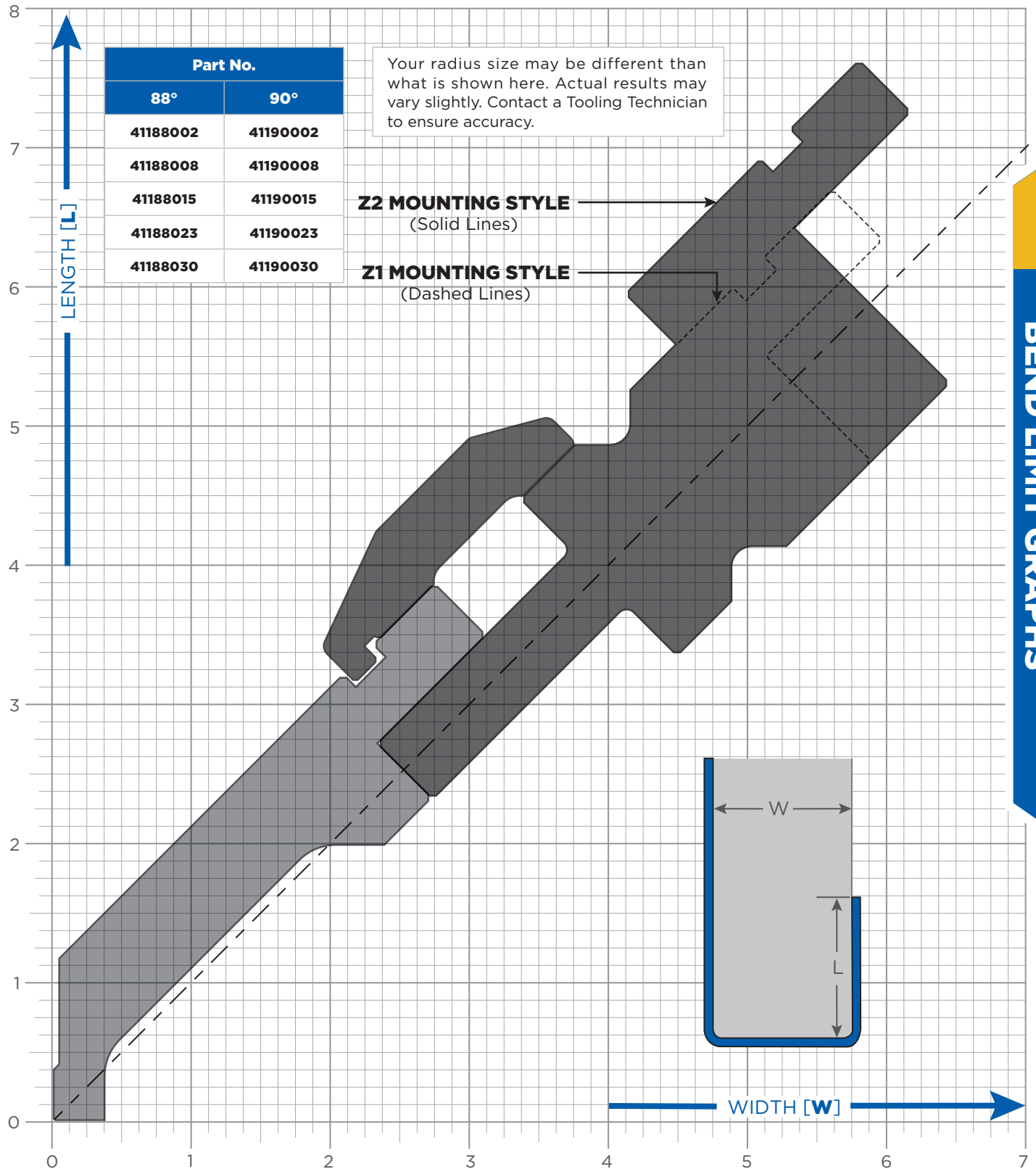


= 30 lbs. / 13.6kg or more



SASH PUNCH (STAGED)

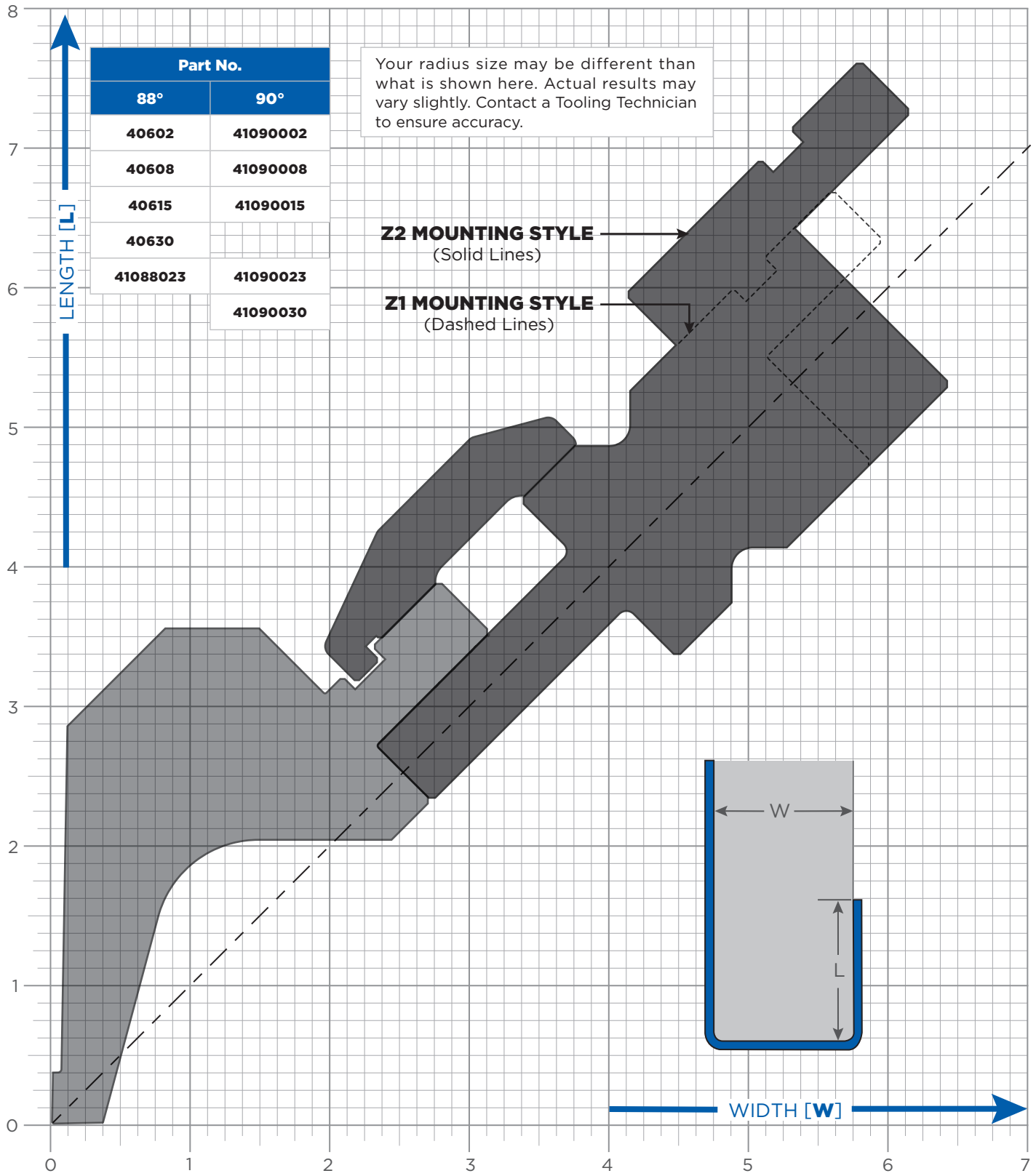
88° & 90°



GOOSENECK PUNCH (STAGED)

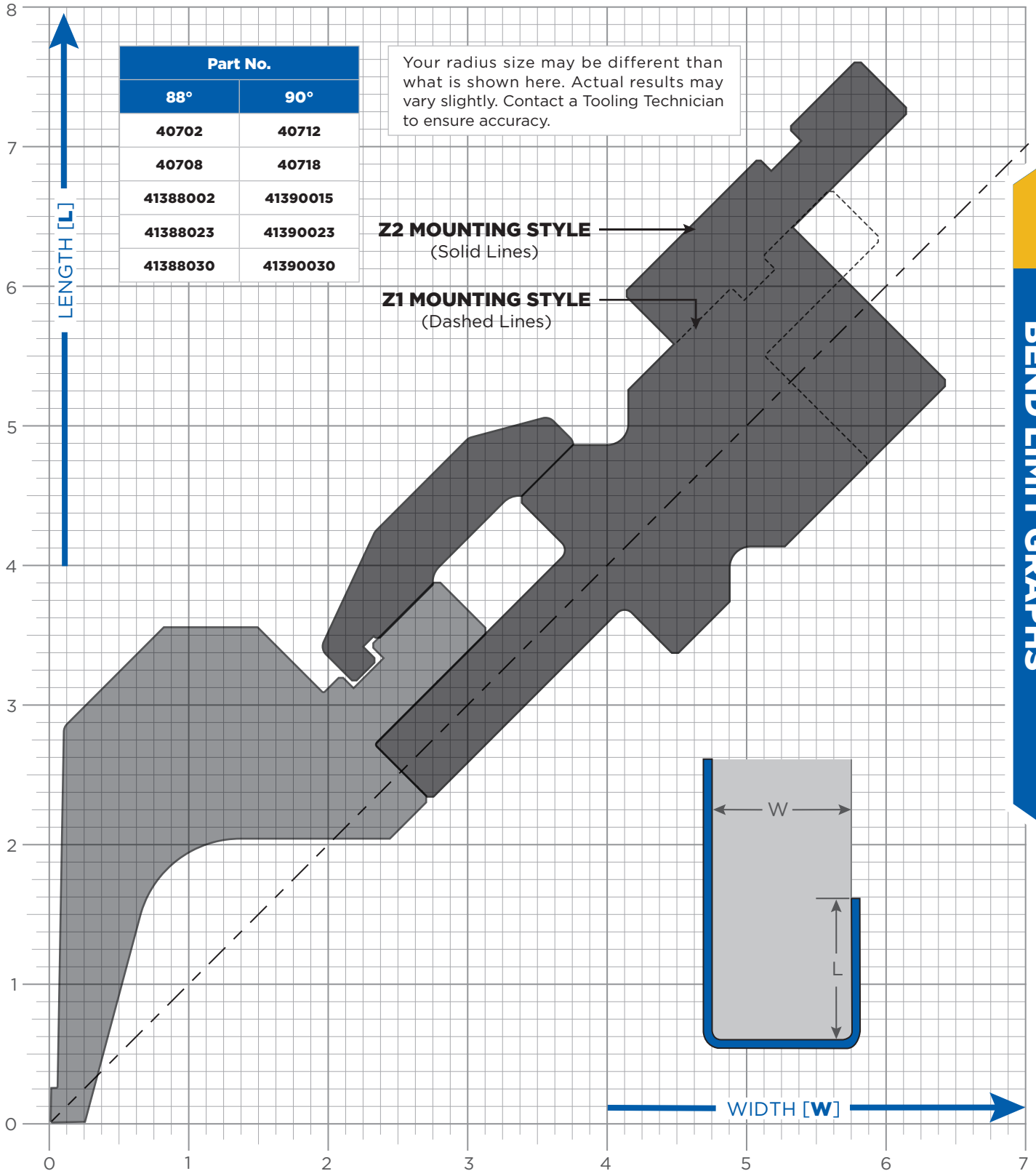
88° & 90°

BEND LIMIT GRAPHS



THIN TIP GOOSENECK PUNCH (STAGED)

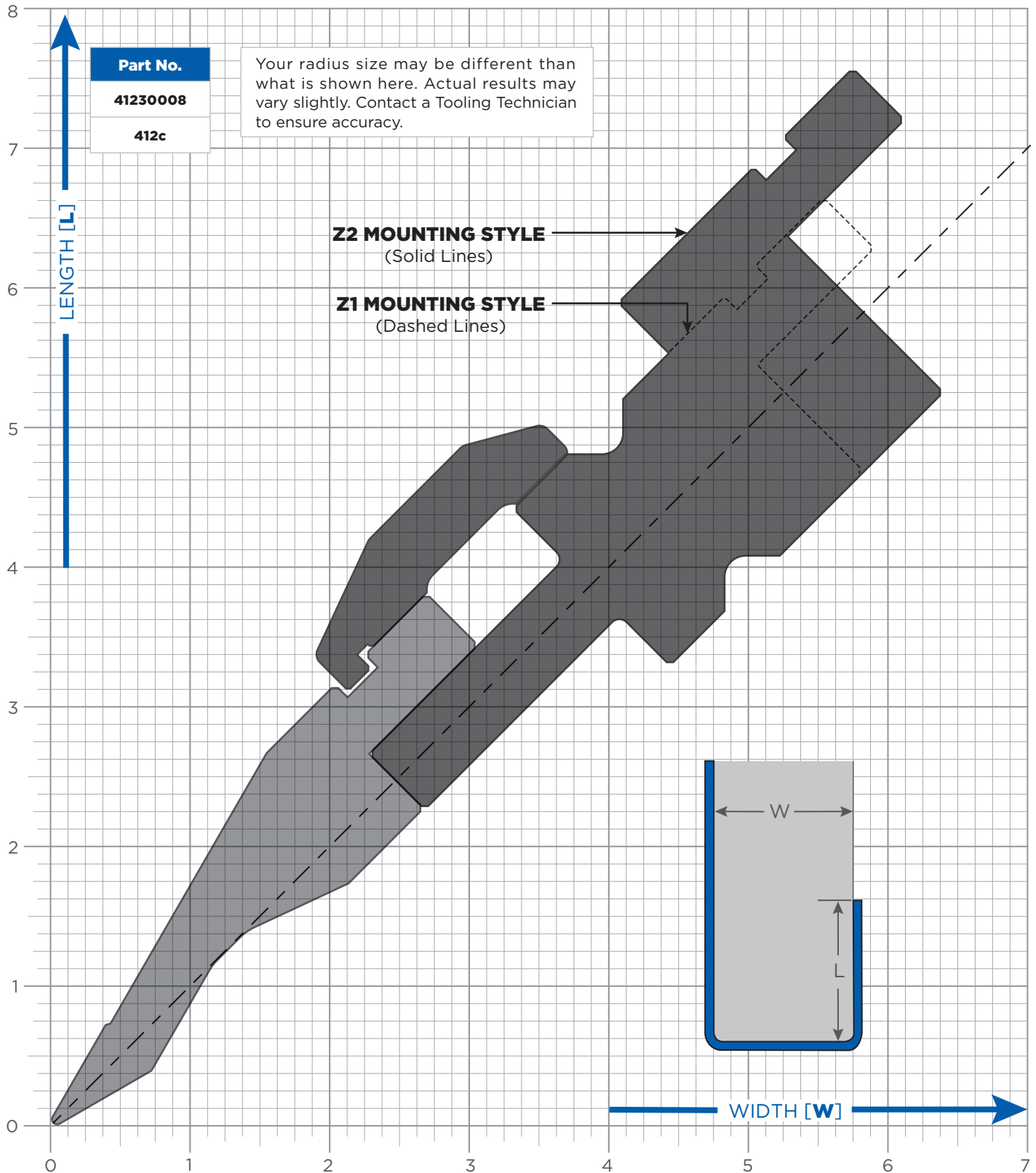
88° & 90°



ACUTE PUNCH (STAGED)

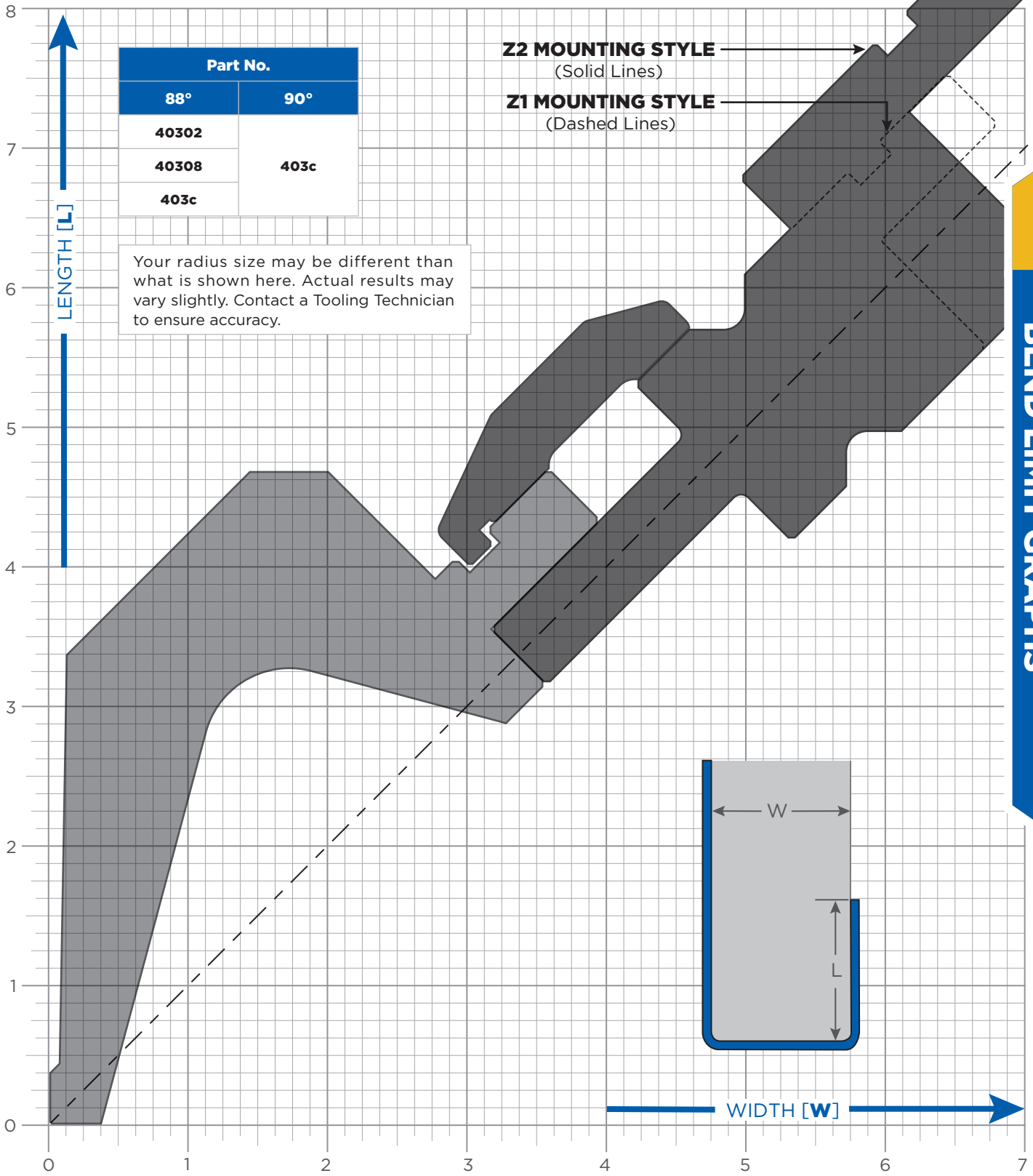
30°

BEND LIMIT GRAPHS



GOOSENECK PUNCH (STAGED)

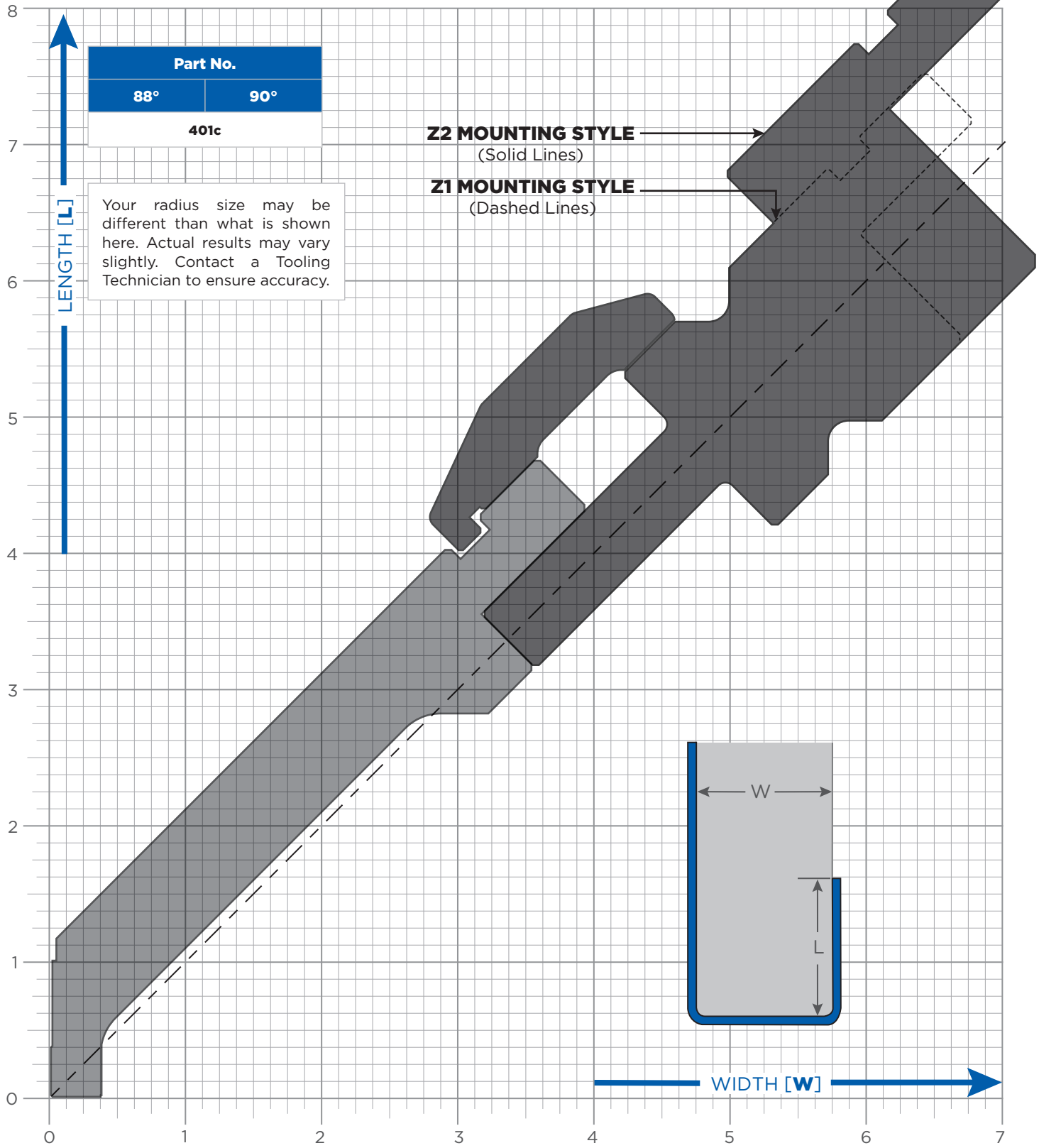
88° & 90°



SASH PUNCH (STAGED)

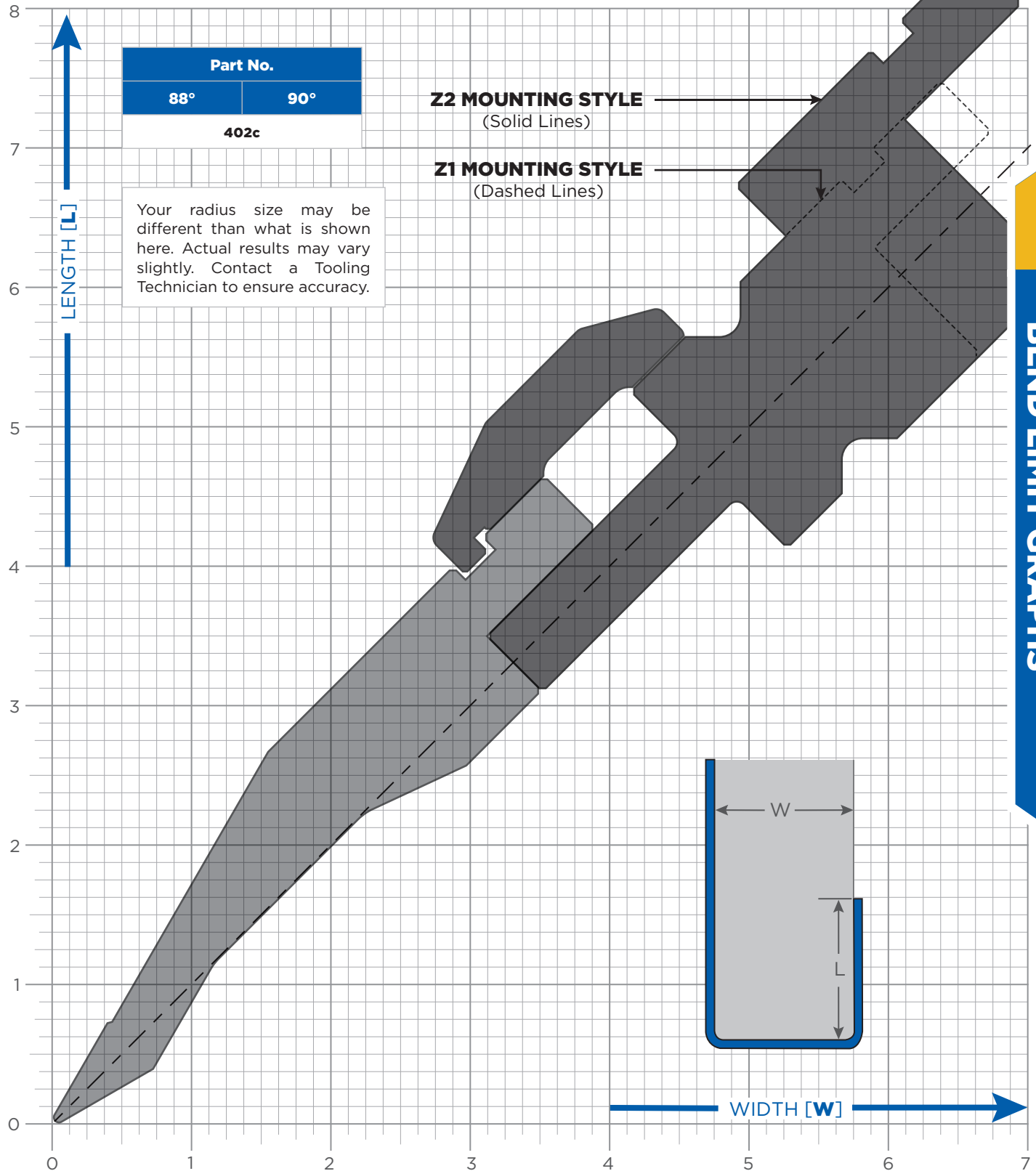
88° & 90°

BEND LIMIT GRAPHS



ACUTE PUNCH (STAGED)

30°



SPECIAL TOOLING



EUROPEAN



WT-STYLE



AMERICAN



RFA-STYLE

CHALLENGE OUR “NEVER SAY NO” ATTITUDE

We regularly help customers with their most challenging applications. Our innovative solutions simplify complex bends and make the impossible possible. We are defined by our “never say no” attitude. Bring us your most complex problem and we will work with you until we’ve found an effective solution.

Quality Materials — Quality Control

We combine premium materials with specialized manufacturing systems to produce extraordinary products that outlast the competition.

Quick Quotes — Short Lead Times

With the fastest lead times in the industry, our tool might ship before the competition even provides a quote.

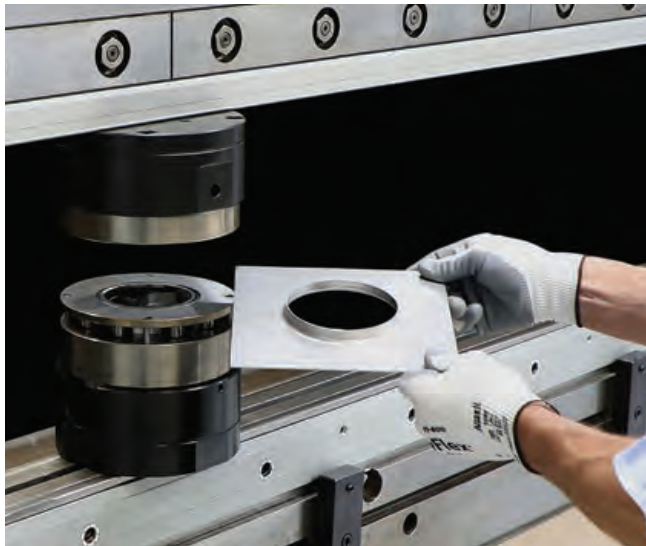


BRAKE PARTNER®

Make Punch Press Forms in the Press Brake

For fabricators who have migrated away from punch presses to laser cutting machines, or for those whose punch presses are running at full capacity, Brake Partner® from Wilson Tool International is an especially helpful solution.

Brake Partner, manufactured to fit in virtually any press brake, features a pressure-pad system which provides blank-holding and stripping, and can be used with or without guide posts, depending on the application.



Enjoy These Cost Saving Benefits

- Reduce press brake special tooling costs
- Punch press tooling has shorter lead times
- Put your existing press brakes to work on applications that were previously impossible on a punching machine
- Reduce outsourcing of punching applications
- Streamline equipment usage and create more flexibility in your shop

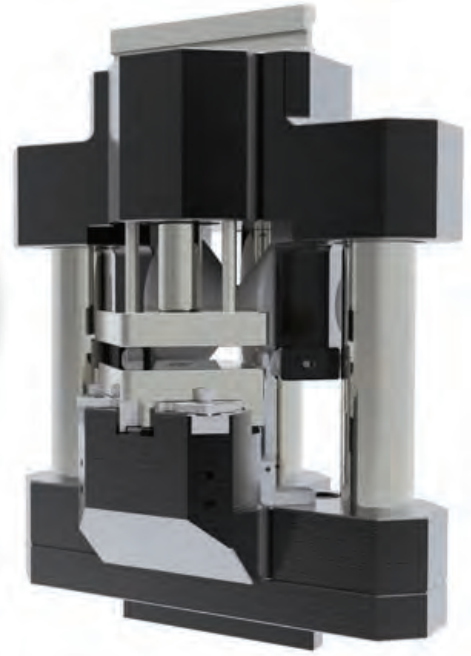
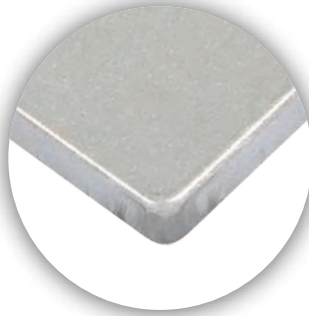


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CORNER FORMER

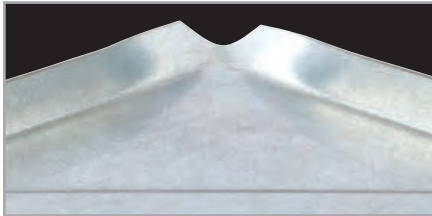
To make a four-sided tray or door, the sides would traditionally be folded, the corners welded and the joint ground, to produce an acceptable finish. This process is time consuming, costly and requires a certain skill set.

The Corner Former from Wilson Tool International allows you to use your existing press brake to bend up the corners, form the corners and then crop the edges to leave a clean, finished look without the need for welding, grinding and finishing.



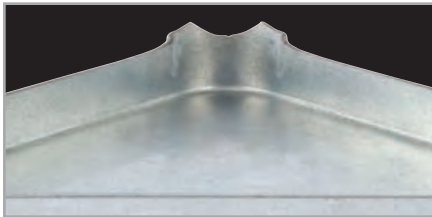
SPECIALS

3 SIMPLE STEPS TO A FINISHED CORNER



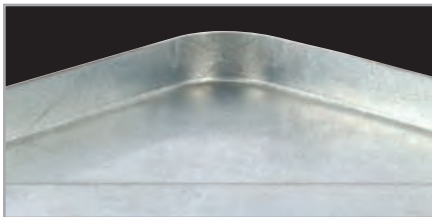
Step 1: Bend with Flare

All four corners are bent like any other part except your standard die will have an engineered relief to achieve an intentionally flared bend at the ends.



Step 2: Corner Former

After the engineered flare, the part is moved to the corner forming step to roll the edge. You now have a complete corner with extra material that needs to be trimmed.



Step 3: Corner Cropper/Trim

In a quick and simple one-hit action, the corner cropper cuts the extra material flush to the edges of the tray or door. You have now made your part in one handling with little or no additional post processing needed.



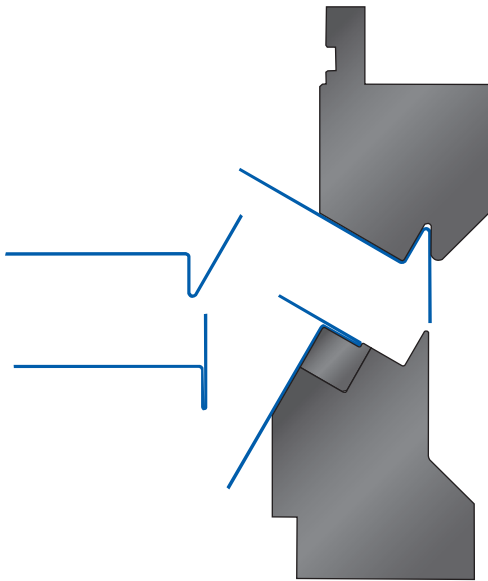
Scan QR Code to Watch the Video



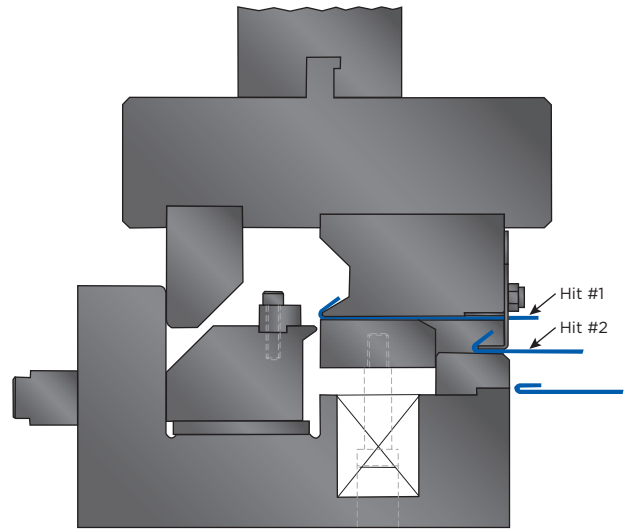
Scan QR Code to See How Much You Can Save



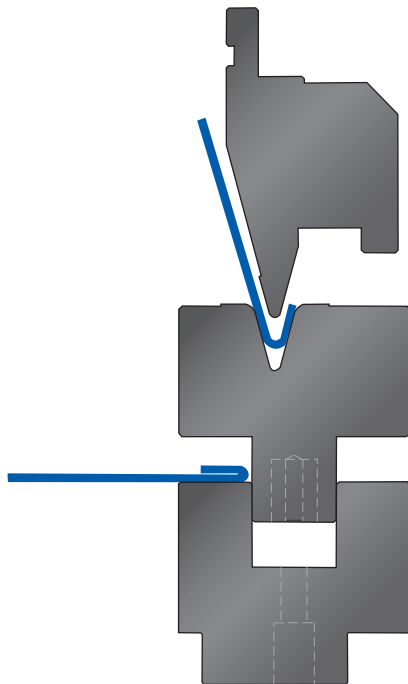
CUSTOM HEMMING



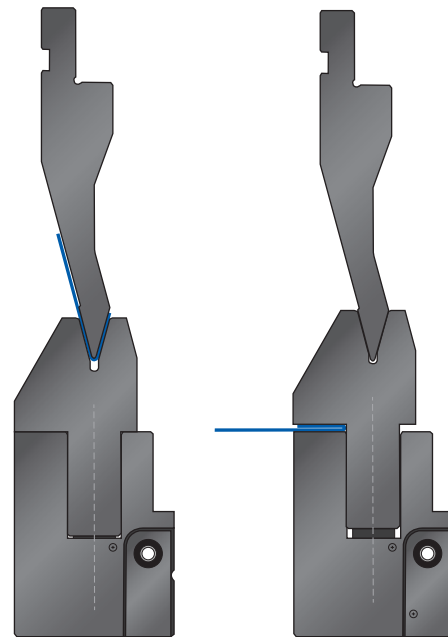
AH1 – ANGLE HEM
Typically used to form seams in excess of 1/2 inch.



FSH1 – FLAT SHEET HEM



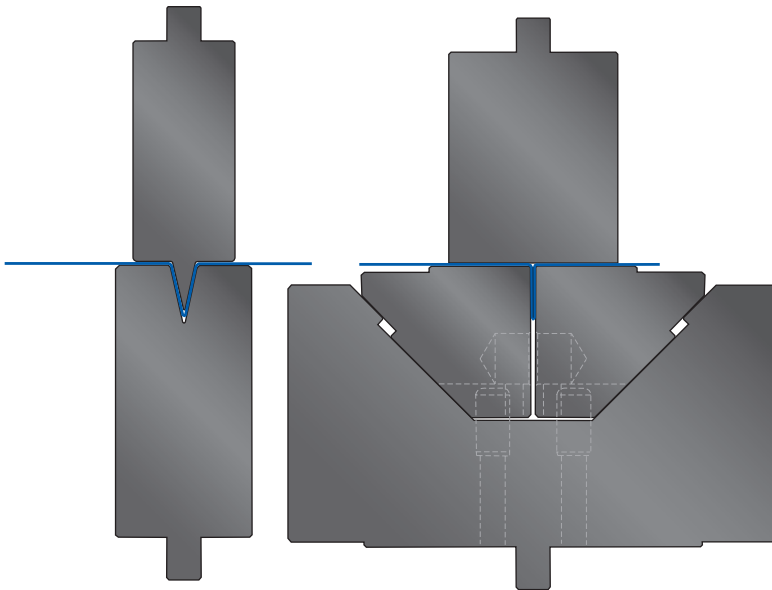
HDH1 – HEAVY DUTY HEM
Heavy duty hemming for thick gauge applications.



PH1 – PNEUMATIC HEM
This tool set introduces pneumatic cylinders to rapidly open and close the pre-form insert. This set removes the inconsistency associated with pre-forming or acute bending on a spring actuated insert.

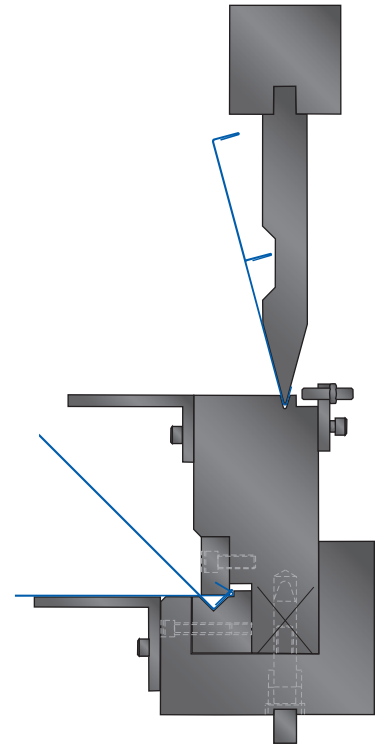
SPECIALS

CUSTOM HEMMING

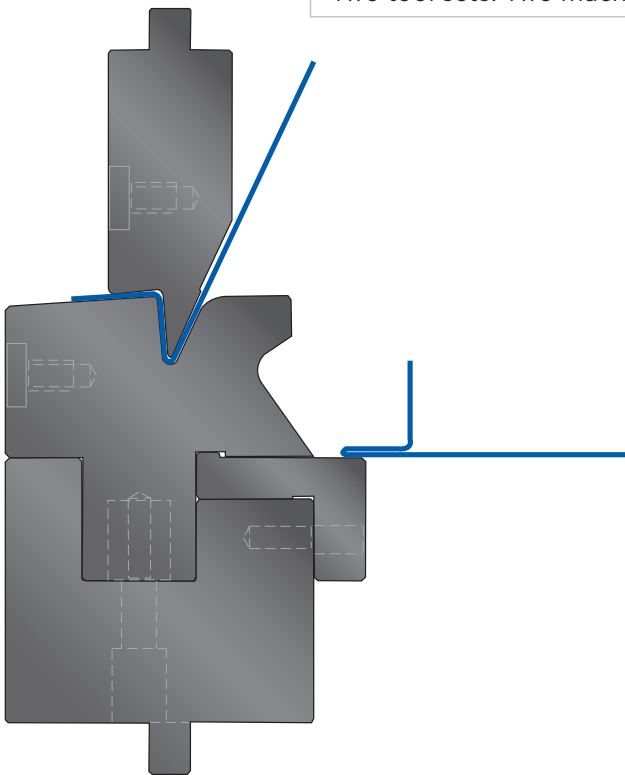


SH1 – SEAM HEM

Two tool sets. Two machine strokes



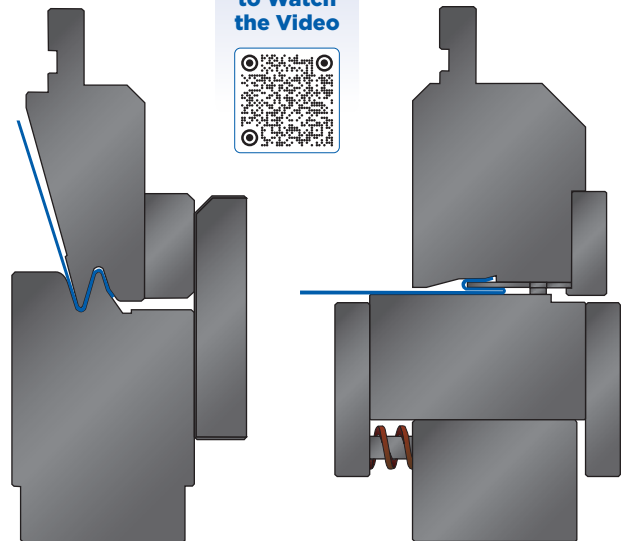
SSH2 – STANDING SEAM HEM



SSH1 – STANDING SEAM HEM

Used to form a standing seam in two strokes. The first stroke forms an acute angle offset, the second stroke closes the seam.

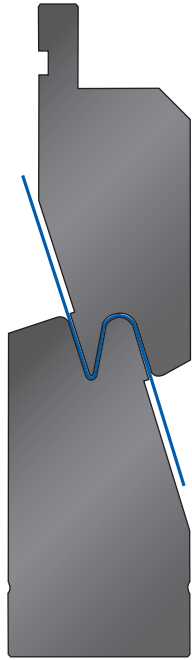
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ZH1 – Z HEM

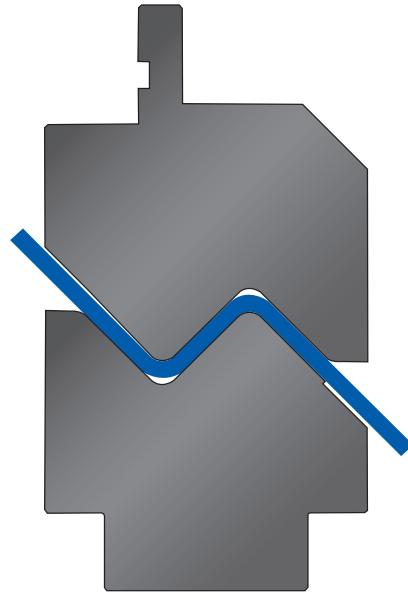
Creates a Z-hem or a Clip hem. Shim can be built in to maintain a gap in the hem. Two tool sets. Two machine strokes.

OFFSET TOOLS

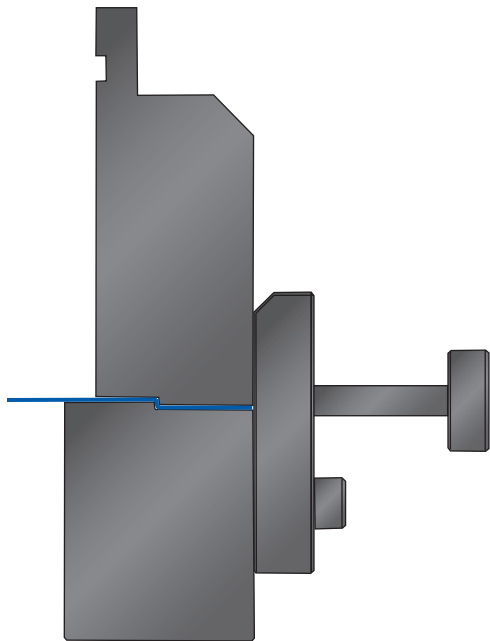


AO1 – ANGLED OFFSET

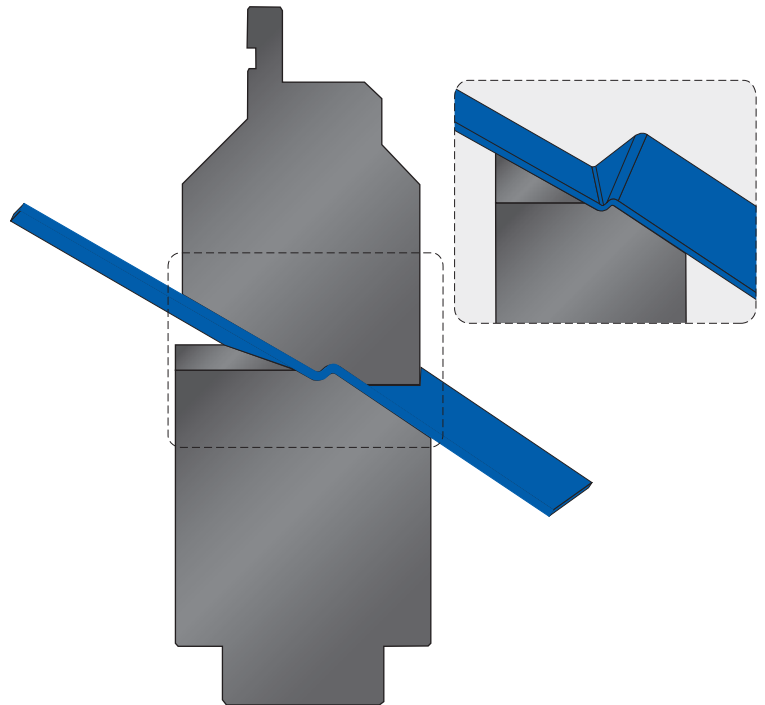
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LO1 – LARGE OFFSET
Used for heavy gauge, large offset bending.



HO1 – HORIZONTAL OFFSET
For offsets that are approximately one material thickness. Prevents material whip up. Thrust plates and adjustable back gauging are provided.



NPO1 – NON PARALLEL OFFSET
For offsets that have non-parallel flanges. Inset shows punch hidden for a clear view of the formed sheet.

SPECIALS

ADJUSTABLE DIES



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Adjustable dies are a great solution when bending thick materials and you need the flexibility to adjust the width of the V-opening. Instead of buying several dies, adjustable dies enable you to alter the width, rather than changing out the die.

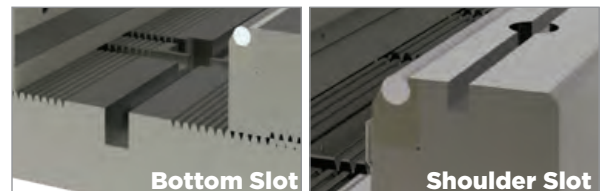
Adjustable Die Features

- Riding on spring-loaded ball bearings, openings are easily adjusted by one operator
- Available openings range from 1 to 24 inches and can be adjusted in 1-inch increments
- Capable of withstanding tonnage of up to 400 tons per foot, allowing easy thick material bending
- Induction hardened and hard chrome rollers help reduce required tonnage by as much as 20%
- Chrome rollers can be replaced at your facility

Adjustable Die Options

- Die assembly can be configured to remain on the press permanently and function as a standard die holder
- Cover bellows are available to keep the grooves that are used to adjust the dies free from dirt and dust
- Available clamping options for side blocks include manual and automated release and/or movement
- Available with Manual, Ball Screw, Hydraulic and CNC options

Die Holder Slots



Opening Adjustments



Shoulder Inserts



REPLACEABLE SHOULDER DIES

Dies that have a replaceable shoulder radius are ideal for extreme wear conditions like heavy plate and abrasive materials. Replacing the shoulder insert saves on replacement cost.

Since the radius is able to rotate during bending, friction and tonnage are reduced, resulting in reduced part marking and less tonnage on tooling and machinery.



Scan QR Code for More Thick Material Solutions



DOVETAIL HOLDER AND RADIUS

Lighten Your Load with Two-Piece Punches

Replaceable radius punches help limit tooling costs, reduce setup time and lighten tool changes. Tip inserts simply slide on and off the universal punch body, increasing the flexibility of each punch and minimizing heavy lifting for the operator.

Replaceable Radius Punch Highlights

- Setup is as simple as sliding the tip insert on and off the tool body
- No adjustment is required between punch radius changes
- Tip is lighter than a standard punch for easier tool changes
- Lighter tools reduces need for multiple operators
- Lighter tools creates a safer handling environment for operators
- Tool costs are minimized when purchasing one body with multiple tips
- Various angles and radii can be loaded into the same punch holder

Details

- Made to suit specific needs
- Designed to tackle light- or heavy-duty bending
- Ground and induction hardened for optimal life and performance
- Dovetail or T Style attachment feature



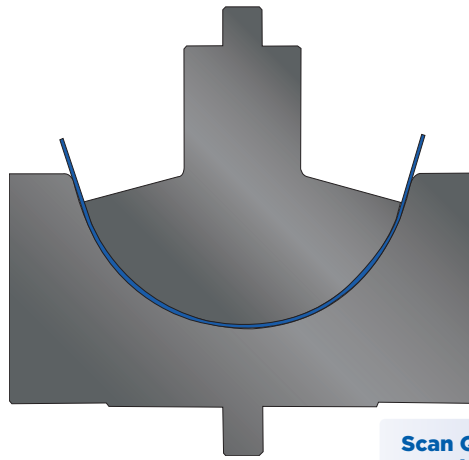
Dovetail

T Style



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LARGE RADII



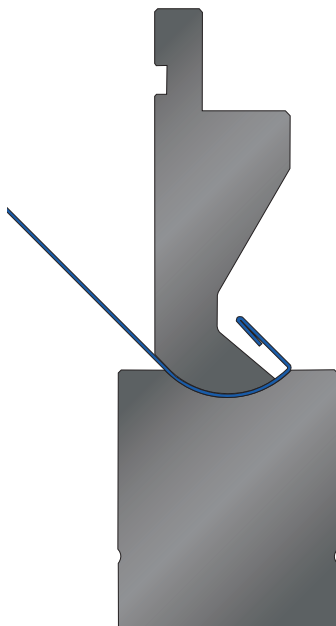
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LR1 – LARGE RADIUS

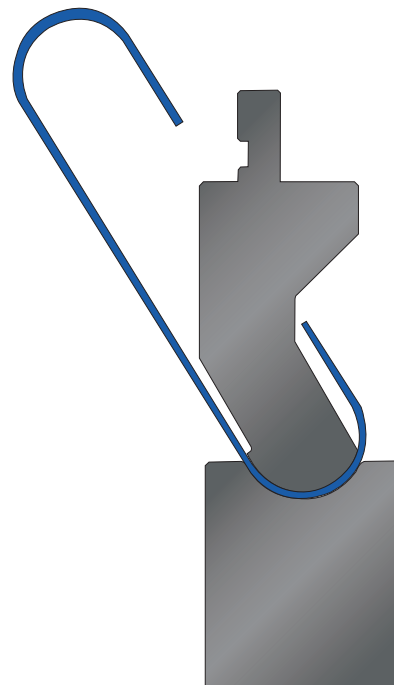
Bottoming radius set with spring-back allowance built in. It is manufactured to form a radius in a specific type and thickness of material for tight tolerance requirements.

SPECIALS



LR2 – MULTI-HIT RADIUS

Used when a full radius is required before the flange. The solution may require multiple strokes.

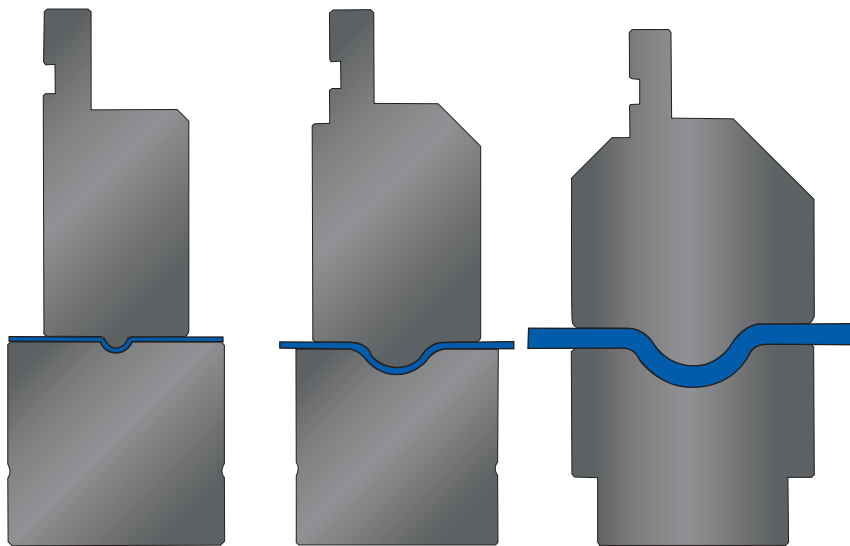


LR3 – MULTI-HIT RADIUS

Used when the return flange starts at the radius end. The solution may require multiple strokes.



STRENGTHENING RIB



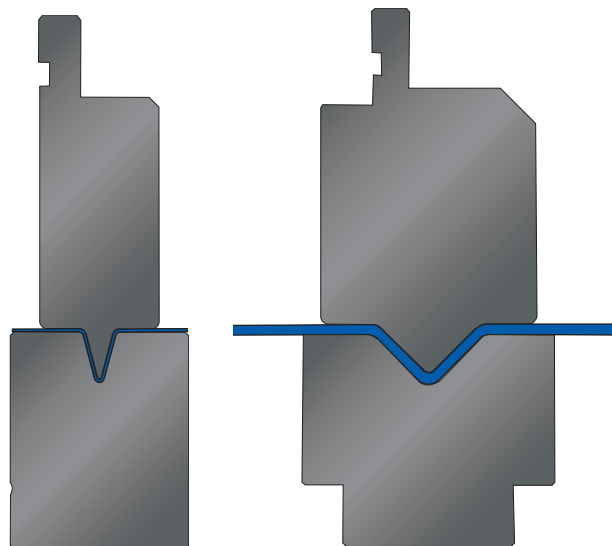
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SRI – STRENGTHENING RIB

Produce a strengthening rib in one stroke. Spring back allowance is built in. Closed end and open end ribs are available.

V-RIB

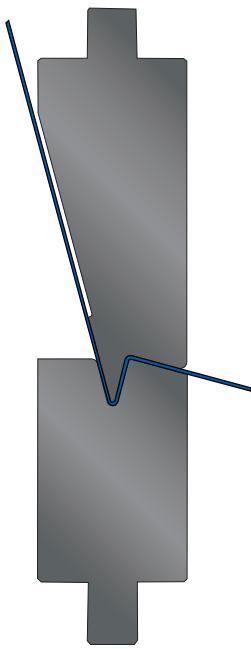


VR1 – V RIB

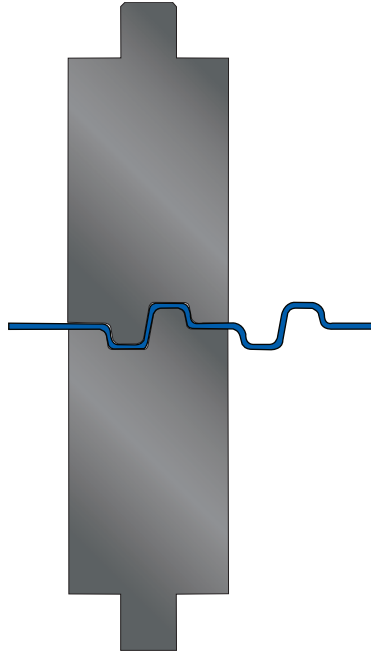
Produce a V rib in one stroke. Spring back allowance is built in.

FORMING

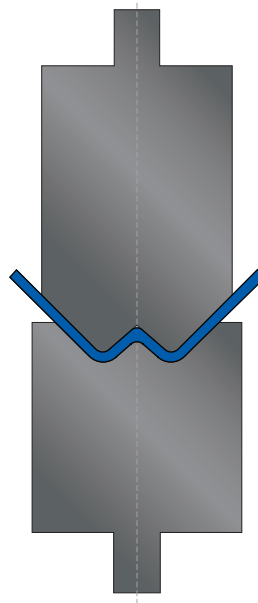
SPECIALS



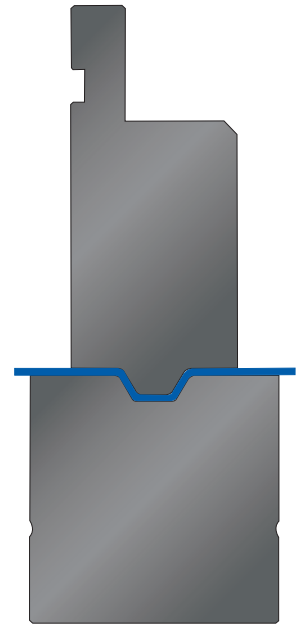
FM1 – FORMING



FM2 – FORMING

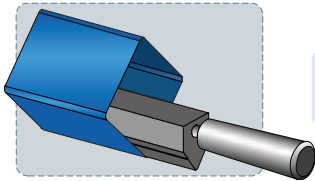
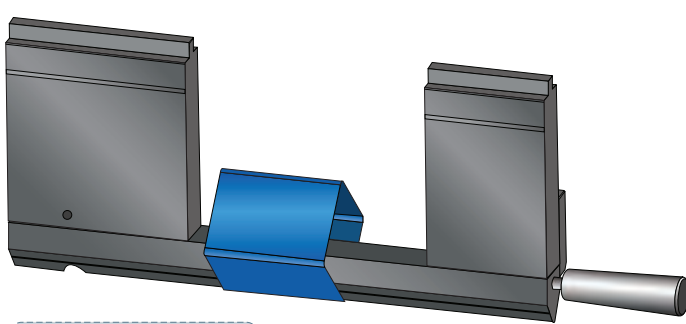


FM3 – FORMING



OH1 – OPEN HAT

A large variety of custom forming sets are available. Custom built to suit any specific requirement.
Call for specific application requirements.

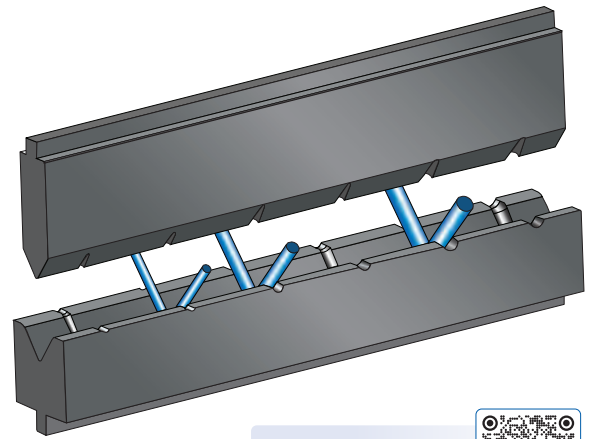


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W1 – WINDOW

Used when minimum return
flange clearance is required.



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Watch the Video

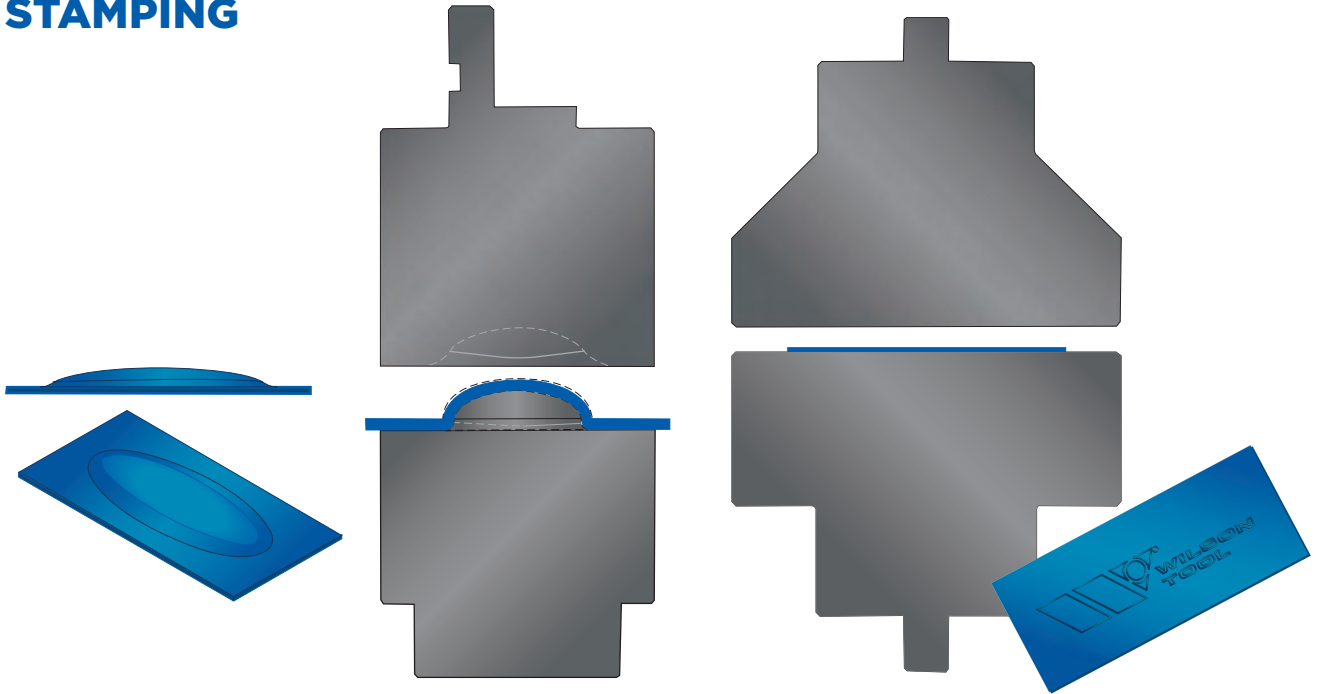


RB1 – ROD BENDING

Provides nesting for the rod
during the forming process.



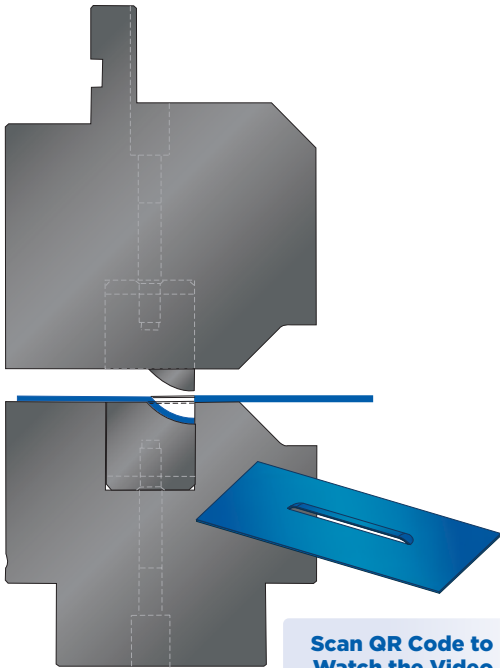
STAMPING



EM1 – EMBOSS

A variety of raised emboss and chisel point emboss sets are available.

LG1 – LOGO



LL1 – LOUVER

Multiple louver configurations are available. For louver forming, sheet must be pre-slit.

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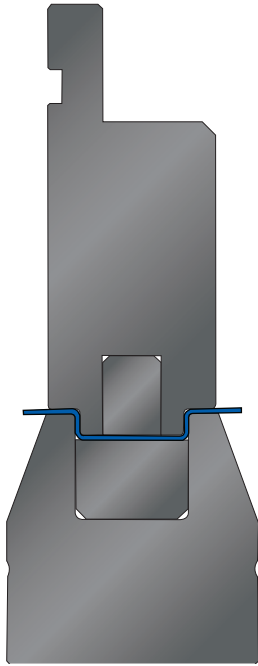


LS1 – LETTER STAMP

Provides chisel point embossing with interchangeable characters. Single row or multi-row available.

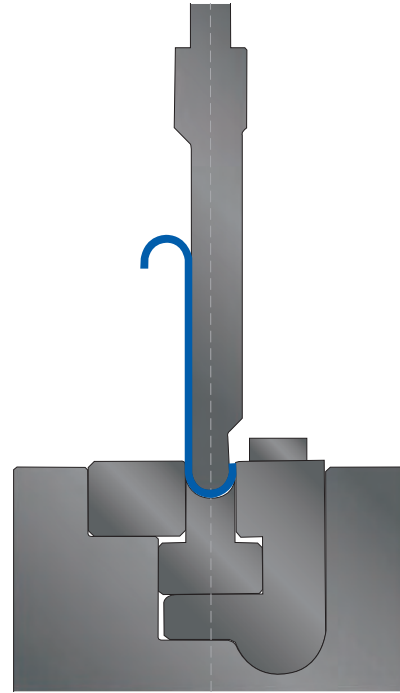
Part No.	Description	Size	Price
4LSP25	Punch Character Holder	—	
42312ST	Flattening Block Die	—	
6898	Characters (requires 26/row)	3/32"	
6896	Characters (requires 20/row)	1/8"	

MECHANICAL



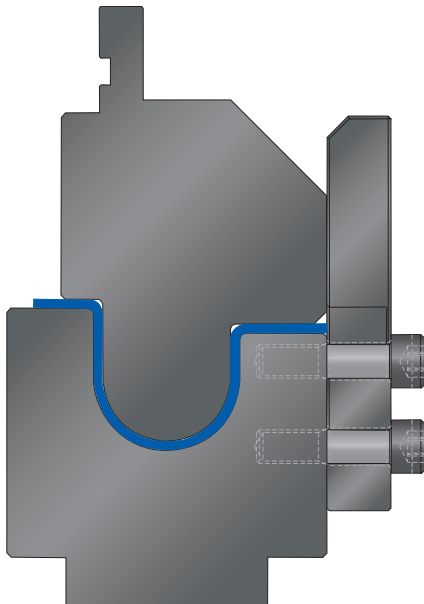
HT1 – HAT CHANNEL

Provides straight wall or angled wall hat channel bending in one stroke. Spring back allowance built in.



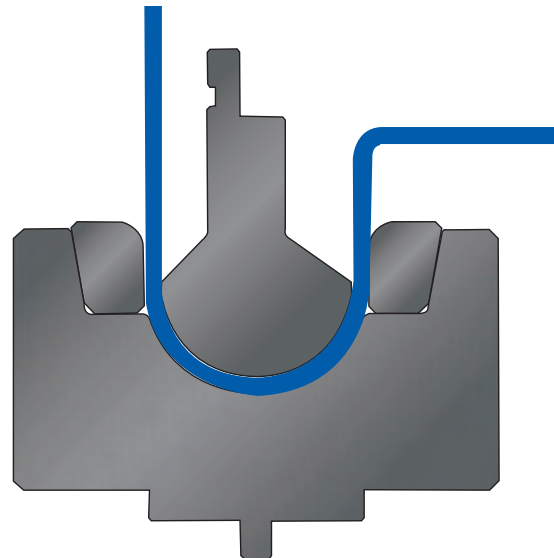
UC1 – U CHANNEL

Recommended for applications where considerable spring back is encountered. Secondary flattening operations may be required.



UC2 – U CHANNEL

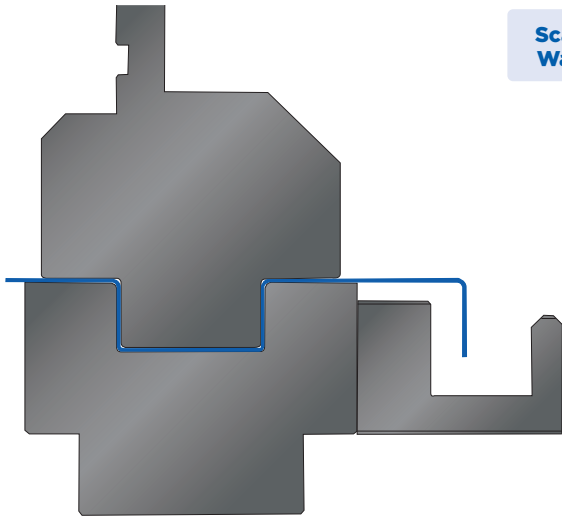
Recommended for applications where considerable spring back is encountered. Secondary flattening operations may be required.



UC3 – U CHANNEL

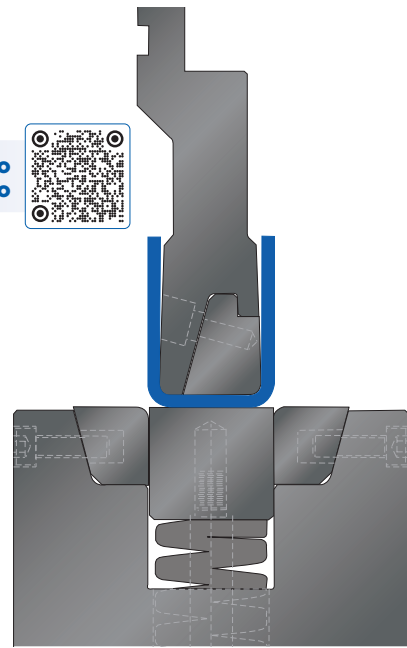
Recommended for applications where considerable spring back is encountered. Secondary flattening operations may be required.

MECHANICAL

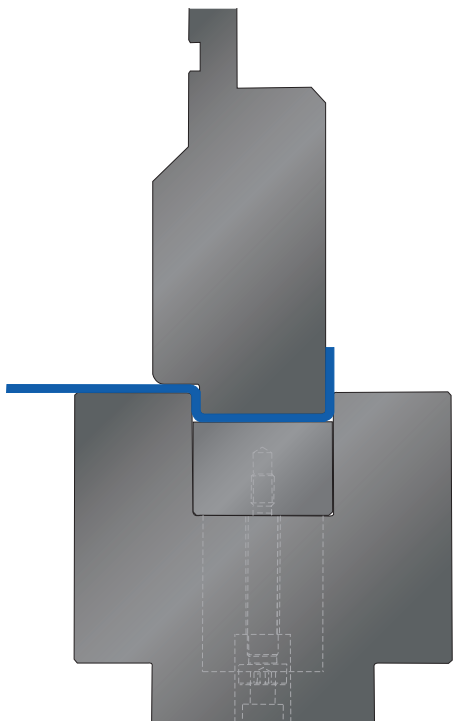


C1 – CHANNEL
For deep channels when the channel bottom needs to remain flat.

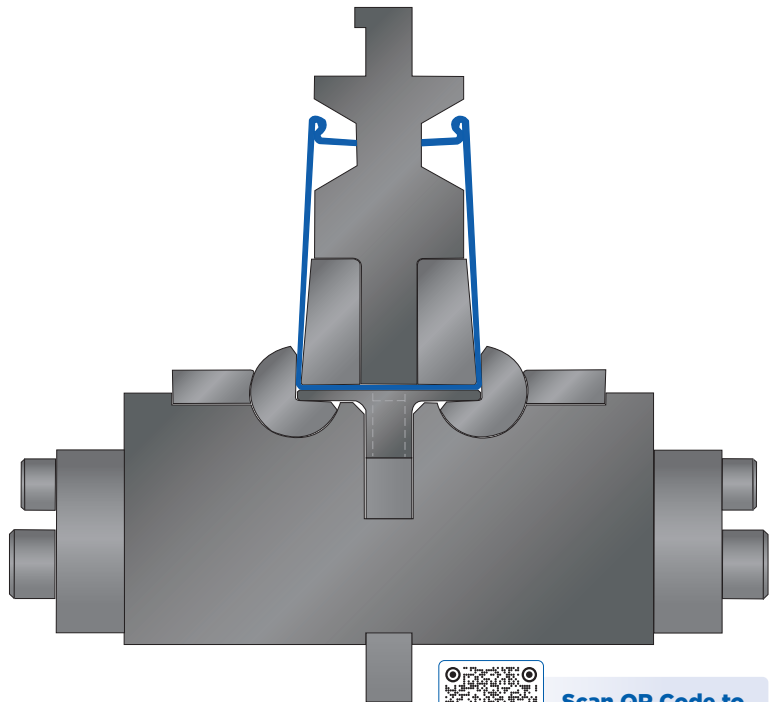
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C2 – CHANNEL
For deep channels when the channel bottom needs to remain flat.



C3 – CHANNEL
For deep channels when the channel bottom needs to remain flat.



C4 – ROTARY BEND CHANNEL
For deep channels when the channel bottom needs to remain flat.

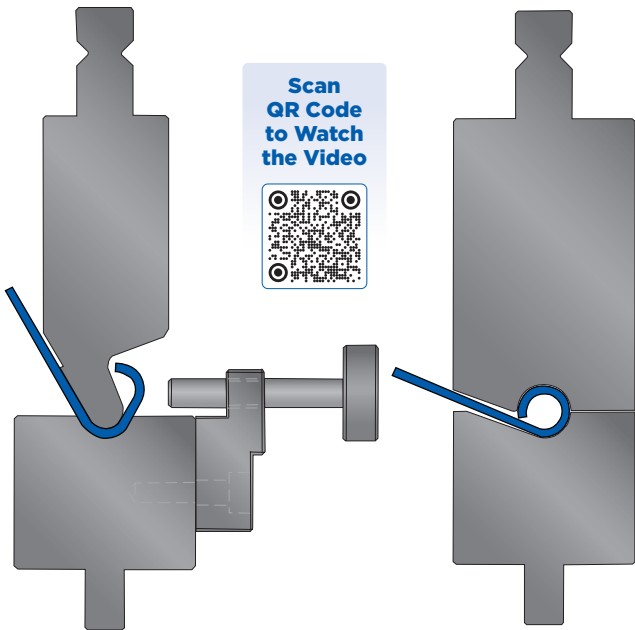


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SPECIALS

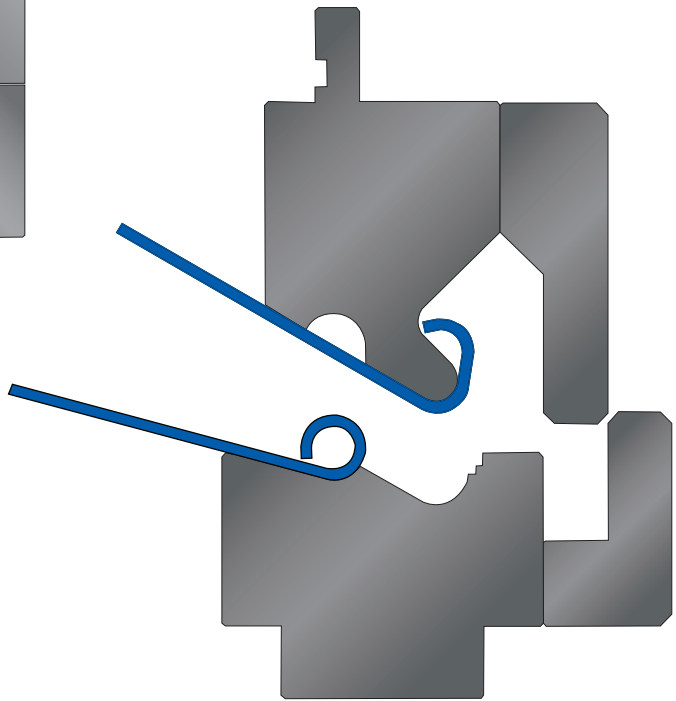
MECHANICAL

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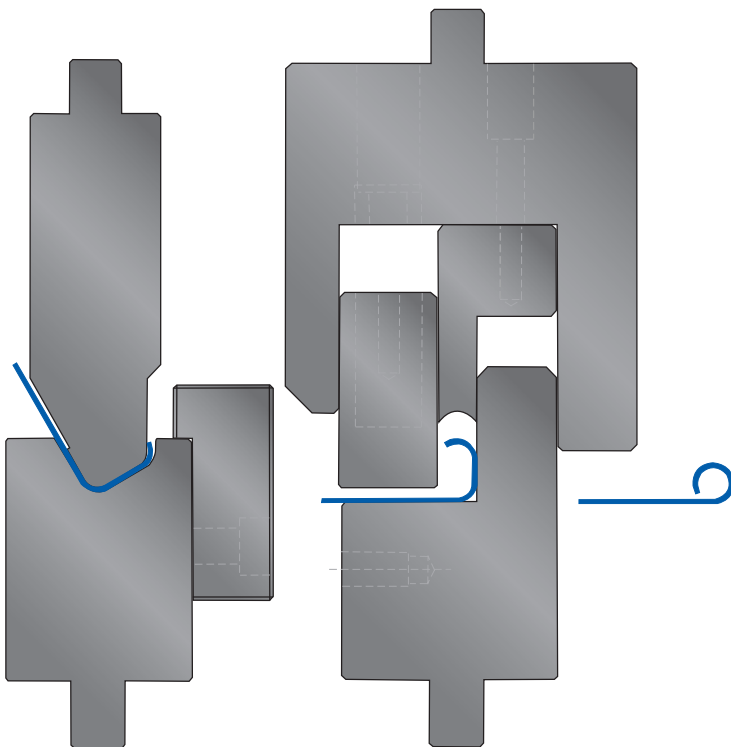
CL1 – CURL TOOL SET

Two tool sets, three machine strokes.



CL2 – CURL TOOL SET

Typically used for thick materials
and large diameter curls.
One tool set, three machine strokes.

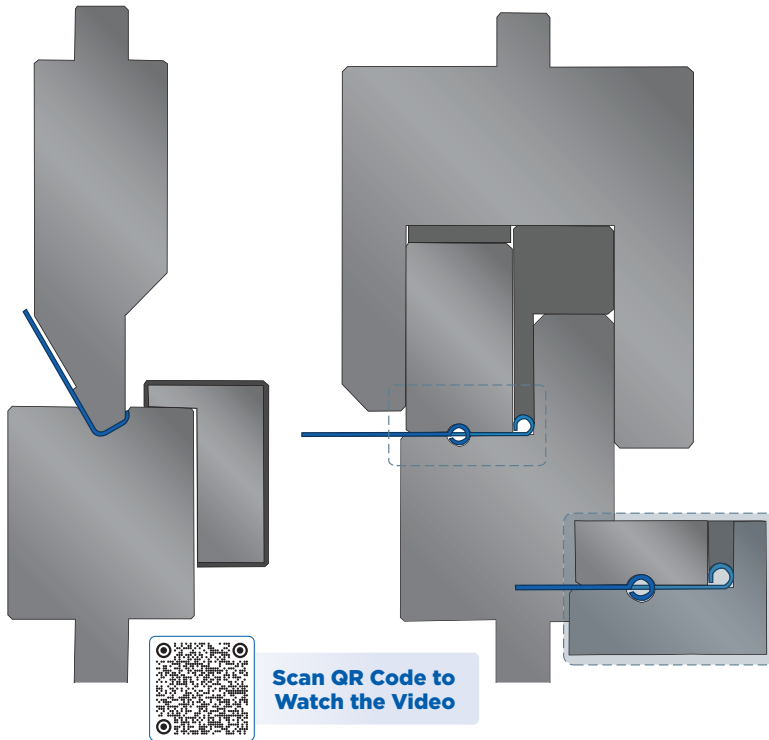


CL3 – CURL

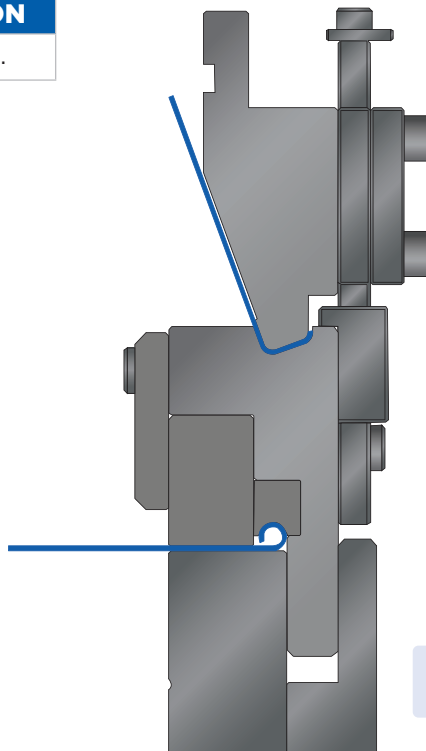
Used for hinges and corner beading.
Two tool sets, two machine strokes.



MECHANICAL



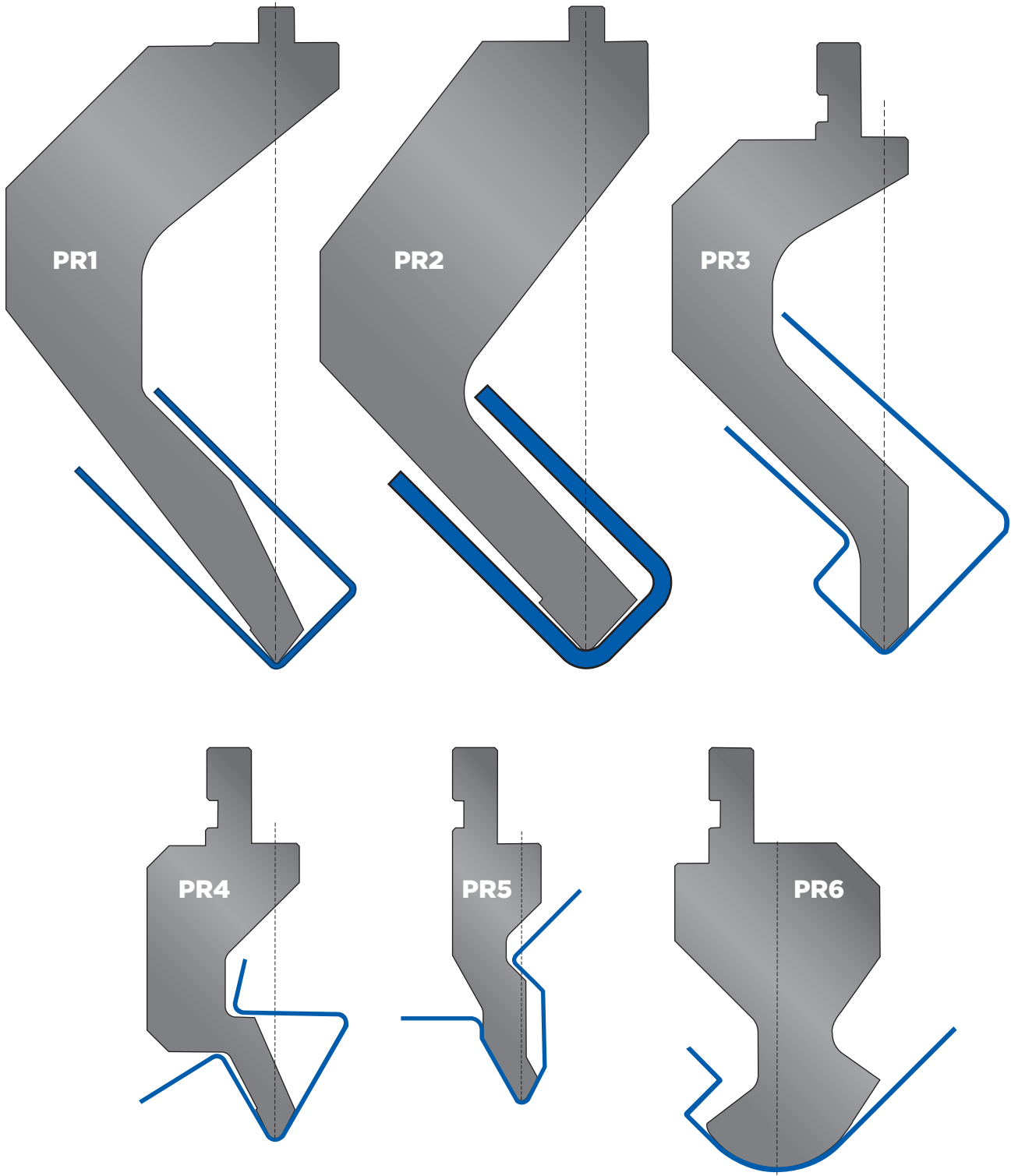
CL4 – CENTER CURL APPLICATION
Two tool sets, three machine strokes.



CL5 – DOUBLE DECKER TOOL SET
Used for hinges and corner beading.
One tool set, two machine strokes.

SPECIALS

SPECIAL SHAPE PUNCHES



PUNCH HOLDERS



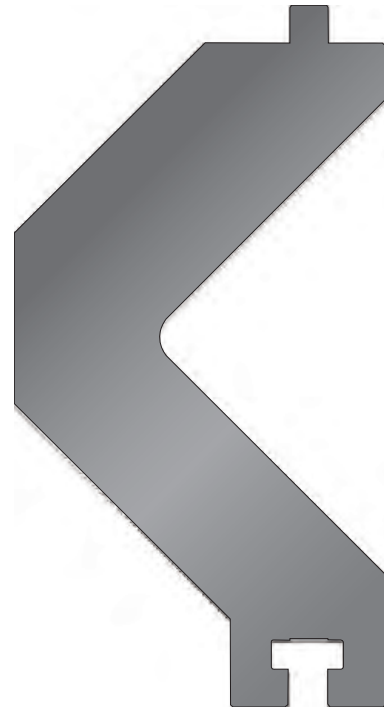
WT – AMERICAN

With Set Screws

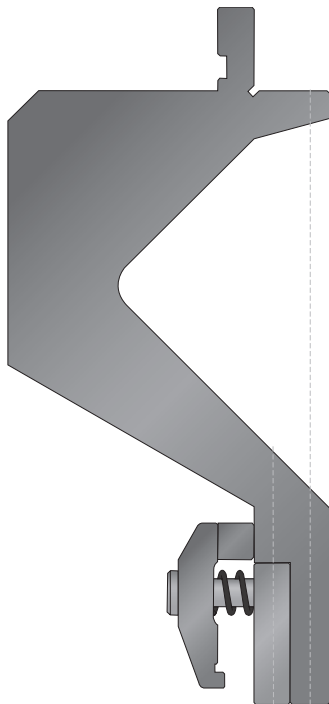


AMERICAN SELF-SEAT HOLDER

WT to American with Clamp Plate



**AMERICAN DEEP
GOOSENECK HOLDER**



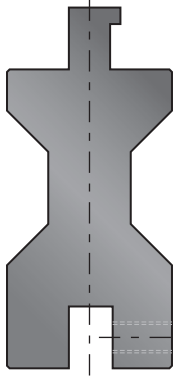
EURO Z1 OR Z2 CLAMPING

Part No. 43002

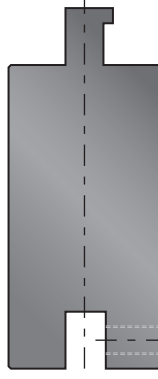
PUNCH HOLDERS

Stack punch holders to make a taller punch to bend tall side flanges or to replace worn OEM punch holders that need replacement. These holders can be made in small sections or one piece to fit the length of your brake.

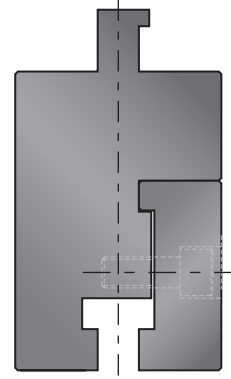
PUNCH HOLDERS



RA1 — DOG BONE



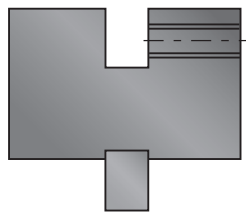
RA2 — SET SCREW



RA3 — CLAMP PLATE

Holders are commonly made to replace any original OEM punch and/or die holders or to accommodate part configuration. These designs can be one solid length or sections that are easier to handle.

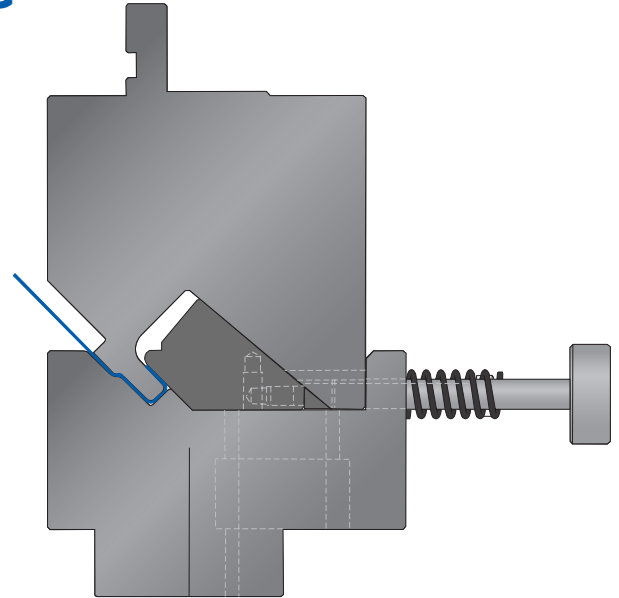
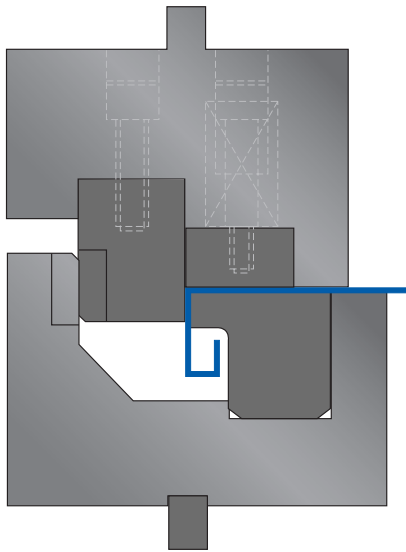
DIE HOLDERS



DIE HOLDERS

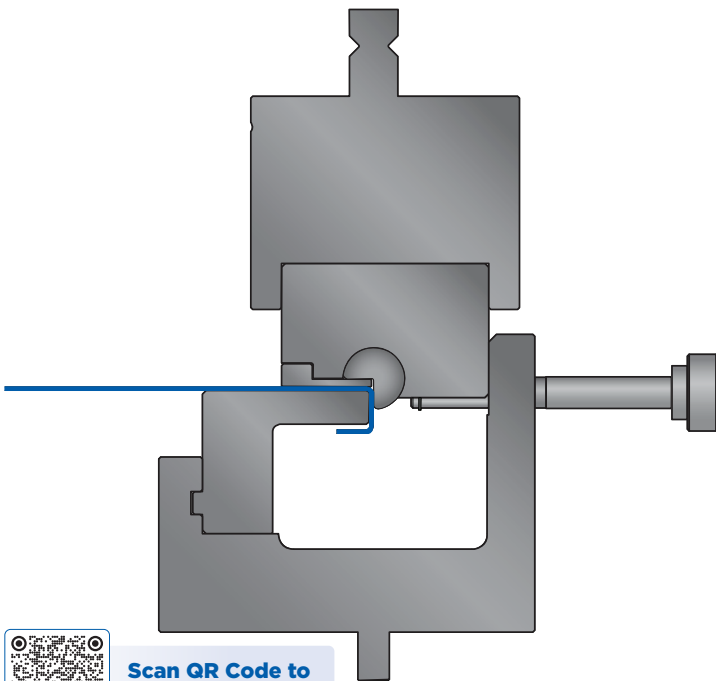
Die holders can raise the die to help with down flange interference or to replace worn OEM die holders that need replacement. These holders can be made in small sections or one piece to fit the length of your brake.

WIPING AND ROTARY BENDING

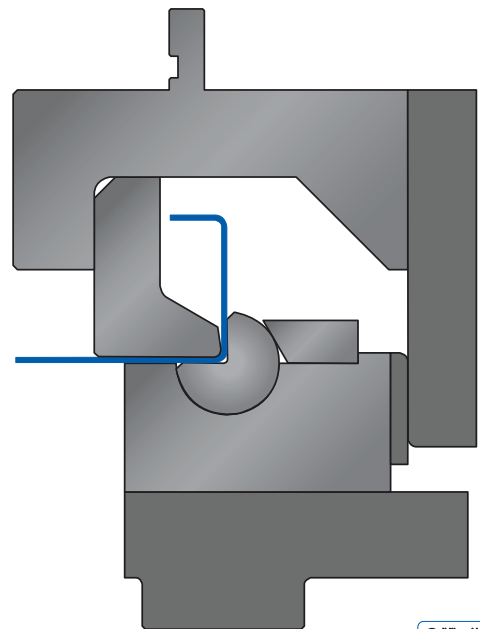


WD1 – WIPE DOWN
 Holds the sheet flat while wiping the flange down. Ideal for large panels and high production.

WO1 – WIPING FORM
 Holds the sheet flat while wiping the flange down. Ideal for large panels and high production.



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RTD – FORM DOWN

RTU – FORM UP

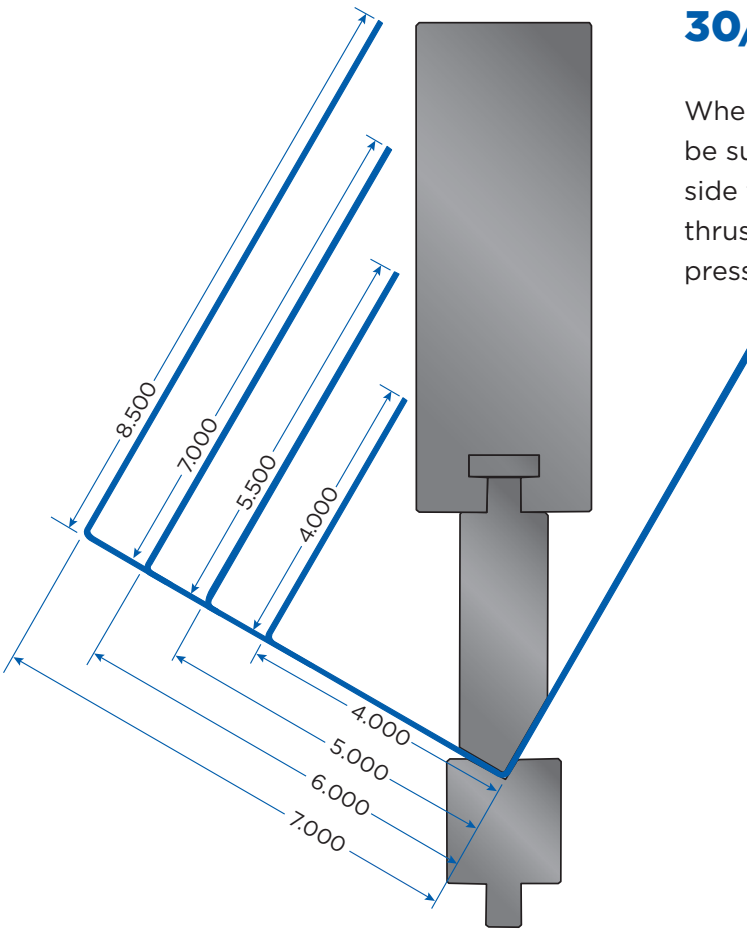
ROTARY FLANGE FORMING

Holds sheet flat while forming. Overbend allowance is built in to compensate for material springback. Ideal for large panels and high production.

SPECIALS

30/60 DEEP BOX BENDING

When forming a 4-sided box, the punch must be sufficient height to prevent the pre-formed side from striking the upper beam. This is a thrusting application and not suitable for all press brakes.



SWING EAR SECTIONS

When bending a box with return flanges, swing ears simply swing out of the way when the bend is complete for easier part removal.

- Swing ear sections are configured in pairs and match the standard profile in height, angle and radius - single ears can be specially ordered.
- The need for swing ears is application-driven and fabricators' expected results should be reviewed by Wilson Tool International prior to ordering to help ensure desired outcomes.



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Left and right ear sections shown in illustration.



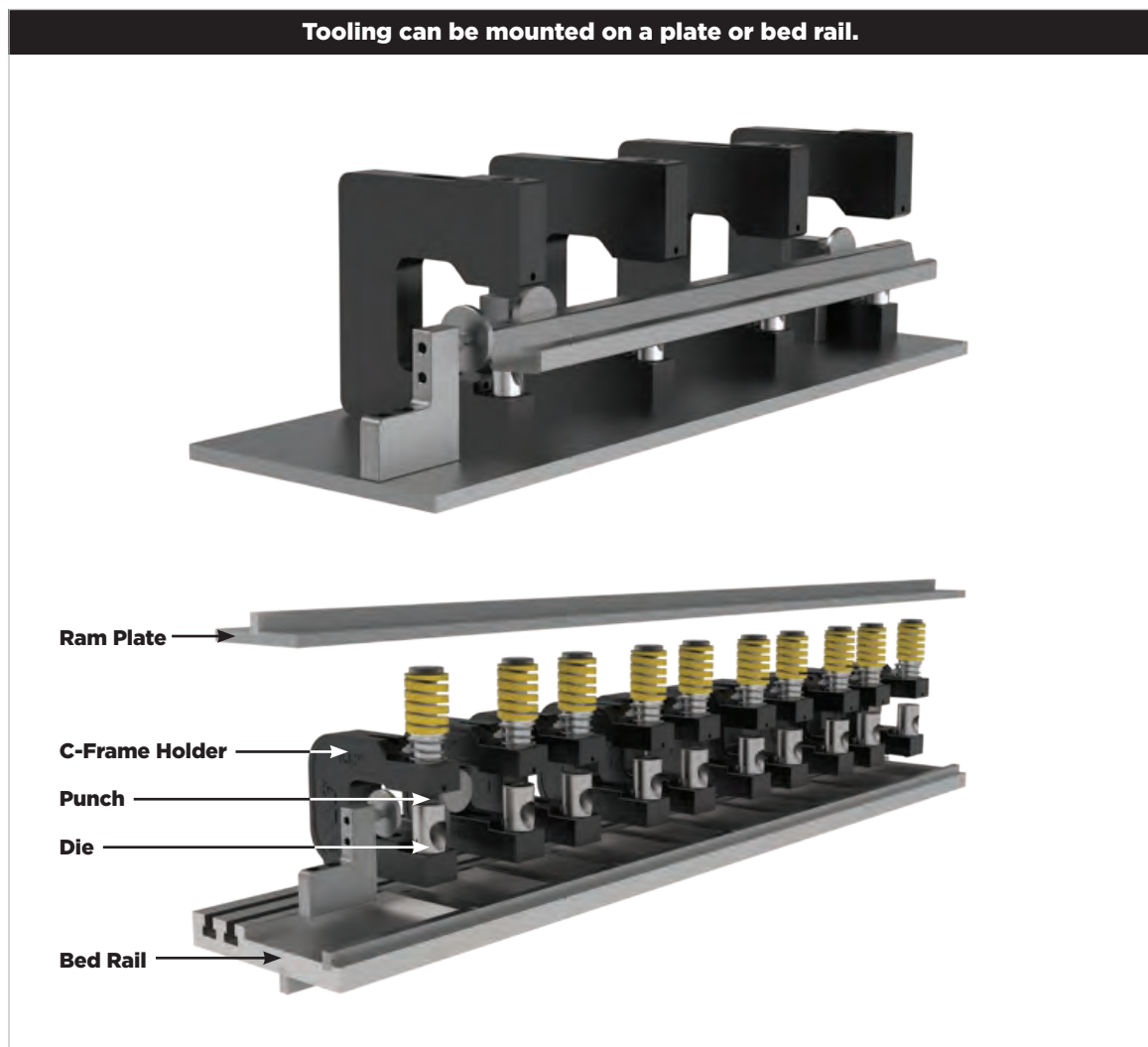
UNITIZED TOOLING

Unitized tooling offers flexibility for various applications, including press brakes, Multicyl setups, and presses. For press brakes, simply attach the units to a bed rail or use a job-specific template. These templates function as a plug-and-play system: attach the template to the machine, secure it and begin punching parts. Once finished, remove the entire plate, including the mounted units. To reduce weight, the plates can be segmented.

Bed rails with adjustable spacers allow you to easily reposition units to accommodate various specifications. Sliding on the face of the bed rails, combined with universal stops on the sides and back, ensure accurate and consistent placement of extruded or flat sheets. This flexibility enables repeatable production processes.



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PRESS BRAKE SPECIALS CHECKLIST

Company:

Contact:

Phone:

Sales Engineer:

Quote #:

Sales Desk Contact:

MACHINE SPECIFICATIONS

BRAKE MAKE/MODEL		TONNAGE	
OVERALL LENGTH		APPROX. AGE	
STROKE	<i>Open Height</i>		<i>Closed Height</i>

TOOLING AND APPLICATION

TOOLING TYPE	<input type="checkbox"/> American <input type="checkbox"/> European <input type="checkbox"/> WT <input type="checkbox"/> Bystronic <input type="checkbox"/> Other			
LENGTH OF BEND				
MATERIAL TYPE		THICKNESS		

Is customer currently performing this bend? Yes No

If YES, specify if this is a Wilson Tool Repeat Replicate Customer Tool Redesign

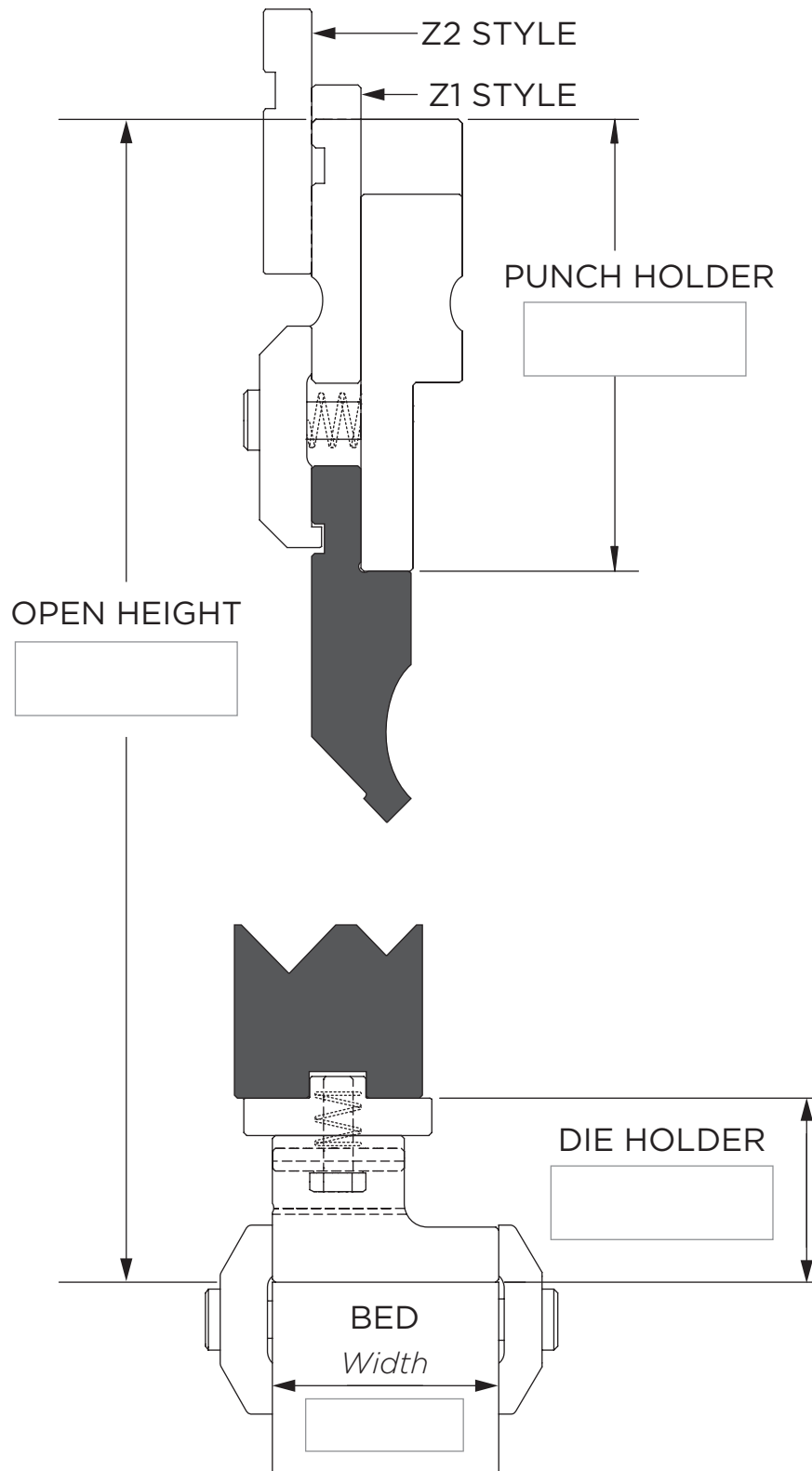
Explain:

TOLERANCE BLOCK

PART RADII TOLERANCE	<i>Tolerances tighter than $\pm 5\%$ may affect price/lead time</i>
PART BEND ANGLE TOLERANCE	<i>Tolerances tighter than $\pm 3\%$ may affect price/lead time.</i>
ESTIMATED ANNUAL USAGE	



TYPICAL PRESS SETUP


















TONNAGE ESTIMATES

Making Multiple Bends Formula on a Press Brake

For shape as shown, in mild steel with radii equal to the metal thickness unless otherwise noted.

MULTIPLY METAL THICKNESS BY FACTOR = TONS PER FT.

SHAPE	DESCRIPTION	AIRFORM	BOTTOMING
	VEE DIE	60	150
	WIPING	—	250
	OFFSET	150	300/600
	MATERIAL THICK OFFSET	300	600
	CHANNEL	300	600
	VEE RIB	200	600
	W DIE	300	600
	OPEN HAT CHANNEL	300	450
	SQUARE HAT CHANNEL	—	600
	PREFORM CURL	—	300
	PREFORM CURL	—	200
	CLOSED CURL	—	300
	RADIUS	—	180/300
	(AIR) TEAR DROP	—	200
	CRUSHED HEM	—	400
SHAPE CONSIDERATIONS		Large Radii Angle Variation Concave/Convex sides	Material Thick Radii Min. Angle Variation Maintain Flatness

REFERENCE

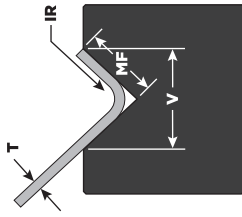
Tonnage Estimation Based on Material Type	Soft Aluminum, Brass, Copper = Tons x 0.35
	Half Hard Aluminum = Tons x 0.5
	Hard/Heat Treated AL, Mild Steel = Tons x 1.0
	Half Hard Brass, Copper = Tons x 1.1
	Stainless Steel = Tons x 1.5
	High Strength Steel = Tons x 2.75



AIR BENDING FORCE CHART IMPERIAL V-OPENINGS & IMPERIAL TONNAGE

NOTE: Formulas and chart are for reference only.

T = Material Thickness; V = V-Opening; MF = Minimum Flange Length; IR = Inside Radius



STANDARD FORMULAS FOR SELECTING A V-OPENING

Material Thickness: .105" or Less = T x 6
 .120" - .313" = T x 8
 .375" - .500" = T x 10
 .625" & Thicker = T x 12

GAGE	DEC. inch [mm]	TONS PER FOOT																		
		V (in.)	0.250	0.313	0.375	0.500	0.625	0.750	0.875	1.000	1.125	1.250	1.500	2.000	2.500	3.000	3.500	4.000	5.000	
	20	0.036 [0.9]	2.9	2.2	1.7	1.2	1.0													
	18	0.048 [1.2]	7.0	4.0	2.9	2.2	1.6	1.3												
	16	0.060 [1.5]		7.8	5.6	3.6	2.7	2.2	1.7											
	14	0.075 [1.9]			11.7	6.0	4.5	3.4	3.0	2.5	2.1									
	13	0.090 [2.3]				12.2	6.8	5.4	4.3	3.7	3.3	2.9								
	12	0.105 [2.7]					10.1	7.4	6.3	5.4	4.4	4.0	3.2							
	11	0.120 [3]						10.5	8.8	7.2	6.2	5.4	4.3	3.2						
	10	0.135 [3.4]							11.3	9.6	8.4	7.0	5.6	4.1						
	9	0.150 [3.8]								13.1	11.9	9.0	6.7	5.2	3.5					
	7	0.188 [4.8]									16.4	14.0	11.2	7.6	5.8	4.5				
	1/4"	0.250 [6.35]										28.8	22.0	15.3	11.5	9.1	7.5	6.2		
	5/16"	0.312 [8]											38.0	26.0	19.2	16.0	12.5	10.6	7.6	
	3/8"	0.375 [9.5]												41.0	29.9	24.0	19.4	16.0	12.3	
	7/16"	0.438 [11.1]													45.2	35.0	28.0	24.0	17.0	
	1/2"	0.500 [12.7]														47.9	39.0	33.1	24.0	
	5/8"	0.625 [16]															69.5	58.0	42.2	
	3/4"	0.750 [19]																92.0	69.0	
	7/8"	0.875 [22]																	104.0	
	1"	1.000 [25.4]																		

Larger v-openings generate less tonnage.

Smaller v-openings generate increased tonnage and are NOT recommended.

Tonnage Estimation Based on Material Type
 Soft Aluminum, Brass, Copper = Tons x 0.35
 Half Hard Aluminum = Tons x 0.5
 Hard/Heat Treated AL, Mild Steel = Tons x 1.0
 Half Hard Brass, Copper = Tons x 1.1
 Stainless Steel = Tons x 1.5
 High Strength Steel = Tons x 2.75

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NOTE: The chart above is based on mild steel (tensile strength of 60,000 PSI) formed to an included angle of 88°. See chart to the right for other materials. Forming to other angles will change the Minimum Flange (MF), Inside Radius (IR) and tonnage.



SET-UP COST ANALYSIS

How Much Will You Save?

Making a new purchase, or switching from one solution to another, often needs to be justified with hard data. Make that easier on yourself with this cost/benefit calculator. Use this tool to evaluate the cost/benefit of incorporating a solution from Wilson Tool International into your organization.

Enter your company-specific information next to the blue arrows in the chart below to see the potential savings you can expect by replacing your current tooling with tooling from Wilson Tool.

CURRENT SITUATION			WITH WILSON TOOL	
▶ \$		HOURLY RATE		\$
\$		MINUTE RATE		\$
▶		SET-UP TIME (MINUTES)	▶	
▶		AVERAGE SET-UPS PER DAY		
\$		COST PER SET-UP		\$
\$		YEARLY COST		\$

By reducing your set-up time from ____ minute(s) to ____ minute(s) for ____ set-ups per day, you will save up to \$_____ per year, or ____ weeks per year of labor costs due to increased efficiency.

REFERENCE

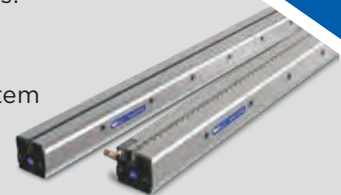
CLAMPING SOLUTIONS FOR FASTER TOOL CHANGES

Clamping solutions for upper and lower beams can be added to virtually any press brake to speed tool changeovers and reduce downtime. Whether you're looking for deflection control, simple lever activation or an ultra-fast hydraulic solution, Wilson Tool has a clamping system to meet your needs.



Express Crowning® System

For bending longer parts without deflection, the Express Crowning® system is the precise and consistent option for crowning your press brake.



Express Rail® Clamping Systems

Express Rail® clamping systems are the fastest acting hydraulically powered options, using a wireless pendant control that clamps and seats tooling in seconds.

Express Clamps

European-Style punches instantly lock into place with a pull of the lever. These self-seating clamps for straight or beveled tang punches are available for virtually any make or model of press brake. (See pages 34-35.)



TOOL STORAGE

XTREME STORAGE CABINET



- Vertical configuration for drawer access from either side
- High-capacity drawers with a keyed lock and label window open smoothly with rolling casters
- Trays can be adjusted vertically to maximize space for the height of tooling and tray inserts can be adjusted to adapt to your style of tooling, and to create a center channel from 0-59mm wide
- Drawer trays hold punches in tip-up position
- Shallow top tray in each drawer for storing small items/hand tools
- Relatively small footprint allows for placement close to the machine



XTREME STORAGE CABINET DETAIL	55130 (XSC312)	55131 (XSC512)
Number of Drawers	3	5
Cabinet Height (outside dim.)	48.8" [1.24m]	48.8" [1.24m]
Width (left to right — outside dim.)	26.0" [0.66m]	40.9" [1.04m]
Depth / Tool Space (front to back — inside dim.)	41.3" [1.05m]	41.3" [1.05m]
Number of Tool Trays	9	15
Total Length* of Tooling (1 tool/tray — inside dim.)	Up to 31' [9.44m]	Up to 51.5' [15.7m]
Total Length* of Tooling (2 tools/tray — inside dim.)	Up to 62' [18.9m]	Up to 103' [31.4m]

*Total length does not include available storage in the top most tray in each drawer.



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TOOL STORAGE

XTREME STORAGE CABINET



- Vertical configuration for drawer access from either side
- High-capacity drawers have a keyed lock and open smoothly with rolling casters
- Vertically adjustable trays maximize space for the height of tooling
- Adjustable tray inserts accommodate up to two rows of various tooling profiles. Removable center channel for larger tooling.
- Drawer trays hold punches in tip-up position
- Shallow top tray in each drawer for storing small items/hand tools
- Relatively small footprint allows for placement close to the machine

CUSTOM COLOR OPTIONS

051 Everest Blue	052 Classic Blue	055 Avalanche Blue	057 Midnight Blue	560 Glossy Sapphire Blue	041 Beige	061 Frost White	071 Light Gray	745 Modern Gray	072 Charcoal Gray
1025 Glossy EverGreen	208 Glossy Yellow	085 Sienna Orange	081 Flame Red	806 Glossy Carmine Red	815 Glossy Cranberry Red	091 Black	902 Glossy Black	741 Glossy Carbon Black	616 White

*Colors may differ slightly from those shown. Allow 15 working days lead time for custom colors.



Catalog Numbers[†]

Xtreme Storage Cabinet Detail	5103A / 5103W	5104A / 5104W	5105A / 5105W	5106A / 5106W
Number of Drawers	3	4	5	6
Cabinet Height (outside dim.)	62" [1575mm]	62" [1575mm]	62" [1575mm]	62" [1575mm]
Width (left to right - outside dim.)	23" [585mm]	30" [762mm]	37" [940mm]	44" [1118mm]
Depth / Tool Space (front to back - inside dim.)	44" [1118mm]	44" [1118mm]	44" [1118mm]	44" [1118mm]
Number of Tool Trays	12	16	20	24
Total Length* of Tooling (1 tool/tray - inside dim.)	40' [12.1m]	53' [16.1m]	66.5' [20.2m]	80' [24.3m]
Total Length* of Tooling (2 tools/tray - inside dim.)	80' [24.3m]	106' [32.3m]	133' [40.5m]	160' [48.7m]

[†] A = American or European Style Tooling; W = WT or European Style Tooling

*Total length does not include available storage in the top trays.

TOOL STORAGE

PRESS BRAKE TOOL STORAGE

- Solid steel construction
- Rated capacity of 3,600 lbs.
- Total weight capacity: 440 lbs. per drawer
- One-drawer-at-a-time integrated locking
- Retainer top with rubber mat
- Stationary cabinets have a removable kick-plate for fork lift transportation
- Mobile base option with side handle has heavy-duty casters and extended wheel base to prevent tipping
- Cabinets ship via freight truck



Tip-up Cabinet for European-Style Punches

- 5 drawers with upright storage for punches held in steel U-channels

Part No.	W x D x H	Drawer Sizes
91007S	42" x 24" x 43"	2 - 2.75" [69.9mm] 1 - 6.75" [171.4mm]
91007	42" x 24" x 47.5"	2 - 7.75" [196.9mm]

Lead time = 5 to 15 Days



Lay-Down Cabinet for Press Brake Tooling

- 9 drawers for punches and dies lined with blue, industrial-strength, closed cell foam
- Lay down design displays laser markings and makes for easy identification of tools
- Heavy-duty construction with reinforced drawers for industry leading twist strength

Part No.	W x D x H	Drawer Sizes
90021HDS	48" x 27" x 49"	5 - 2.25" [57.1mm] 4 - 3.25" [82.5mm]
90021HDM	48" x 27" x 53.5"	

Lead time = 5 to 15 Days



CUSTOM COLOR OPTIONS

051 Everest Blue	052 Classic Blue	055 Avalanche Blue	057 Midnight Blue	560 Glossy Sapphire Blue	041 Beige	061 Frost White	071 Light Gray	745 Modern Gray	072 Charcoal Gray
1025 Glossy EverGreen	208 Glossy Yellow	085 Sienna Orange	081 Flame Red	806 Glossy Carmine Red	815 Glossy Cranberry Red	091 Black	902 Glossy Black	741 Glossy Carbon Black	616 White

Colors may differ slightly from those shown. Allow 15 working days lead time for custom colors.



MARK-FREE BENDING

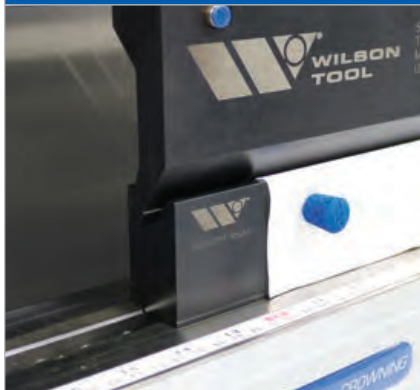
URETHANE ROLLS — 6 in. x 100 ft.



Part No.	Thickness	Durometer	Description
42530	.015" [.4mm]	85A (Milky White)	<ul style="list-style-type: none"> • More elastic than blue • Well suited for deeper draw applications • Will not last as long as blue for 90° bends
42531	.030" [.8mm]		
42532	.022" [.56mm]	95A (Blue)	<ul style="list-style-type: none"> • A more ridged solution • Lasts considerably longer than the white options in many applications • Harder and less elastic than blue • Not suited for deeper draw applications

Note: This is not a good time to cheat the V-opening and make it smaller. Keep in mind you are filling the V-opening with two thicknesses of urethane so it would be safer to oversize the V-opening a bit. The larger the shoulder radius, the larger the V-opening relative to the material type and thickness, the longer the life will be realized.

PROTECTIVE FABRIC DRAPE

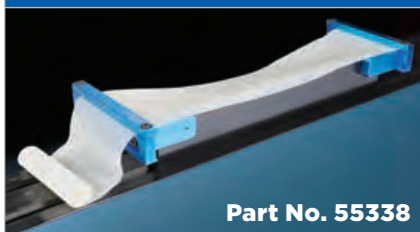


Forms a protective barrier between the sheet metal and the die shoulders during the bending process.

Lasts 5-8 times longer than a urethane drape.

Part No.	Description
55335	12.5m [41'] length x 120mm [4.7"] width
55337	12.5m [41'] length x 240mm [9.5"] width
988156	3/8" x 1/2" Cylinder Magnet w/Blue Grip Cover

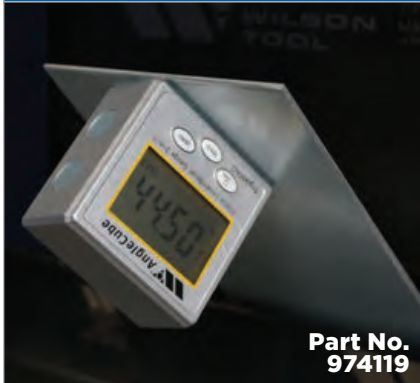
DRAPE HOLDER



Magnetic body provides quick, secure attachment to any press brake die or die holder. Hex head bolts allow for front-to-back adjustment of material placement and easy material swaps. Low-profile design helps avoid bulky rolls getting in the operator's way.

MEASURING TOOLS

DIGITAL ANGLE CUBE



The compact size of the Digital Cube allows you to quickly read bend angles of work material. Real time display of angle comparison. Magnets on three sides. Self-rotating display for 180° readings.

HAND TOOLS

METRIC HEX KEY WRENCH SET



Metric 9 piece long arm set.
Contains: 1.5 x 77, 2 x 83,
2.5 x 90, 3 x 98, 4 x 106, 5 x 118,
6 x 137, 8 x 156, 10 x 170

SOFT FACE HAMMER



Polyurethane dead-blow hammer. Steel pellets inside hammer head impact a split second after the hammer face, reducing rebound.

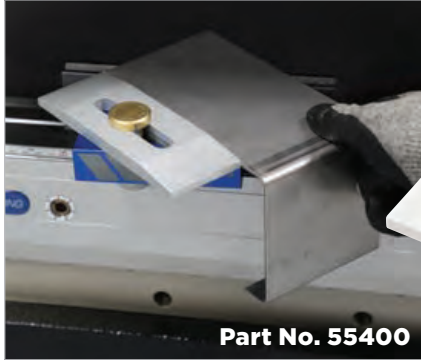
MAGNET SQUARE



ON/OFF work holding magnet.
150 lb. [70 kg] of hold force.
Size: [30] Square

GAUGING TOOLS

DIAL ADJUSTABLE SQUARING ARM



Part No. 55400



Infinite angle squaring arm with tool-free adjustment can be used as a left or right hand gauge. Significant magnetic holding power keeps the unit in place. Small enough to be out of the way, yet big enough to provide a sizable surface to rest the material being bent.

MAGNETIC SQUARING ARM



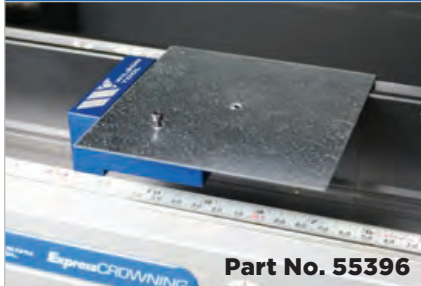
Part No. 42750



Increase bending accuracy with this simple hand tool. Suitable for any press brake die with a flat surface for easy attachment. Adjustable from 0° or 90° and is available in a left-handed or right-handed version.

Part No.	Description
42750L	Magnetic Squaring Arm LEFT
42750R	Magnetic Squaring Arm RIGHT

MAGNETIC SQUARING BLOCK

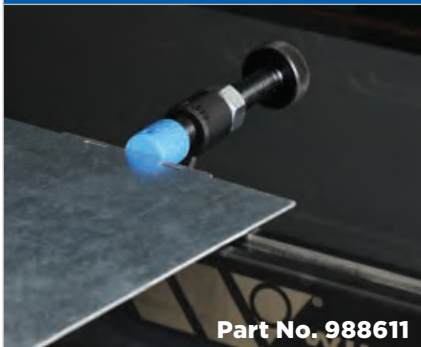


Part No. 55396



Versatile, durable, 90° squaring block for left or right support and gauging. Strong magnets hold the lightweight tool in place while allowing for easy repositioning.

MAGNETIC GAUGE



Part No. 988611



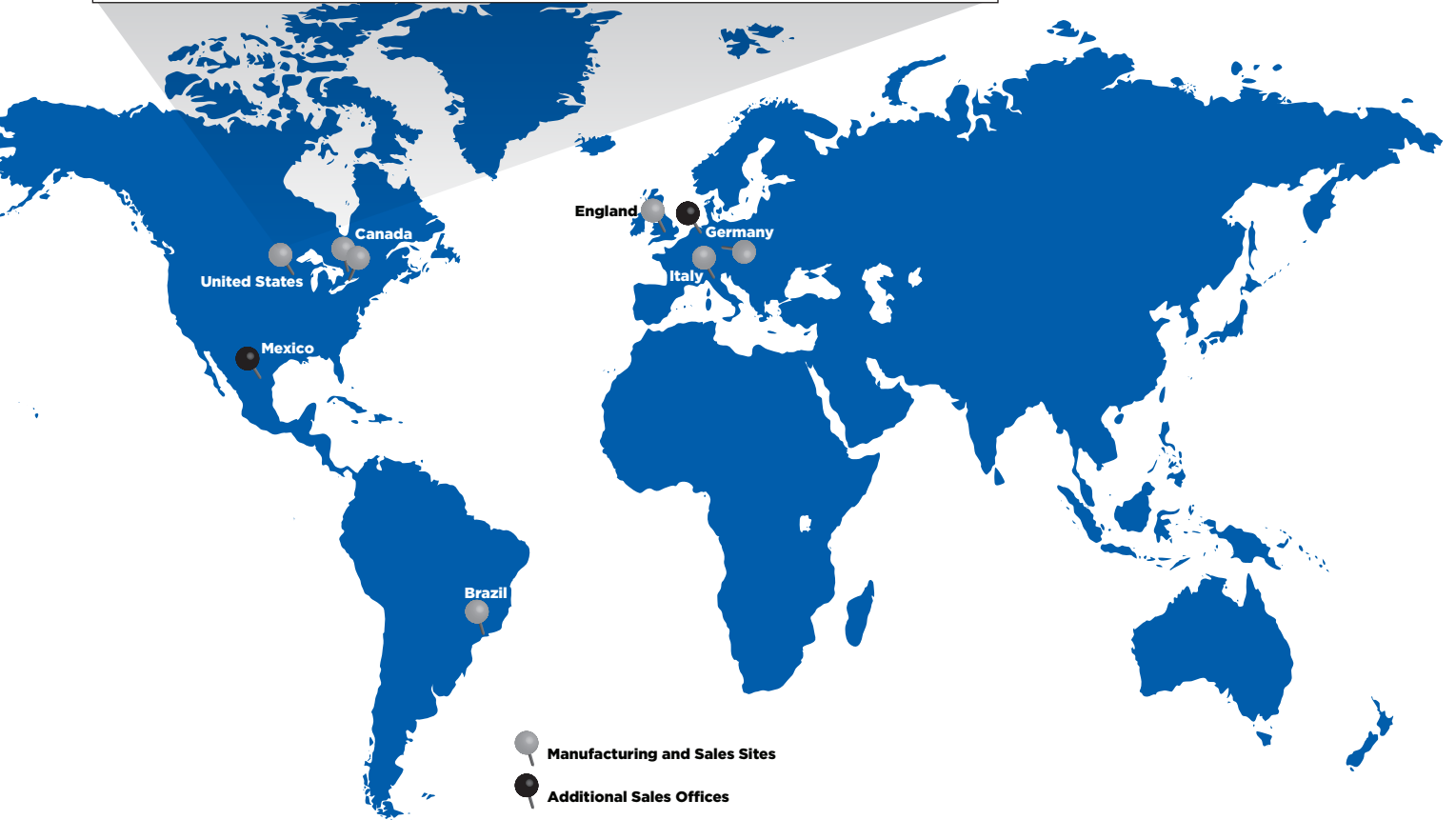
Use for back gauging, gauging outside the frame of the brake, front gauging, or when the part doesn't quite work with part configuration.

Part No.	Description
988741	Blue Threaded Cap

WILSON TOOL INTERNATIONAL HEADQUARTERS

12912 Farnham Avenue N, White Bear Lake, MN 55110, USA
800.445.4518 | **bending@wilsontool.com**

Canada 800.268.5573 bending@wilsontoolcanada.com
Mexico 001.800.741.2510 doblez@wilsontool.com



GUARANTEED TO OUTPERFORM

With Wilson Tool International, you're not just receiving tools — you're gaining a partner dedicated to your productivity, and products backed with a guarantee to outperform your current tooling.



B374C (9.2025)