



THICK TURRET PUNCH TOOLING SOLUTIONS

2025

My Account

by Wilson Tool International

Wilson Tool Customers can now enjoy 24/7 access to their account online! My Account features include:

- Online Ordering
- Request Quotes
- Access Drawings
- View Invoices
- Track Packages
- View Order History

wilsontool.com/MyAccount



CONNECT WITH WILSON TOOL

Keep up with everything that's new at Wilson Tool International! Visit our website or find us on social media for the latest information, news, videos and product releases.



TERMS AND CONDITIONS

ORDER Minimum order is \$50.00

CREDIT REQUIREMENTS All orders are subject to approval by our Credit Department. If you are a new account, please furnish us with your tax exempt status, a bank reference, three current supplier references and/or your current D&B rating with your first order. A credit limit will be imposed on new accounts until credit has been established.

PAYMENT TERMS Terms are net 10 days. Catalog prices are subject to change without notice.

FREIGHT Orders are shipped F.O.B. from our manufacturing facility. (International Shipments are Incoterms: Ex Works).

ORDER CANCELLATION If an order is canceled, an additional charge will be assessed to cover the cost of labor and material.

RETURNED MATERIAL A handling/restocking fee will be applied to all standard products returned for credit. A return authorization number and shipping instructions must be obtained in advance before an item can be returned.

CLAIMS All claims or product shortages must be made within 30 days of the invoice date.



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 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.



WILSON STYLE



HPX



HP2



basix



THICK TURRET TOOLING SOLUTIONS



SMALL STATION ADVANTAGES	HPX®	HP2	BASIX
Hardened guides for increased durability	●	●	●
Simple tool-less stripper change	●	●	●
Relieved strippers for extended grind life	●	●	●
Optima® coated punches available	●	●	●
Slug Hugger® 2 – maximum slug retention	●	●	●
Internal and external tool lubrication	●	●	
Machine lubrication capability (ABS only, all HPX®)	●	●	
OEM compatible	●	●	
In machine adjustment for faster set ups	●	●	
Easy click length adjustment – no shims or tooling required	●	●	
Maximum available grind life	●	●	
EXP® quick change technology	●		
Made standard from Ultima® premium tool steel	●		
Accepts round or shaped punches in the same assembly	●		
Push button guide release	●		

HPX® 1/2" A STATION – WILSON STYLE

WILSON STYLE 1/2" A



PUNCH AND GUIDE ASSEMBLY



GUIDE



EXP® PUNCH



STRIPPER



DIE



SHIM

Scan QR Code to Explore More HPX®



PUNCH AND GUIDE ASSEMBLY	CAT. NO.	PRICE
Round	14936	
Shape	14937	
Optima® Coating	—	
GUIDE ASSEMBLY	CAT. NO.	PRICE
Assembly only 0° & 90°	14942	
Assembly only 0° & 45°	14943	
Assembly only 0°, 90°, 180° & 270°	14944	
SPRING PACK ASSEMBLY	CAT. NO.	PRICE
Spring Pack Assembly only	14366	
GUIDE	CAT. NO.	PRICE
Round	14076X	
Shape 0°	14077X	
Shape 0° & 45°	14079X	
Shape 0° & 90°	14078X	
PUNCH	CAT. NO.	PRICE
Round	13904	
Shape	13905	
Optima® Coating	—	
STRIPPER	CAT. NO.	PRICE
Round	13045	
Shape	13152	
DIE	CAT. NO.	PRICE
Round Slug Hugger**	2192	
Round Standard	1808	
Shape Slug Hugger* 2*	12959	
Shape Positive	1817	
Shape Negative	1818	
DIE SHIM	CAT. NO.	PRICE
.010" [0.25mm] Pack of 25	2208	
.030" [0.76mm] Pack of 25	2722	
.060" [1.5mm] Pack of 25	2172	

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

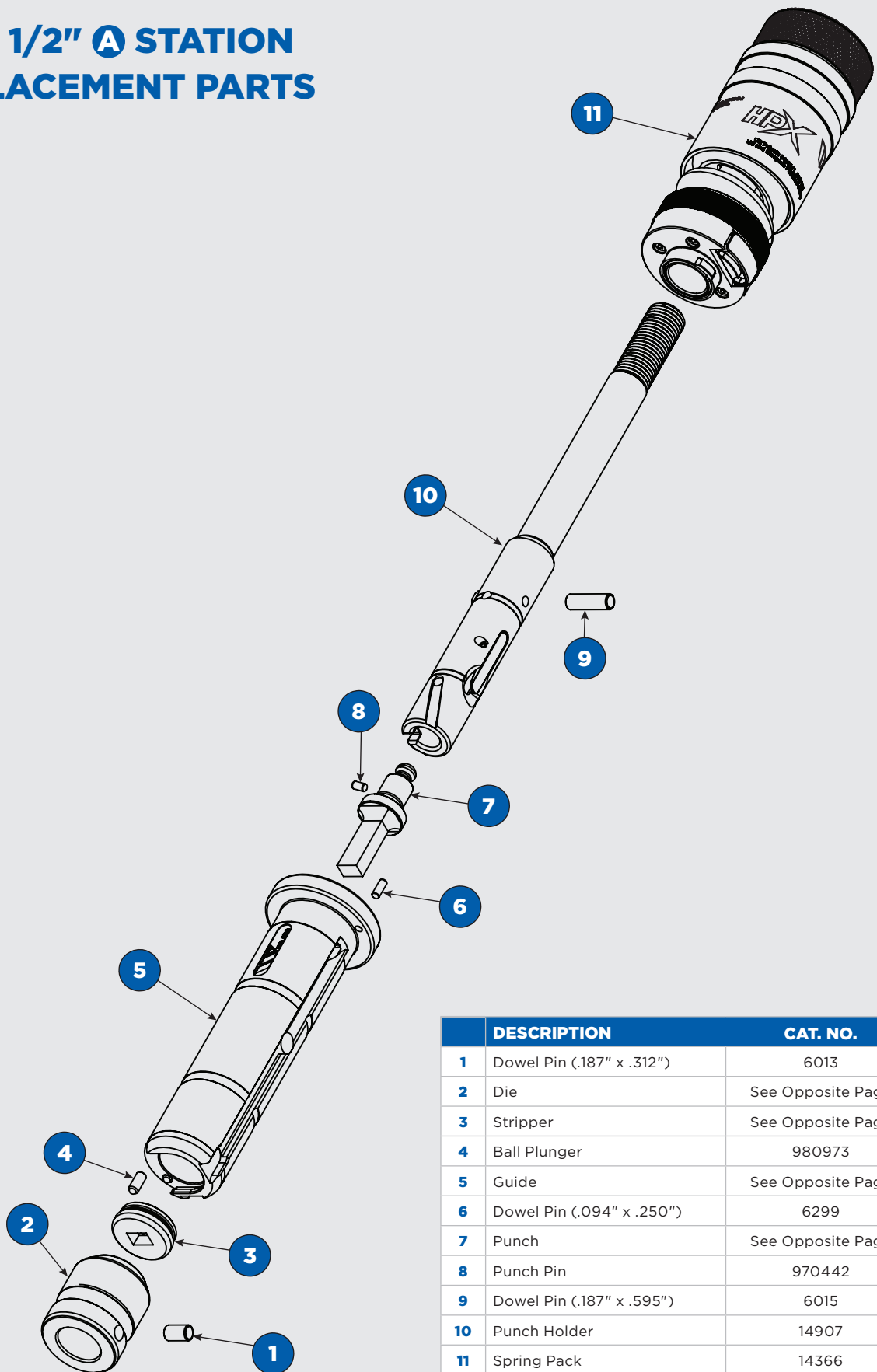
Additional charges may apply to non-standard features. See page 156.

DESCRIPTION	A DIMENSION	MAX. MATERIAL THICKNESS	NOTES
HPX® tooling is Wilson Tool's 'Best' product. It is loaded with all the great features of the HP2 plus the EXP® quick change punch system with Ultima® premium tool steel.	.500" [12.7mm] 	.150" [3.81mm] 	<ul style="list-style-type: none"> Compatible with ABS and non-ABS machines. Ultima® tool steel is standard in EXP punches. Dies are available in Ultima® tool steel upon request.

STANDARD SHAPES Non-standard shapes available. See pages 136-142.



HPX® 1/2" A STATION REPLACEMENT PARTS



	DESCRIPTION	CAT. NO.
1	Dowel Pin (.187" x .312")	6013
2	Die	See Opposite Page
3	Stripper	See Opposite Page
4	Ball Plunger	980973
5	Guide	See Opposite Page
6	Dowel Pin (.094" x .250")	6299
7	Punch	See Opposite Page
8	Punch Pin	970442
9	Dowel Pin (.187" x .595")	6015
10	Punch Holder	14907
11	Spring Pack	14366

1/2" A

WILSON STYLE

HPX® 1-1/4" Ⓑ STATION – WILSON STYLE

WILSON STYLE 1-1/4" Ⓑ



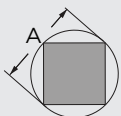
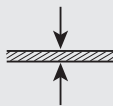
Scan QR Code to Explore More HPX®



PUNCH AND GUIDE ASSEMBLY	CAT. NO.	PRICE
Round	14939	
Shape	14940	
Optima® Coating	—	
GUIDE ASSEMBLY	CAT. NO.	PRICE
Assembly only 0° & 90°	14945	
Assembly only 0° & 45°	14946	
Assembly only 0°, 90°, 180° & 270°	14947	
SPRING PACK ASSEMBLY	CAT. NO.	PRICE
Spring Pack Assembly only	14367	
GUIDE	CAT. NO.	PRICE
Round	14084X	
Shape 0°	14085X	
Shape 0° & 45°	14087X	
Shape 0° & 90°	14086X	
PUNCH	CAT. NO.	PRICE
Round	13916	
Shape	13917	
Optima® Coating	—	
STRIPPER	CAT. NO.	PRICE
Round	2433	
Shape	2432	
DIE	CAT. NO.	PRICE
Round Slug Hugger**	2194	
Round Standard	2021	
Shape Slug Hugger* 2*	12961	
Shape Positive	2025	
Shape Negative	2026	
DIE SHIM	CAT. NO.	PRICE
.010" [0.25mm] Pack of 25	2209	
.030" [0.76mm] Pack of 25	2724	
.060" [1.5mm] Pack of 25	2173	

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

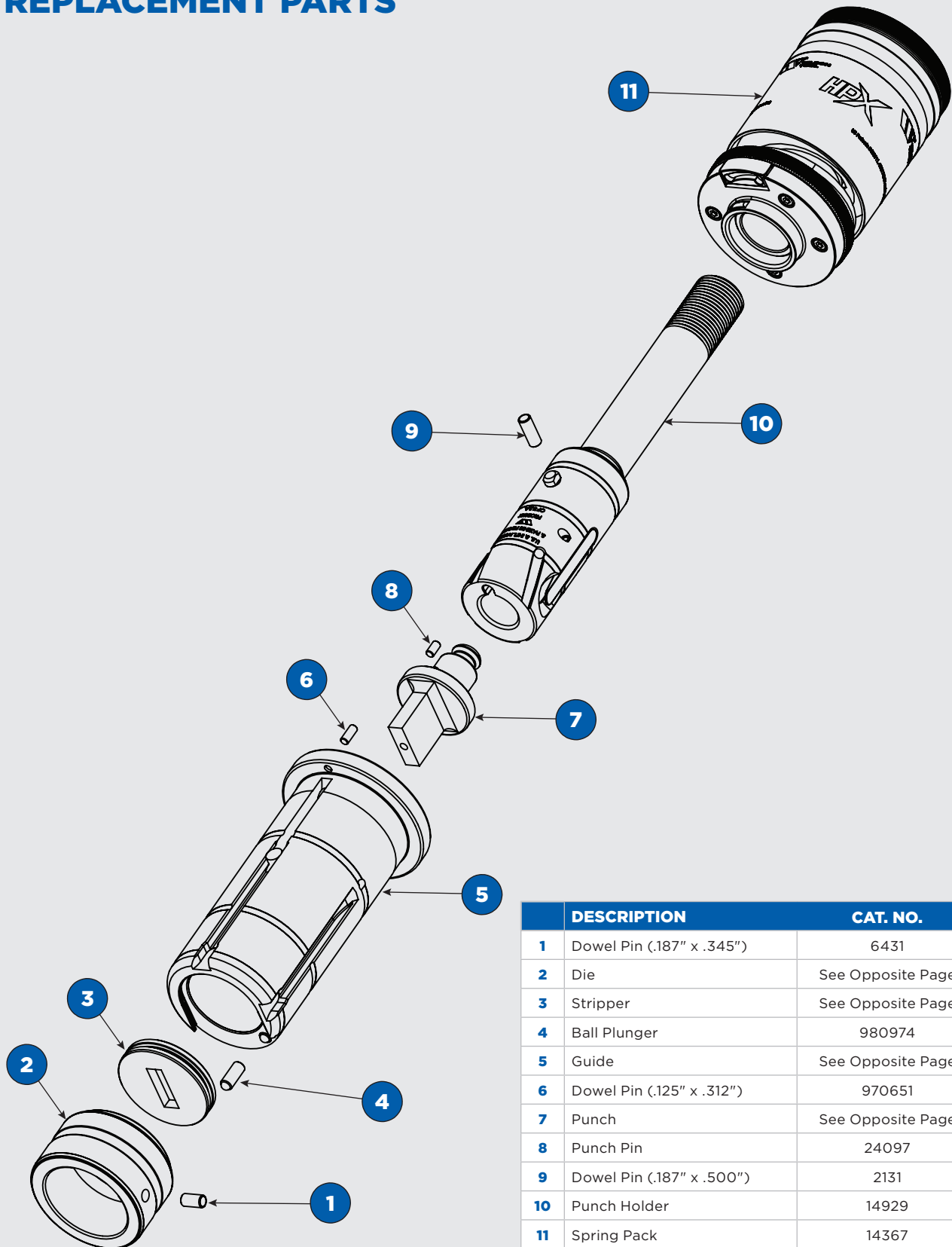
Additional charges may apply to non-standard features. See page 156.

DESCRIPTION	A DIMENSION	MAX. MATERIAL THICKNESS	NOTES
HPX® tooling is Wilson Tool's 'Best' product. It is loaded with all the great features of the HP2 plus the EXP® quick change punch system with Ultima® premium tool steel.	1.250" [31.8mm] 	.250" [6.35mm] 	<ul style="list-style-type: none"> Compatible with ABS and non-ABS machines. Ultima® premium tool steel is standard in EXP® punches. Dies are available in Ultima® tool steel upon request.

STANDARD SHAPES Non-standard shapes available. See pages 136-142.



HPX® 1-1/4" B STATION REPLACEMENT PARTS



	DESCRIPTION	CAT. NO.
1	Dowel Pin (.187" x .345")	6431
2	Die	See Opposite Page
3	Stripper	See Opposite Page
4	Ball Plunger	980974
5	Guide	See Opposite Page
6	Dowel Pin (.125" x .312")	970651
7	Punch	See Opposite Page
8	Punch Pin	24097
9	Dowel Pin (.187" x .500")	2131
10	Punch Holder	14929
11	Spring Pack	14367

1-1/4" B

WILSON STYLE

EXP® 1/2" A STATION — WILSON STYLE

1/2" A WILSON STYLE



HP & HP2 PUNCH HOLDER		
Compatible with HP and HP2 Punch and Guide Assemblies		
CAT. NO.	PRICE	
Round	14897	
Shape	14895	

HP & HP2 ABS PUNCH HOLDER		
Compatible with HP and HP2 Punch and Guide Assemblies		
CAT. NO.	PRICE	
Round	14893	
Shape	14891	

STANDARD PUNCH HOLDER		
Compatible with Wilson Basix Punch and Guide Assemblies		
CAT. NO.	PRICE	
Round	14901	
Shape	14899	

ULTRA PUNCH HOLDER		
Compatible with Ultra Punch and Guide Assemblies		
CAT. NO.	PRICE	
Ultra	15575	

Ultra is a trademark of Mate Precision Technologies.



Scan QR Code to Explore More EXP®



EXP® PUNCH		
Compatible with all punch holders above		
EXP® PUNCH	CAT. NO.	PRICE
Round	13904	
Shape	13905	
Optima® Coating	—	

EXP® Punch Grinding Fixture

Fixture for sharpening A and B Station EXP® punches with our innovative XSharp™ Grinder.

CAT. NO.	PRICE
6990	



DESCRIPTION	A DIMENSION	MAX. MATERIAL THICKNESS	NOTES
EXP® punch holders allow you to convert your current Wilson Style punch and guide assemblies to the EXP quick change punch system. All EXP punches are Ultima® premium tool steel.	.500" [12.7mm] 	.150" [3.81mm] 	Additional charges may apply to non-standard features. See page 156.

STANDARD SHAPES Non-standard shapes available. See pages 136-142.



EXP® 1-1/4" B STATION – WILSON STYLE



HP & HP2 PUNCH HOLDER		
Compatible with HP and HP2 Punch and Guide Assemblies		
CAT. NO.	PRICE	
Round	14919	
Shape	14917	

HP & HP2 ABS PUNCH HOLDER		
Compatible with HP and HP2 Punch and Guide Assemblies		
CAT. NO.	PRICE	
Round	14915	
Shape	14913	

STANDARD PUNCH HOLDER		
Compatible with Wilson Basix Punch and Guide Assemblies		
CAT. NO.	PRICE	
Round	14923	
Shape	14921	

ULTRA PUNCH HOLDER		
Compatible with Ultra Punch and Guide Assemblies		
CAT. NO.	PRICE	
Ultra	15577	

Ultra is a trademark of Mate Precision Technologies.



Scan QR Code to Explore More EXP®



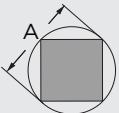
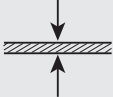
EXP® PUNCH		
Compatible with all punch holders above		
EXP® PUNCH	CAT. NO.	PRICE
Round	13916	
Shape	13917	
Optima® Coating	—	

EXP® Punch Grinding Fixture

Fixture for sharpening A and B Station EXP® punches with our innovative XSharp™ Grinder.

CAT. NO.	PRICE
6990	



DESCRIPTION	A DIMENSION	MAX. MATERIAL THICKNESS	NOTES
EXP® punch holders allow you to convert your current Wilson Style punch and guide assemblies to the EXP quick change punch system. All punches are Ultima® premium tool steel.	1.250" [31.8mm] 	.250" [6.35mm] 	Additional charges may apply to non-standard features. See page 156.

STANDARD SHAPES Non-standard shapes available. See pages 136-142.



HP2 & HP 1/2" A STATION – WILSON STYLE

WILSON STYLE 1/2" A



HP2 PUNCH AND GUIDE ASSEMBLY	CAT. NO.	PRICE	ABS	
			CAT. NO.	PRICE
Round	13767		13770	
Shape	13769		13772	
Optima® Coating	—		—	
Spring Pack Assembly	14150		14150	
HP PUNCH AND GUIDE ASSEMBLY	CAT. NO.	PRICE	CAT. NO.	PRICE
Round	12781		12793	
Shape	13137		13146	
Optima® Coating	—		—	
Spring Pack Assembly	2747		2747	
PUNCH (ABS SHOWN)	CAT. NO.	PRICE	CAT. NO.	PRICE
Round	2405		2385	
Shape	2406		2389	
Optima® Coating	—		—	
GUIDE	CAT. NO.	PRICE	CAT. NO.	PRICE
Round	2821		2835	
Shape 0°	2822		2836	
Shape 0°, & 45°	2903		2907	
Shape 0° & 90° (Option add 180° & 270°)	2904		2908	
STRIPPER	CAT. NO.	PRICE	CAT. NO.	PRICE
Round	13044		13045	
Shape	13143		13152	
DIE	CAT. NO.	PRICE		
Round Slug Hugger**	2192			
Round Standard	1808			
Shape Slug Hugger® 2*	12959			
Shape Positive	1817			
Shape Negative	1818			
DIE SHIM	CAT. NO.	PRICE		
.010" [0.25mm] Pack of 25	2208			
.030" [0.76mm] Pack of 25	2722			
.060" [1.5mm] Pack of 25	2172			

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

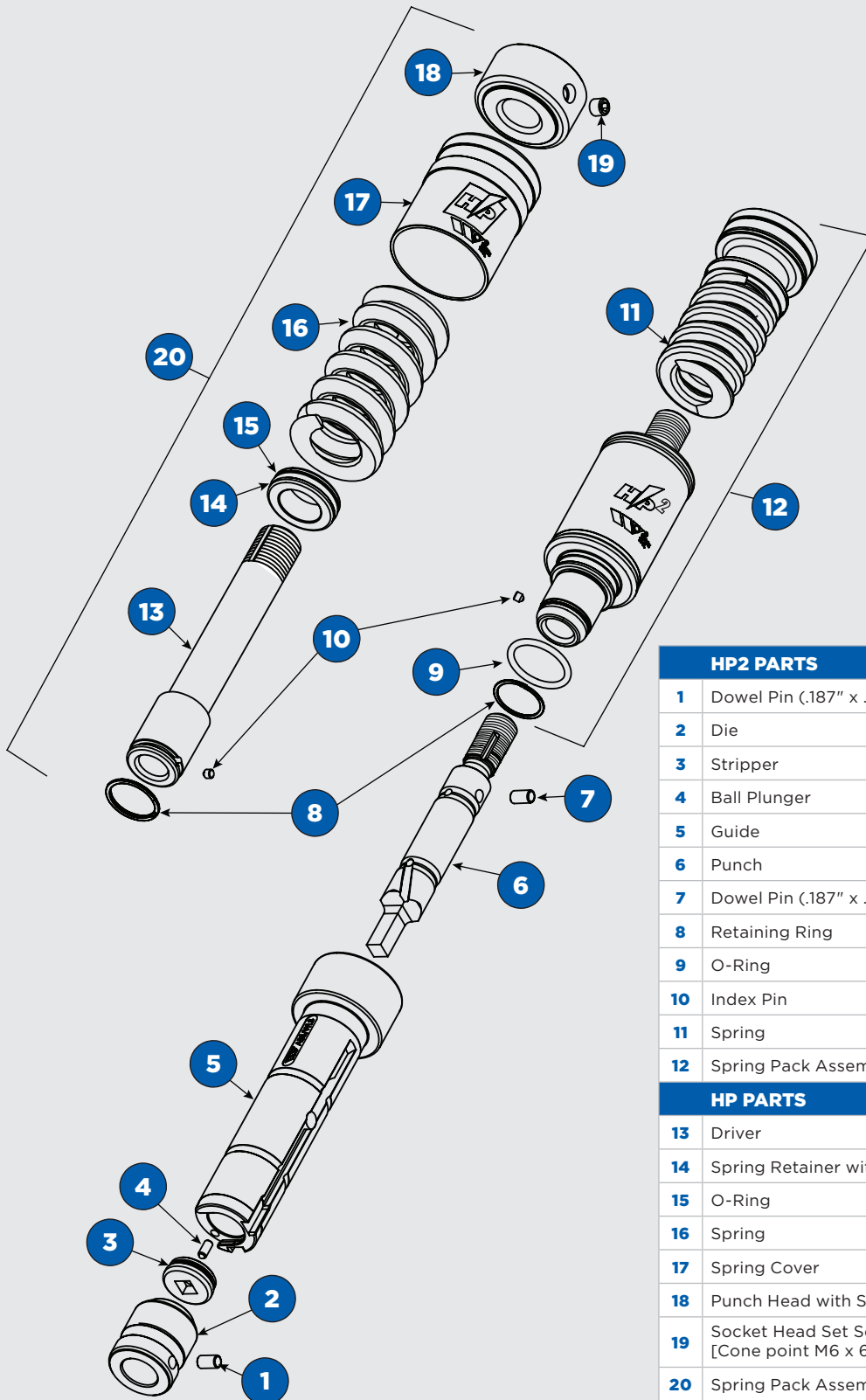
Additional charges may apply to non-standard features. See page 156.

DESCRIPTION	A DIMENSION	MAX. MATERIAL THICKNESS	NOTES
HP2 is Wilson Tool's "Better" product. It offers great value with standard features like, easy click length adjustment, high grade tool steel, and is available in ABS.	.500" [12.7mm] 	.150" [3.81mm] 	HP punches and dies are available in Ultima® premium tool steel upon request.

STANDARD SHAPES Non-standard shapes available. See pages 136-142.



HP2 & HP 1/2" Ⓐ STATION REPLACEMENT PARTS



HP2 PARTS		CAT. NO.
1	Dowel Pin (.187" x .312")	6013
2	Die	See Opposite Page
3	Stripper	See Opposite Page
4	Ball Plunger	980973
5	Guide	See Opposite Page
6	Punch	See Opposite Page
7	Dowel Pin (.187" x .312")	6013
8	Retaining Ring	6853
9	O-Ring	2282
10	Index Pin	6873
11	Spring	24291
12	Spring Pack Assembly	14150
HP PARTS		CAT. NO.
13	Driver	2388
14	Spring Retainer with O-Ring	1804
15	O-Ring	2282
16	Spring	1803
17	Spring Cover	13052
18	Punch Head with Set Screw	2780
19	Socket Head Set Screw [Cone point M6 x 6mm]	6297
20	Spring Pack Assembly	2747

1/2" Ⓐ

WILSON
STYLE

HP2 & HP 1-1/4" Ⓑ STATION – WILSON STYLE

WILSON STYLE 1-1/4" Ⓑ



HP2 PUNCH AND GUIDE ASSEMBLY



PUNCH (ABS shown)



GUIDE



HP SPRING PACK ASSEMBLY



STRIPPER



DIE



SHIM

HP2 PUNCH AND GUIDE ASSEMBLY	CAT. NO.	PRICE	ABS	
			CAT. NO.	PRICE
Round	13779		13782	
Shape	13781		13784	
Optima® Coating	—		—	
Spring Pack Assembly	14149		14149	
HP PUNCH AND GUIDE ASSEMBLY	CAT. NO.	PRICE	CAT. NO.	PRICE
Round	12827		12831	
Shape	13167		13170	
Optima® Coating	—		—	
Spring Pack Assembly	2749		2749	
PUNCH (ABS SHOWN)	CAT. NO.	PRICE	CAT. NO.	PRICE
Round	2407		2398	
Shape	2408		2399	
Optima® Coating	—		—	
GUIDE	CAT. NO.	PRICE	CAT. NO.	PRICE
Round	2859		2881	
Shape 0°	2860		2882	
Shape 0°, & 45°	2861		2883	
Shape 0° & 90° (Option add 180° & 270°)	2862		2884	
STRIPPER	CAT. NO.	PRICE	CAT. NO.	PRICE
Round	1890		2433	
Shape	1917		2432	
DIE	CAT. NO.	PRICE		
Round Slug Hugger**	2194			
Round Standard	2021			
Shape Slug Hugger® 2*	12961			
Shape Positive	2025			
Shape Negative	2026			
DIE SHIM	CAT. NO.	PRICE		
.010" [0.25mm] Pack of 25	2209			
.030" [0.76mm] Pack of 25	2724			
.060" [1.5mm] Pack of 25	2173			

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

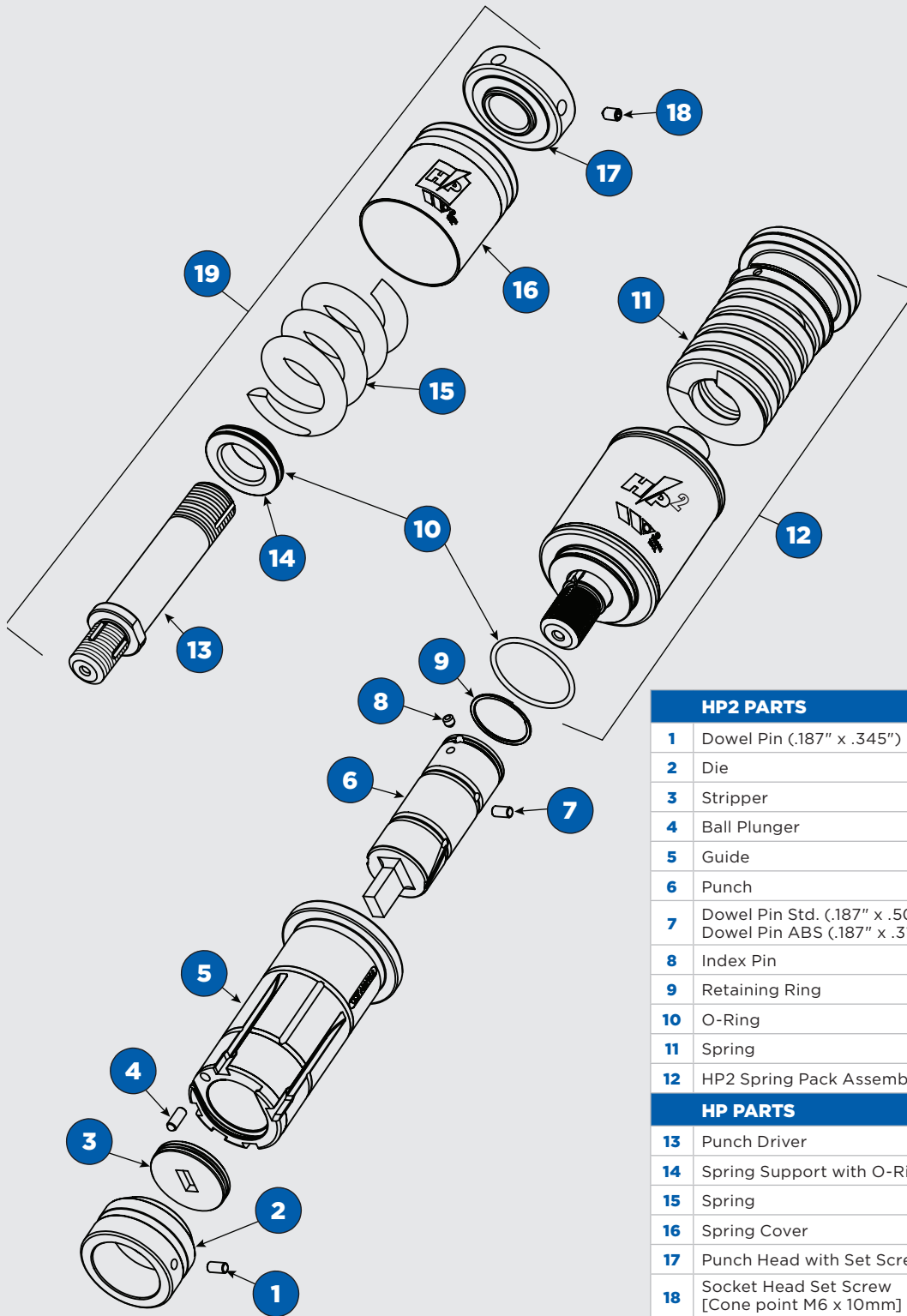
Additional charges may apply to non-standard features. See page 156.

DESCRIPTION	A DIMENSION	MAX. MATERIAL THICKNESS	NOTES
HP2 is Wilson Tool's "Better" product. It offers great value with standard features like, easy click length adjustment, high grade tool steel, and is available in ABS.	1.250" [31.8mm] 	.250" [6.35mm] 	HP punches and dies are available in Ultima® premium tool steel upon request.

STANDARD SHAPES Non-standard shapes available. See pages 136-142.



HP2 & HP 1-1/4" Ⓑ STATION REPLACEMENT PARTS



HP2 PARTS		CAT. NO.
1	Dowel Pin (.187" x .345")	6431
2	Die	See Opposite Page
3	Stripper	See Opposite Page
4	Ball Plunger	980974
5	Guide	See Opposite Page
6	Punch	See Opposite Page
7	Dowel Pin Std. (.187" x .500") Dowel Pin ABS (.187" x .312")	2131 6013
8	Index Pin	6874
9	Retaining Ring	2803
10	O-Ring	2283
11	Spring	00030
12	HP2 Spring Pack Assembly	14149
HP PARTS		CAT. NO.
13	Punch Driver	13556
14	Spring Support with O-Ring	1824
15	Spring	1953
16	Spring Cover	13053
17	Punch Head with Set Screw	2781
18	Socket Head Set Screw [Cone point M6 x 10mm]	6206
19	HP Spring Pack Assembly	2749

1-1/4" Ⓑ

WILSON STYLE

HP 1/2" Ⓐ STATION HEAVY DUTY – WILSON STYLE

1/2" Ⓐ WILSON STYLE



HP PUNCH AND GUIDE ASSEMBLY	CAT. NO.	PRICE	ABS	
			CAT. NO.	PRICE
Round	12857		12861	
Shape	13182		13185	
Optima® Coating	—		—	
PUNCH (ABS SHOWN)	CAT. NO.	PRICE	CAT. NO.	PRICE
Round	2405		2385	
Shape	2406		2389	
Optima® Coating	—		—	
GUIDE	CAT. NO.	PRICE	CAT. NO.	PRICE
Round	2821		2835	
Shape 0°	2822		2836	
Shape 0°, & 45°	2903		2907	
Shape 0° & 90° (Option add 180° & 270°)	2904		2908	
STRIPPER	CAT. NO.	PRICE	CAT. NO.	PRICE
Round	13044		13045	
Shape	13143		13152	
DIE	CAT. NO.	PRICE		
Round Slug Hugger®*	2192			
Round Standard	1808			
Shape Slug Hugger® 2*	12959			
Shape Positive	1817			
Shape Negative	1818			
DIE SHIM	CAT. NO.	PRICE		
.010" [0.25mm] Pack of 25	2208			
.030" [0.76mm] Pack of 25	2722			
.060" [1.5mm] Pack of 25	2172			

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

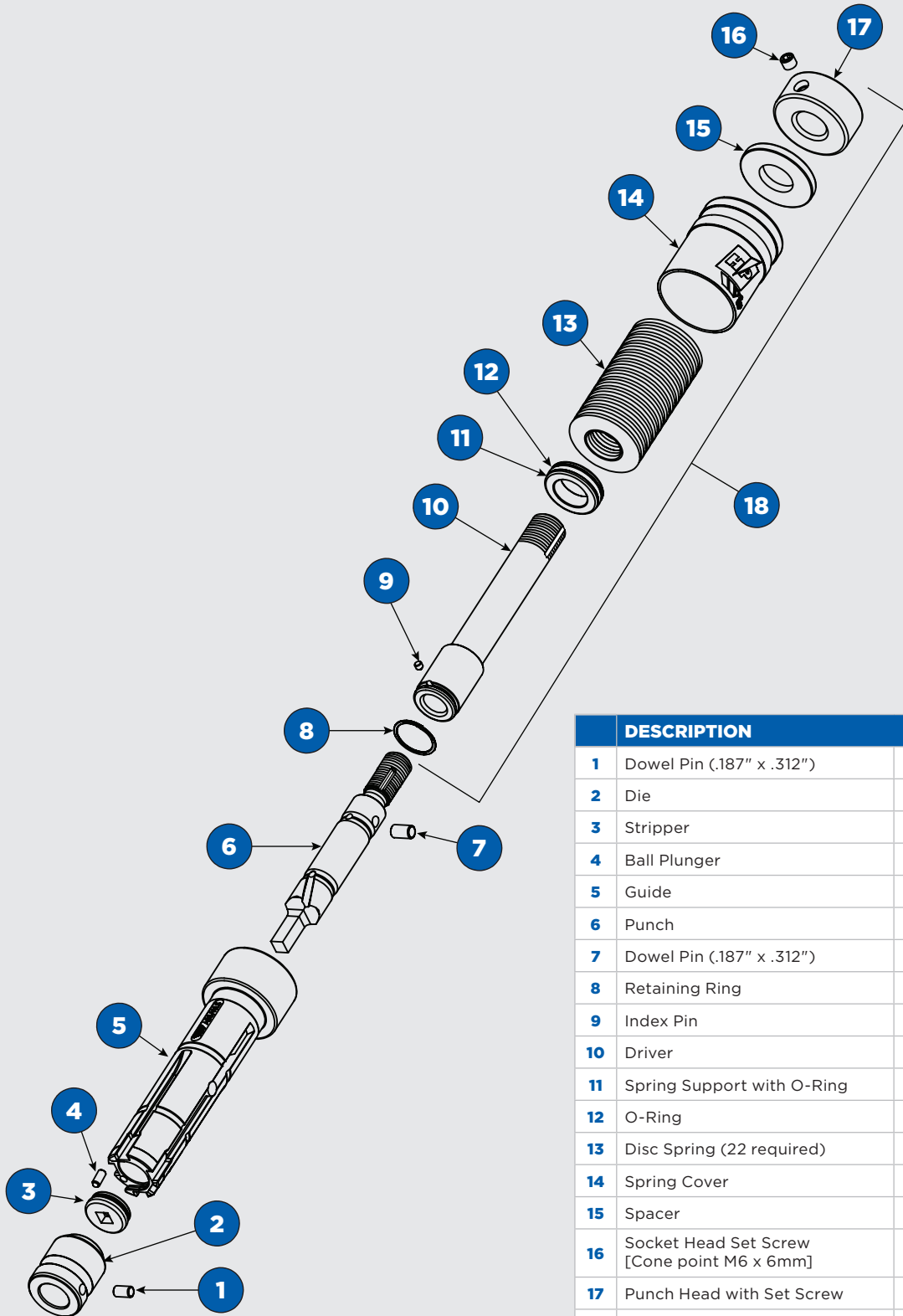
Additional charges may apply to non-standard features. See page 156.

DESCRIPTION	A DIMENSION	MAX. MATERIAL THICKNESS	NOTES
HP heavy duty tooling assemblies are designed to deliver the best performance when punching thicker materials up to .250" [6.35mm].	.500" [12.7mm] 	.250" [6.35mm] 	HP punches and dies are available in Ultima® premium tool steel upon request.

STANDARD SHAPES Non-standard shapes available. See pages 136-142.



HP 1/2" Ⓐ STATION HEAVY DUTY REPLACEMENT PARTS



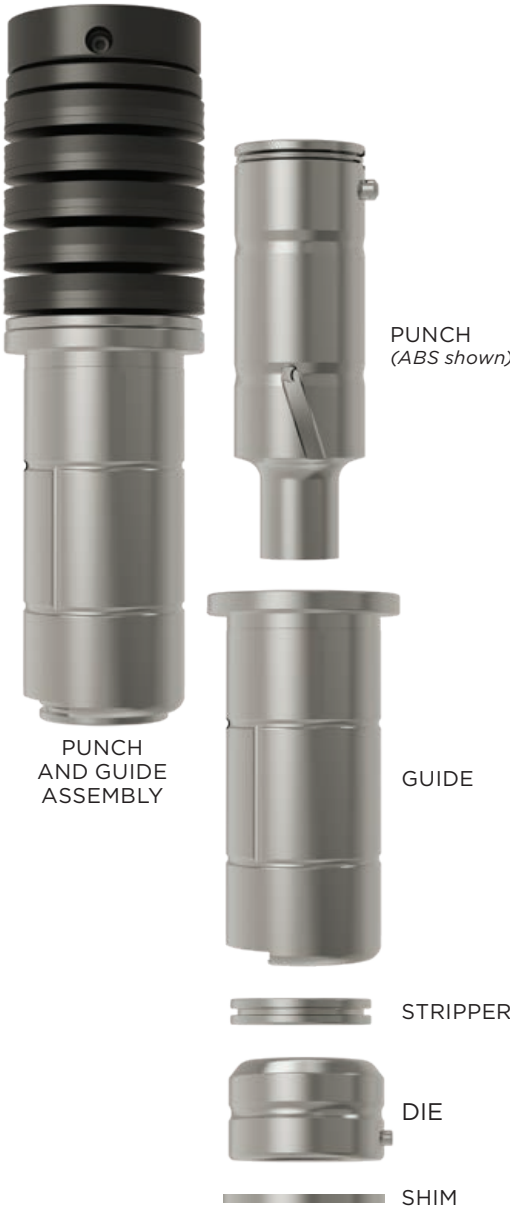
	DESCRIPTION	CAT. NO.
1	Dowel Pin (.187" x .312")	6013
2	Die	See Opposite Page
3	Stripper	See Opposite Page
4	Ball Plunger	980973
5	Guide	See Opposite Page
6	Punch	See Opposite Page
7	Dowel Pin (.187" x .312")	6013
8	Retaining Ring	6853
9	Index Pin	6873
10	Driver	2388
11	Spring Support with O-Ring	2295
12	O-Ring	2282
13	Disc Spring (22 required)	2297
14	Spring Cover	13052
15	Spacer	2296
16	Socket Head Set Screw [Cone point M6 x 6mm]	6297
17	Punch Head with Set Screw	2788
18	Spring Pack Assembly	2477

1/2" Ⓐ

WILSON
STYLE

HP 1-1/4" Ⓑ STATION HEAVY DUTY – WILSON STYLE

WILSON STYLE 1-1/4" Ⓑ



HP PUNCH AND GUIDE ASSEMBLY	CAT. NO.	PRICE	ABS	
			CAT. NO.	PRICE
Round	12873		12877	
Shape	13194		13197	
Optima® Coating	–		–	
PUNCH (ABS SHOWN)	CAT. NO.	PRICE	CAT. NO.	PRICE
Round	2407		2398	
Shape	2408		2399	
Optima® Coating	–		–	
GUIDE	CAT. NO.	PRICE	CAT. NO.	PRICE
Round	2859		2881	
Shape 0°	2860			
Shape 0°, & 45°	2861		2883	
Shape 0° & 90° (Option add 180° & 270°)	2862		2884	
STRIPPER	CAT. NO.	PRICE	CAT. NO.	PRICE
Round	1890		2433	
Shape	1917		2432	
DIE	CAT. NO.	PRICE		
Round Slug Hugger®*	2194			
Round Standard	2021			
Shape Slug Hugger® 2*	12961			
Shape Positive	2025			
Shape Negative	2026			
DIE SHIM	CAT. NO.	PRICE		
.010" [0.25mm] Pack of 25	2209			
.030" [0.76mm] Pack of 25	2724			
.060" [1.5mm] Pack of 25	2173			

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

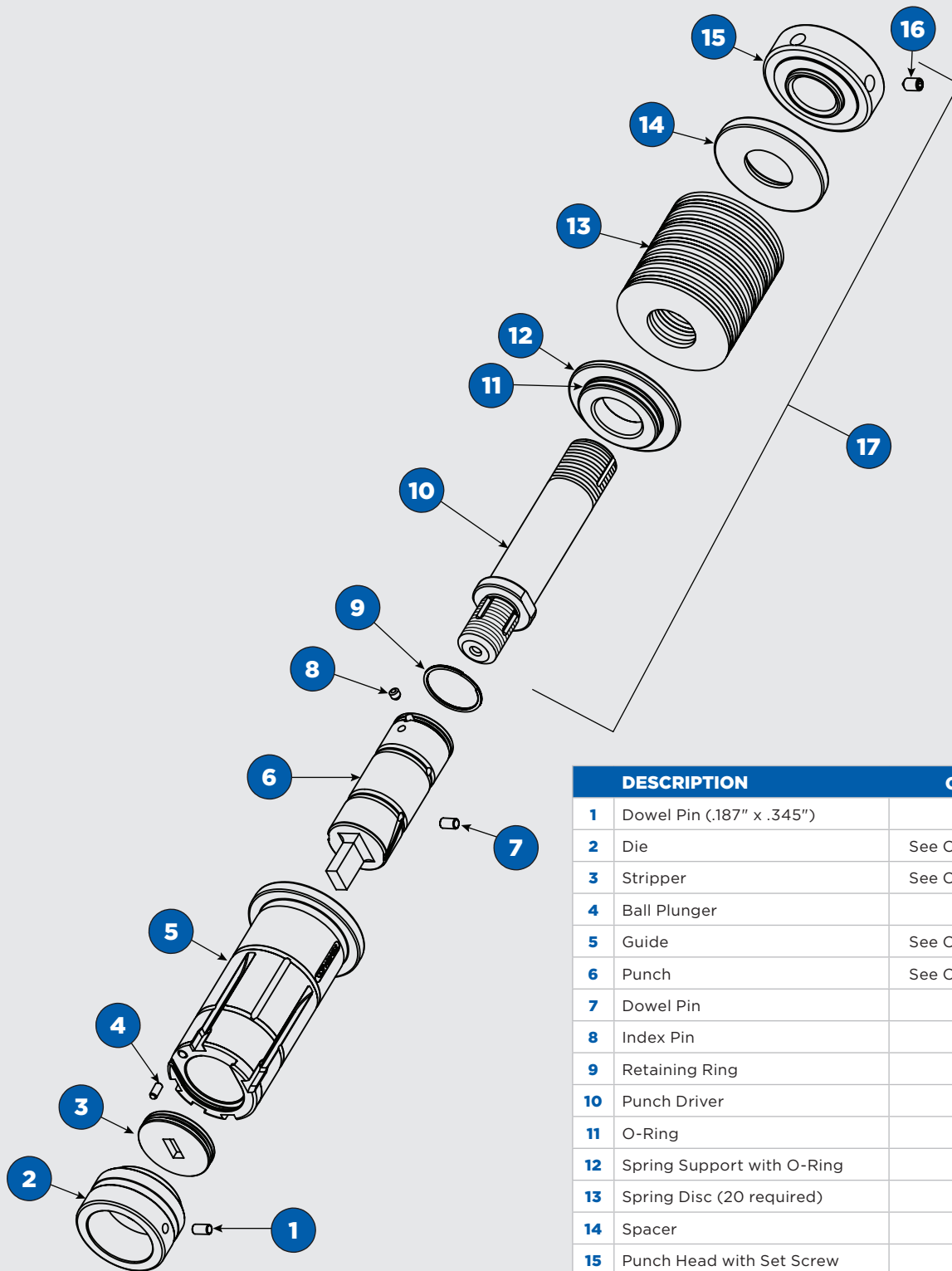
Additional charges may apply to non-standard features. See page 156.

DESCRIPTION	A DIMENSION	MAX. MATERIAL THICKNESS	NOTES
HP heavy duty tooling assemblies are designed to deliver the best performance when punching thicker materials up to .312" [7.93mm].	1.250" [31.8mm] 	.312" [7.93mm] 	HP punches and dies are available in Ultima® premium tool steel upon request.

STANDARD SHAPES Non-standard shapes available. See pages 136-142.



HP 1-1/4" (B) STATION HEAVY DUTY REPLACEMENT PARTS



DESCRIPTION	CAT. NO.
1 Dowel Pin (.187" x .345")	6431
2 Die	See Opposite Page
3 Stripper	See Opposite Page
4 Ball Plunger	980974
5 Guide	See Opposite Page
6 Punch	See Opposite Page
7 Dowel Pin	2131
8 Index Pin	6874
9 Retaining Ring	2803
10 Punch Driver	13556
11 O-Ring	2283
12 Spring Support with O-Ring	2435
13 Spring Disc (20 required)	2302
14 Spacer	2434
15 Punch Head with Set Screw	2781
16 Socket Head Set Screw [Cone point M6 x 10mm]	6206
17 Spring Pack Assembly	2750

1-1/4" (B)

WILSON STYLE

BASIX 1/2" A STATION – WILSON STYLE

WILSON STYLE 1/2" A



PUNCH AND GUIDE ASSEMBLY	CAT. NO.	PRICE
Round	13453	
Shape	13455	
Optima® Coating	—	
PUNCH	CAT. NO.	PRICE
Round	1807	
Shape	1816	
Optima® Coating	—	
GUIDE	CAT. NO.	PRICE
Round	2821	
Shape 0°	2822	
Shape 0° & 45°	2903	
Shape 0° & 90° (Option add 180° & 270°)	2904	
STRIPPER	CAT. NO.	PRICE
Round	13044	
Shape	13143	
DIE	CAT. NO.	PRICE
Round Slug Hugger**	2192	
Round Standard	1808	
Shape Slug Hugger* 2*	12959	
Shape Positive	1817	
Shape Negative	1818	

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

PUNCH SHIM	CAT. NO.	PRICE
.060" [1.5mm] Pack of 25	2167	
DIE SHIM	CAT. NO.	PRICE
.010" [0.25mm] Pack of 25	2208	
.030" [0.76mm] Pack of 25	2722	
.060" [1.5mm] Pack of 25	2172	

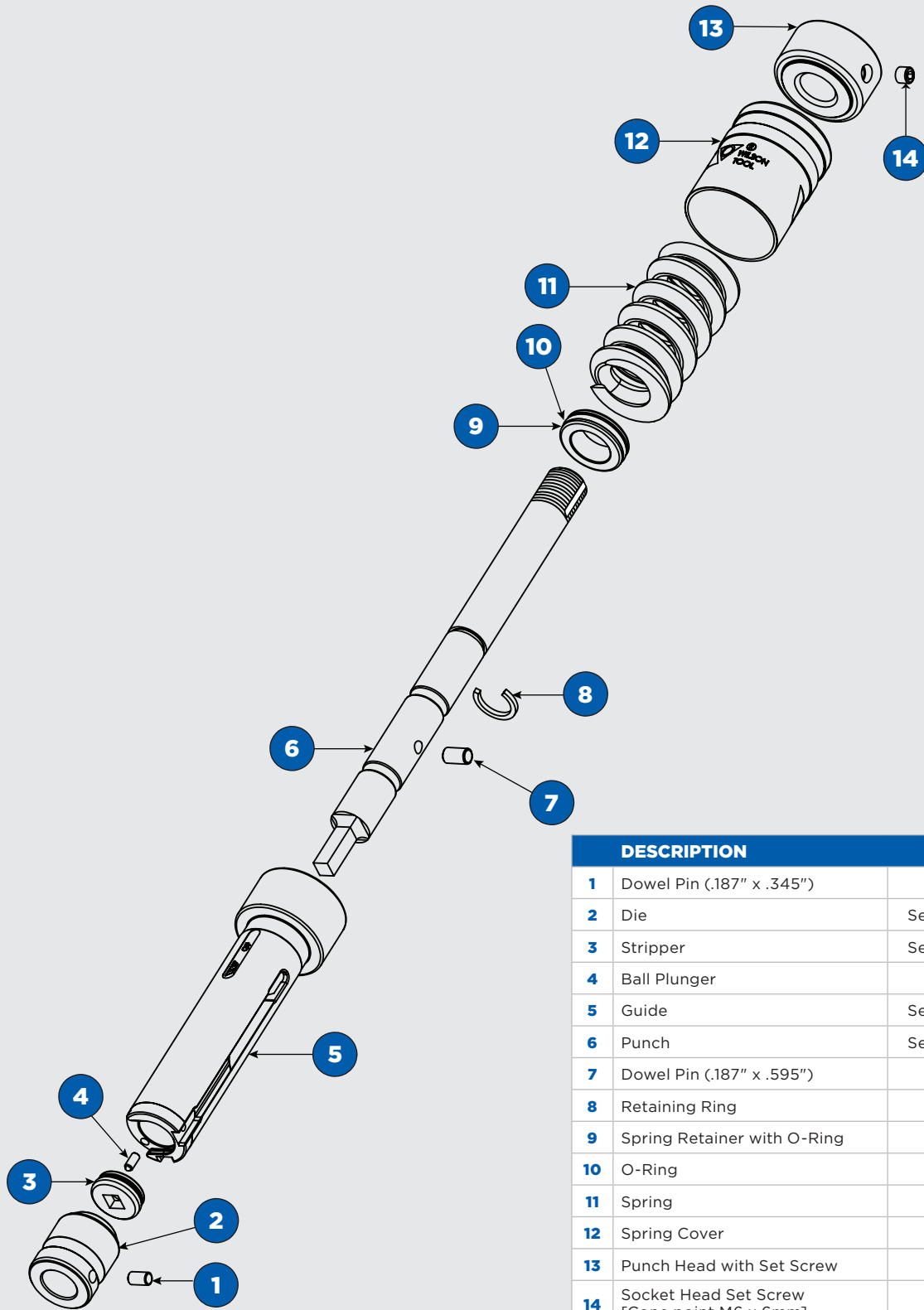
Additional charges may apply to non-standard features. See page 156.

DESCRIPTION	A DIMENSION	MAX. MATERIAL THICKNESS	NOTES
Basix assemblies are designed to deliver durability and performance at a lower cost with basic features.	.500" [12.7mm] 	.150" [3.81mm] 	Dies are available in Ultima® premium tool steel upon request.

STANDARD SHAPES Non-standard shapes available. See pages 136-142.



BASIX 1/2" A STATION REPLACEMENT PARTS



	DESCRIPTION	CAT. NO.
1	Dowel Pin (.187" x .345")	6431
2	Die	See Opposite Page
3	Stripper	See Opposite Page
4	Ball Plunger	980973
5	Guide	See Opposite Page
6	Punch	See Opposite Page
7	Dowel Pin (.187" x .595")	6015
8	Retaining Ring	1805
9	Spring Retainer with O-Ring	1804
10	O-Ring	2282
11	Spring	1803
12	Spring Cover	2731
13	Punch Head with Set Screw	2780
14	Socket Head Set Screw [Cone point M6 x 6mm]	6297

1/2" A

WILSON STYLE

BASIX 1-1/4" ⓑ STATION – WILSON STYLE

WILSON STYLE 1-1/4" ⓑ



PUNCH AND GUIDE ASSEMBLY	CAT. NO.	PRICE
Round	2851	
Shape	2853	
Optima® Coating	—	
PUNCH	CAT. NO.	PRICE
Round	1827	
Shape	1839	
Optima® Coating	—	
GUIDE	CAT. NO.	PRICE
Round	2859	
Shape 0°	2860	
Shape 0° & 45°	2861	
Shape 0° & 90° (Option add 180° & 270°)	2862	
STRIPPER	CAT. NO.	PRICE
Round	1890	
Shape	1917	
DIE	CAT. NO.	PRICE
Round Slug Hugger**	2194	
Round Standard	2021	
Shape Slug Hugger® 2*	12961	
Shape Positive	2025	
Shape Negative	2026	

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

PUNCH SHIM	CAT. NO.	PRICE
.060" [1.5mm] Pack of 25	2168	
DIE SHIM	CAT. NO.	PRICE
.010" [0.25mm] Pack of 25	2209	
.030" [0.76mm] Pack of 25	2724	
.060" [1.5mm] Pack of 25	2173	

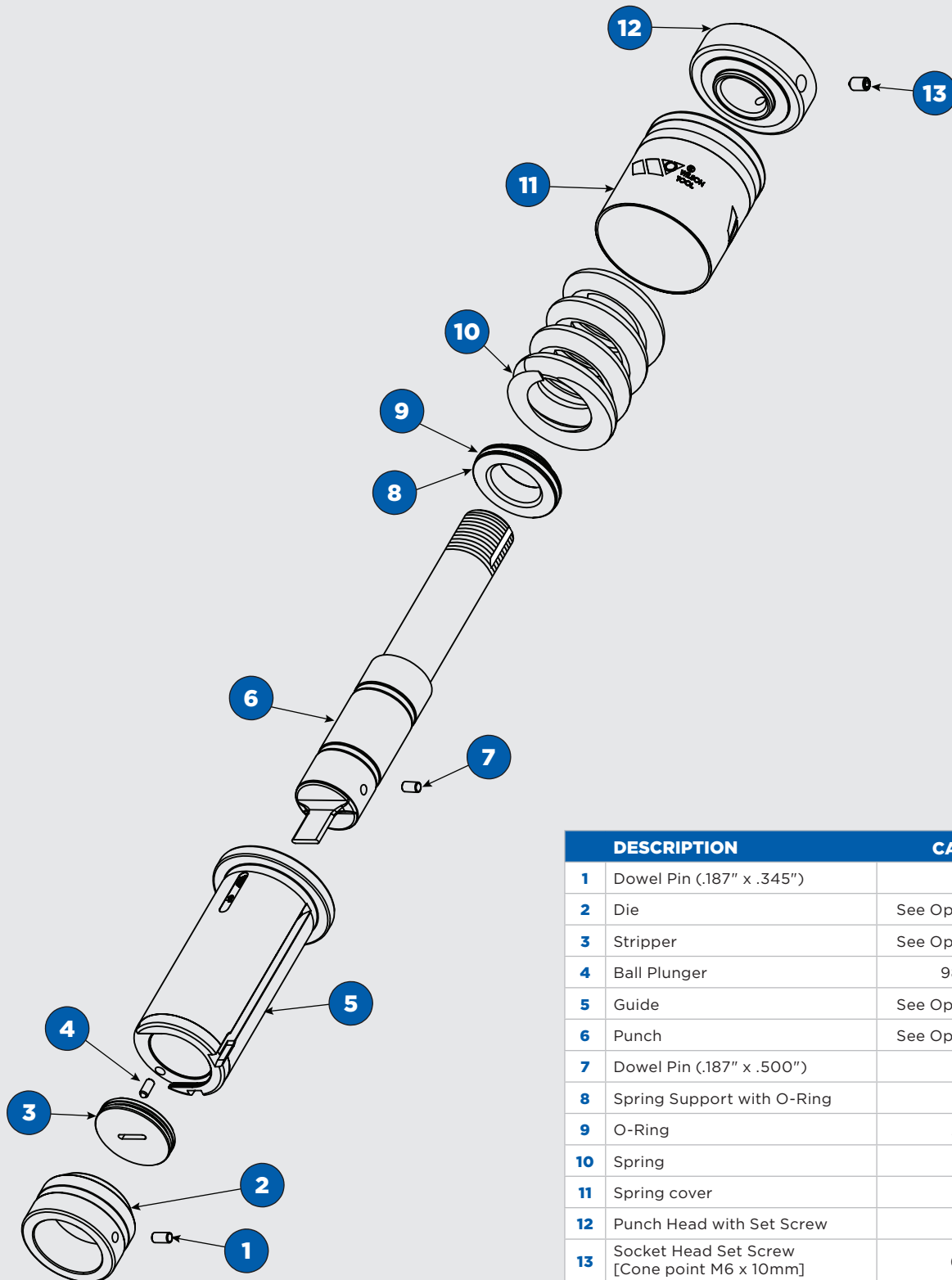
Additional charges may apply to non-standard features. See page 156.

DESCRIPTION	A DIMENSION	MAX. MATERIAL THICKNESS	NOTES
Basix assemblies are designed to deliver durability and performance at a lower cost with basic features.	1.250" [31.8mm] 	.250" [6.35mm] 	Dies are available in Ultima® premium tool steel upon request.

STANDARD SHAPES Non-standard shapes available. See pages 136-142.



BASIX 1-1/4" Ⓑ STATION REPLACEMENT PARTS



	DESCRIPTION	CAT. NO.
1	Dowel Pin (.187" x .345")	6431
2	Die	See Opposite Page
3	Stripper	See Opposite Page
4	Ball Plunger	980974
5	Guide	See Opposite Page
6	Punch	See Opposite Page
7	Dowel Pin (.187" x .500")	2131
8	Spring Support with O-Ring	1824
9	O-Ring	2283
10	Spring	1953
11	Spring cover	2732
12	Punch Head with Set Screw	2781
13	Socket Head Set Screw [Cone point M6 x 10mm]	6206

1-1/4" Ⓑ

WILSON STYLE

BASIX 1/2" A STATION HEAVY DUTY – WILSON STYLE

WILSON STYLE 1/2" A



PUNCH AND GUIDE ASSEMBLY	CAT. NO.	PRICE
Round	13514	
Shape	13516	
Optima® Coating	—	
PUNCH	CAT. NO.	PRICE
Round	2303	
Shape	2304	
Optima® Coating	—	
GUIDE	CAT. NO.	PRICE
Round	2821	
Shape 0°	2822	
Shape 0° & 45°	2903	
Shape 0° & 90° (Option add 180° & 270°)	2904	
STRIPPER	CAT. NO.	PRICE
Round	13044	
Shape	13143	
DIE	CAT. NO.	PRICE
Round Slug Hugger**	2192	
Round Standard	1808	
Shape Slug Hugger* 2*	12959	
Shape Positive	1817	
Shape Negative	1818	

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

PUNCH SHIM	CAT. NO.	PRICE
.060" [1.5mm] Pack of 25	2167	
DIE SHIM	CAT. NO.	PRICE
.010" [0.25mm] Pack of 25	2208	
.030" [0.76mm] Pack of 25	2722	
.060" [1.5mm] Pack of 25	2172	

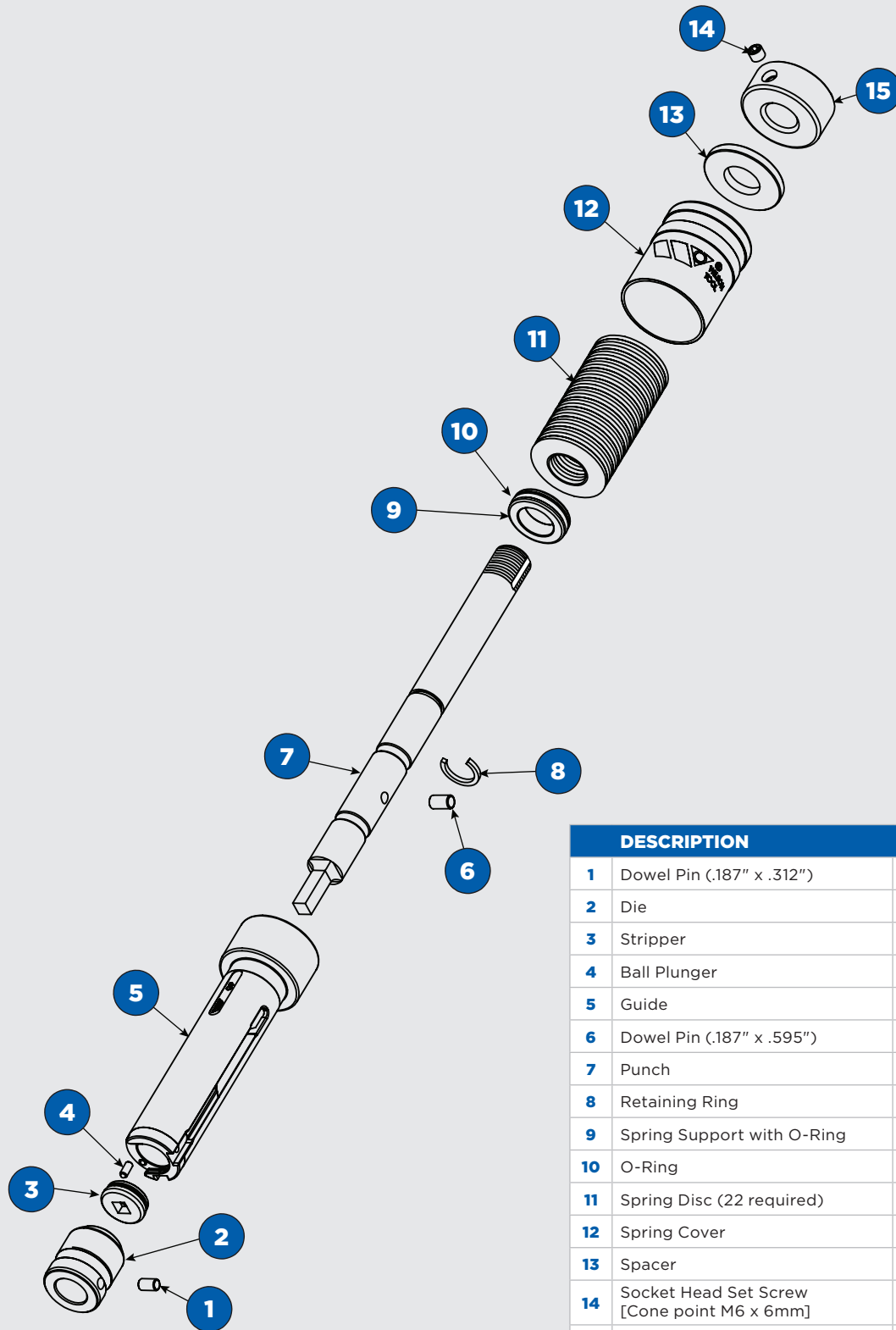
Additional charges may apply to non-standard features. See page 156.

DESCRIPTION	A DIMENSION	MAX. MATERIAL THICKNESS	NOTES
Basix heavy duty assemblies are designed to deliver the best performance when punching thicker materials up to .250" [6.35mm].	.500" [12.7mm] 	.250" [6.35mm] 	Dies are available in Ultima® premium tool steel upon request.

STANDARD SHAPES Non-standard shapes available. See pages 136-142.



BASIX 1/2" A STATION HEAVY DUTY REPLACEMENT PARTS



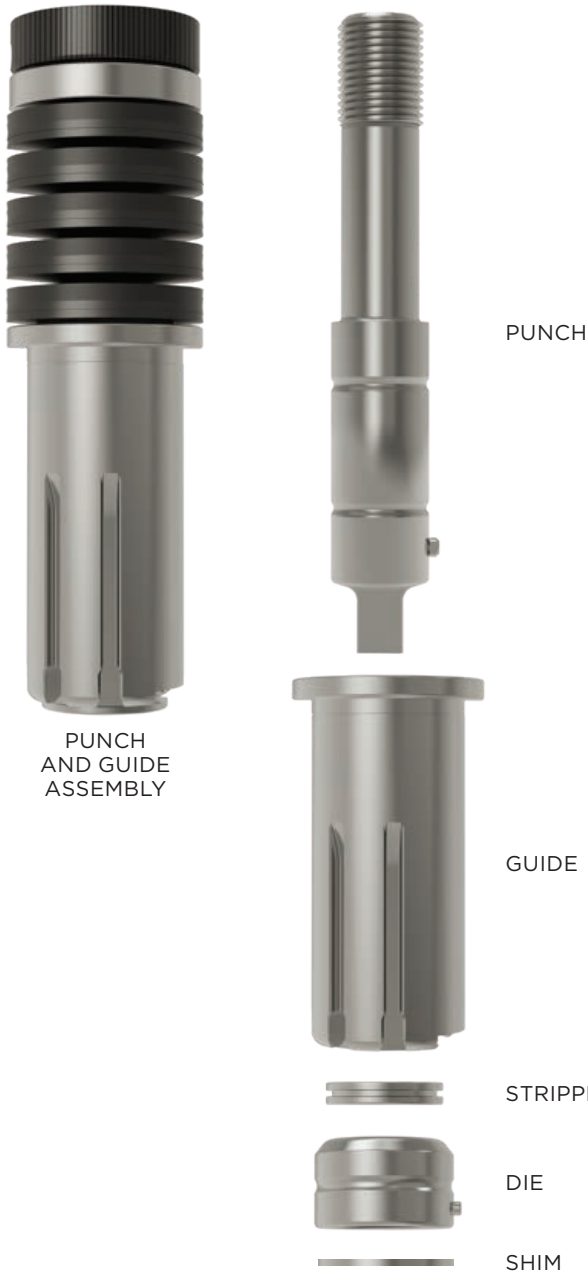
DESCRIPTION	CAT. NO.
1 Dowel Pin (.187" x .312")	6013
2 Die	See Opposite Page
3 Stripper	See Opposite Page
4 Ball Plunger	980973
5 Guide	See Opposite Page
6 Dowel Pin (.187" x .595")	6015
7 Punch	See Opposite Page
8 Retaining Ring	1805
9 Spring Support with O-Ring	2295
10 O-Ring	2282
11 Spring Disc (22 required)	2297
12 Spring Cover	2731
13 Spacer	2296
14 Socket Head Set Screw [Cone point M6 x 6mm]	6297
15 Punch Head with Set Screw	2788

1/2" A

WILSON STYLE

BASIX 1-1/4" Ⓑ STATION HEAVY DUTY – WILSON STYLE

WILSON STYLE 1-1/4" Ⓑ



PUNCH AND GUIDE ASSEMBLY	CAT. NO.	PRICE
Round	13520	
Shape	13522	
Optima® Coating	—	
PUNCH	CAT. NO.	PRICE
Round	2305	
Shape	2306	
Optima® Coating	—	
GUIDE	CAT. NO.	PRICE
Round	2859	
Shape 0°	2860	
Shape 0° & 45°	2861	
Shape 0° & 90° (Option add 180° & 270°)	2862	
STRIPPER	CAT. NO.	PRICE
Round	1890	
Shape	1917	
DIE	CAT. NO.	PRICE
Round Slug Hugger**	2194	
Round Standard	2021	
Shape Slug Hugger* 2*	12961	
Shape Positive	2025	
Shape Negative	2026	

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

PUNCH SHIM	CAT. NO.	PRICE
.060" [1.5mm] Pack of 25	2168	
DIE SHIM	CAT. NO.	PRICE
.010" [0.25mm] Pack of 25	2209	
.030" [0.76mm] Pack of 25	2724	
.060" [1.5mm] Pack of 25	2173	

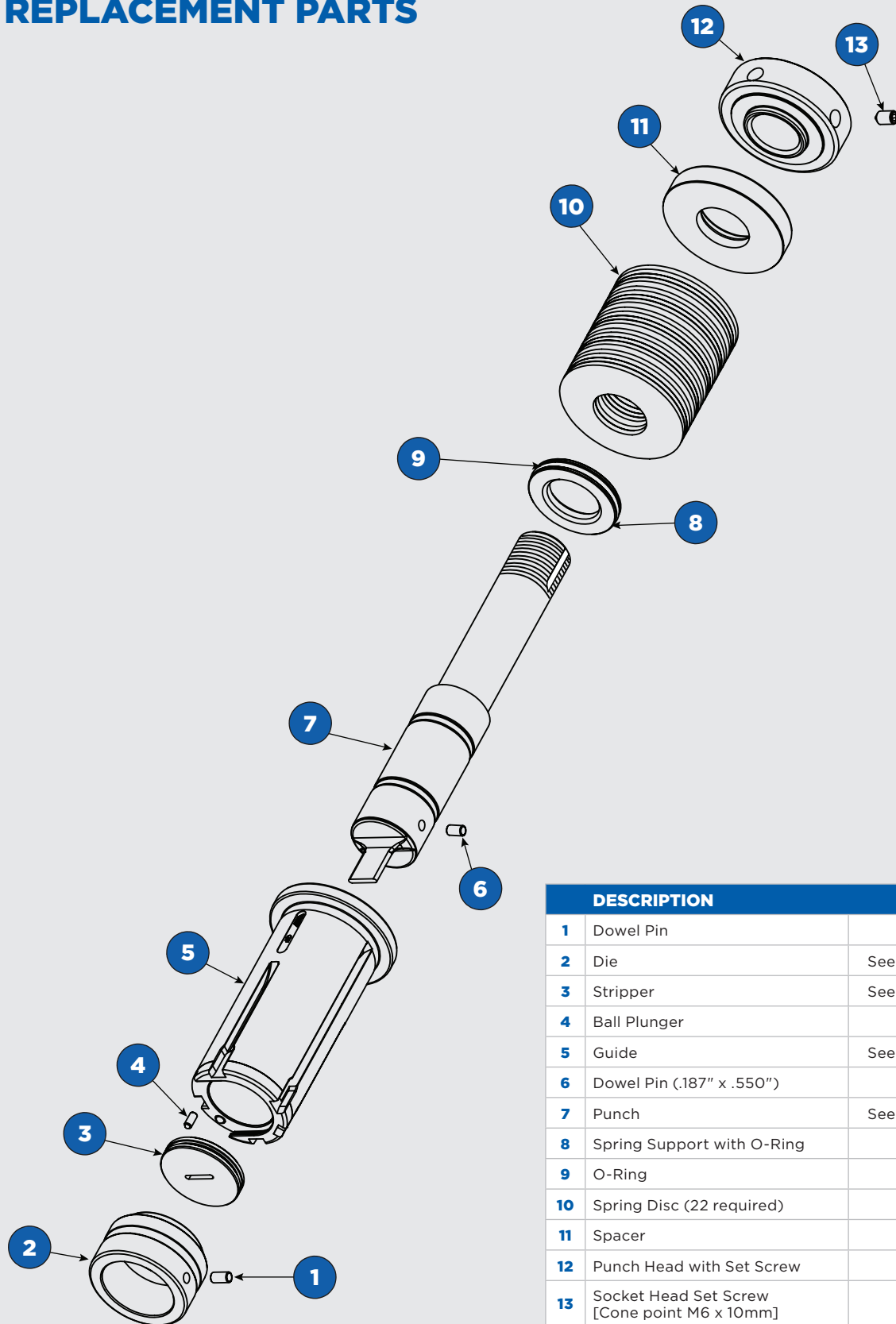
Additional charges may apply to non-standard features. See page 156.

DESCRIPTION	A DIMENSION	MAX. MATERIAL THICKNESS	NOTES
Basix heavy duty assemblies are designed to deliver the best performance when punching thicker materials up to .312" [7.93mm].	1.250" [31.8mm] 	.312" [7.93mm] 	Dies are available in Ultima® premium tool steel upon request.

STANDARD SHAPES Non-standard shapes available. See pages 136-142.



BASIX 1-1/4" Ⓑ STATION HEAVY DUTY REPLACEMENT PARTS



	DESCRIPTION	CAT. NO.
1	Dowel Pin	6431
2	Die	See Opposite Page
3	Stripper	See Opposite Page
4	Ball Plunger	980974
5	Guide	See Opposite Page
6	Dowel Pin (.187" x .550")	2131
7	Punch	See Opposite Page
8	Spring Support with O-Ring	2300
9	O-Ring	2283
10	Spring Disc (22 required)	2302
11	Spacer	2301
12	Punch Head with Set Screw	2781
13	Socket Head Set Screw [Cone point M6 x 10mm]	6206

1-1/4" Ⓑ

WILSON STYLE

WILSON STYLE



THICK TURRET TOOLING SOLUTIONS



LARGE STATION ADVANTAGES
Fast and simple push button length adjustment
Made from hardened tool steel for increased durability
Up to 50% more bearing surface to reduce side loading
Optima® coated keys for superior wear resistance
Internal and external lubrication
ABS machine lubrication capability
External keyways at 0°, 90°, and 135°
Guide assemblies achieve angles of 0°, 45°, 90°, 180°, 225° and 270°
OEM compatible
Punches made from premium hardened tool steel
Optima® coated punches available
Relieved strippers for maximum grind life
Push button lock release for quick stripper plate removal

HP 2" Ⓢ STATION – WILSON STYLE



GUIDE ASSEMBLY

PUNCH

STRIPPER

DIE

SHIM

GUIDE ASSEMBLY	CAT. NO.	PRICE
Assembly	5552	
ABS Assembly	5508	
PUNCH	CAT. NO.	PRICE
Round	5026	
Shape	5025	
Optima® Coating	—	
HEAVY DUTY PUNCH	CAT. NO.	PRICE
Round .500" - 1.250" [12.7mm - 31.75mm]	5117	
Round 1.251" - 1.625" [31.77mm - 41.27mm]	5120	
Shape .500" - 1.250" [12.7mm - 31.75mm]	5118	
Shape 1.251" - 1.625" [31.77mm - 41.27mm]	5119	
STRIPPER	CAT. NO.	PRICE
Round	1848	
Shape	1854	
Round ABS	5150	
Shape ABS	5151	
DIE	CAT. NO.	PRICE
Round Slug Hugger**	2196	
Round Standard	1850	
Shape Slug Hugger* 2*	12964	
Shape Positive	1855	
Shape Negative	1856	

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

DIE SHIM	CAT. NO.	PRICE
.010" [0.25mm] Pack of 10	2210	
.030" [0.76mm] Pack of 10	2726	
.060" [1.5mm] Pack of 10	2174	

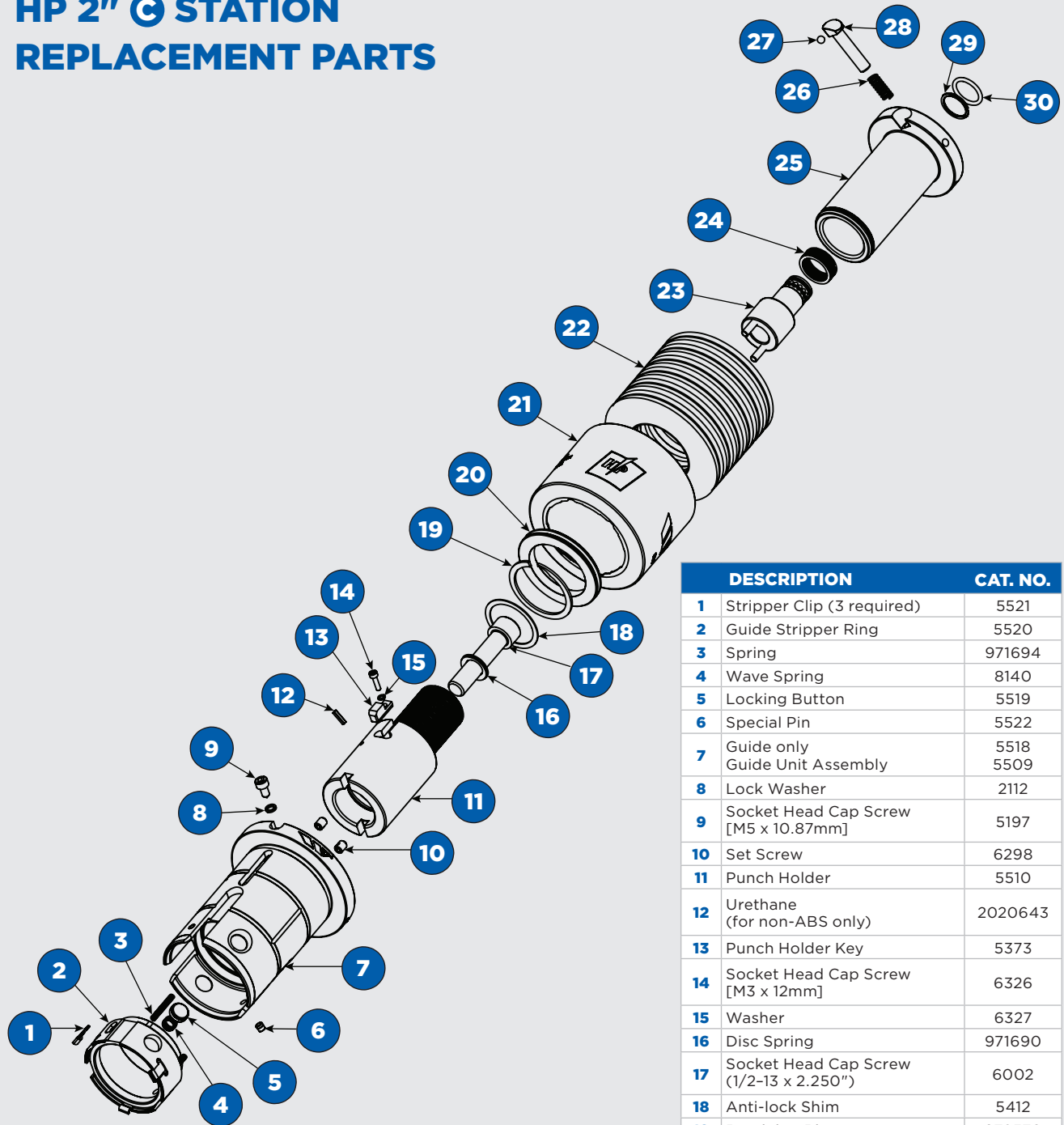
Additional charges may apply to non-standard features. See page 156.

DESCRIPTION	MAX. A DIMENSION	MAX. MATERIAL THICKNESS	NOTES
Guide assemblies achieve angles of 0°, 45°, 90°, 180°, 225°, and 270°.	2.000" [50.8mm] 	.250" [6.35mm] 	<ul style="list-style-type: none"> All punches will be shipped with no shear, unless specified. Use heavy duty punches for material thickness > .250" [6.35mm] or A Dimension < 1.250" [31.75mm]. HP punches and dies are available in Ultima® tool steel upon request.

STANDARD SHAPES Non-standard shapes available. See pages 136-142.



HP 2" © STATION REPLACEMENT PARTS



Cat. No. 5509 Guide Unit Assembly includes:
1, 2, 3, 4, 5, 6, 8, & 9

Cat. No. 5724 Driver Assembly includes:
19, 20, 21, 22, 23, 24, 25, 26, 27, 28, 29 & 30

DESCRIPTION	CAT. NO.
1 Stripper Clip (3 required)	5521
2 Guide Stripper Ring	5520
3 Spring	971694
4 Wave Spring	8140
5 Locking Button	5519
6 Special Pin	5522
7 Guide only Guide Unit Assembly	5518 5509
8 Lock Washer	2112
9 Socket Head Cap Screw [M5 x 10.87mm]	5197
10 Set Screw	6298
11 Punch Holder	5510
12 Urethane (for non-ABS only)	2020643
13 Punch Holder Key	5373
14 Socket Head Cap Screw [M3 x 12mm]	6326
15 Washer	6327
16 Disc Spring	971690
17 Socket Head Cap Screw (1/2-13 x 2.250")	6002
18 Anti-lock Shim	5412
19 Retaining Ring	972570
20 Spring Support	5748
21 Spring Cover	5517
22 Spring Disc (12 required)	5744
23 Adjustment Shaft	5735
24 Wave Spring	971692
25 Punch Driver	5736
26 Spring	972396
27 Adjustment Locking Ball	972420
28 Driver Lock Button	10539
29 Retaining Ring	972441
30 O-Ring (.687" x .094")	972430

HP 3-1/2" ⓓ STATION – WILSON STYLE



GUIDE ASSEMBLY

PUNCH

STRIPPER

DIE

SHIM

GUIDE ASSEMBLY	CAT. NO.	PRICE
Assembly	5553	
ABS Assembly	5523	
PUNCH	CAT. NO.	PRICE
Round	5028	
Shape	5027	
Optima® Coating	—	
STRIPPER	CAT. NO.	PRICE
Round	1864	
Shape	1869	
Round ABS	5152	
Shape ABS	5153	
DIE	CAT. NO.	PRICE
Round Slug Hugger**	2198	
Round Standard	1865	
Shape Slug Hugger® 2*	12965	
Shape Positive	1870	
Shape Negative	1871	

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

DIE SHIM	CAT. NO.	PRICE
.010" [0.25mm] Pack of 5	2211	
.030" [0.76mm] Pack of 5	2728	
.060" [1.5mm] Pack of 5	2175	

Additional charges may apply to non-standard features. See page 156.

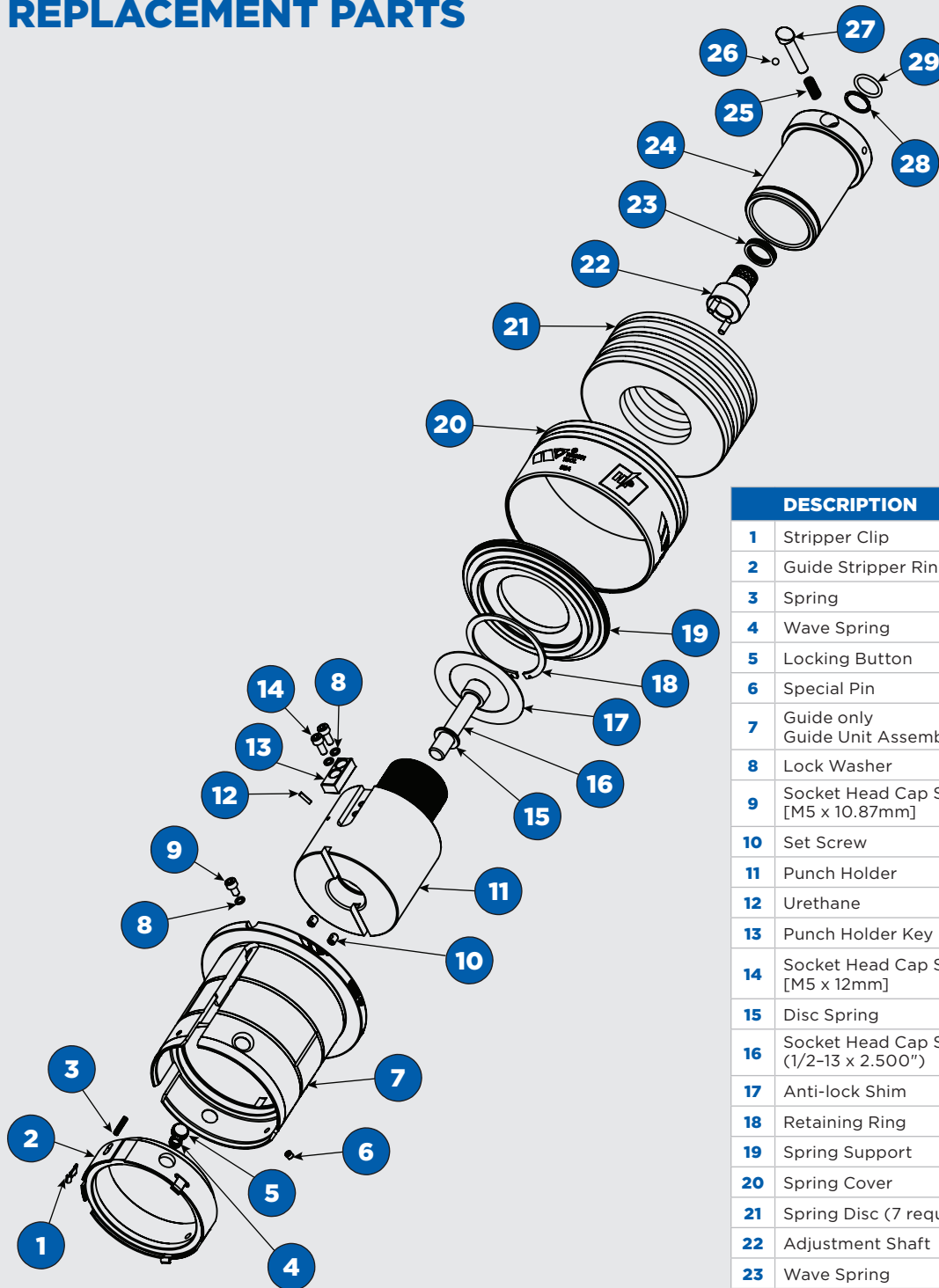
DESCRIPTION	MAX. A DIMENSION	MAX. MATERIAL THICKNESS	NOTES
Guide assemblies achieve angles of 0°, 45°, 90°, 180°, 225°, and 270°.	3.500" [88.9mm] 	.250" [6.35mm] 	<ul style="list-style-type: none"> .062" [1.6mm] rooftop shear is given to all punches with A Dimension > 2.000" [50.8mm] and width > .250" [6.35mm]. Ultima® premium tool steel available for punches and dies.

STANDARD SHAPES Non-standard shapes available. See pages 136-142.



WILSON STYLE 3-1/2" ⓓ

HP 3-1/2" ⌀ STATION REPLACEMENT PARTS



Cat. No. 5524 Guide Unit Assembly includes:
1, 2, 3, 4, 5, 6, 8, & 9

Cat. No. 5725 Driver Assembly includes:
18, 19, 20, 21, 22, 23, 24, 25, 26, 27, 28, 29 & 30

	DESCRIPTION	CAT. NO.
1	Stripper Clip	5521
2	Guide Stripper Ring	5528
3	Spring	971694
4	Wave Spring	8140
5	Locking Button	5519
6	Special Pin	5522
7	Guide only Guide Unit Assembly	5527 5524
8	Lock Washer	2112
9	Socket Head Cap Screw [M5 x 10.87mm]	5197
10	Set Screw	6298
11	Punch Holder	5525
12	Urethane	2020643
13	Punch Holder Key	1862
14	Socket Head Cap Screw [M5 x 12mm]	6110
15	Disc Spring	971690
16	Socket Head Cap Screw (1/2-13 x 2.500")	6566
17	Anti-lock Shim	5413
18	Retaining Ring	5747
19	Spring Support	5738
20	Spring Cover	5561
21	Spring Disc (7 required)	5449
22	Adjustment Shaft	5739
23	Wave Spring	971692
24	Punch Driver	5740
25	Spring	972396
26	Adjustment Locking Ball	972420
27	Index Button	5737
28	Retaining Ring	972441
29	O-Ring	972430

3-1/2" ⌀

WILSON STYLE

HP 4-1/2" ⓔ STATION – WILSON STYLE

4-1/2" ⓔ

WILSON STYLE



GUIDE ASSEMBLY

PUNCH

STRIPPER

DIE

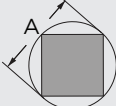
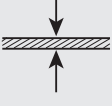
SHIM

GUIDE ASSEMBLY	CAT. NO.	PRICE
Assembly	5554	
ABS Assembly	5533	
PUNCH	CAT. NO.	PRICE
Round	5030	
Shape	5029	
Optima® Coating	—	
STRIPPER	CAT. NO.	PRICE
Round	1877	
Shape	1882	
Round ABS	5154	
Shape ABS	5155	
DIE	CAT. NO.	PRICE
Round Slug Hugger**	2200	
Round Standard	1878	
Shape Slug Hugger® 2*	12967	
Shape Positive	1883	
Shape Negative	1884	

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

DIE SHIM	CAT. NO.	PRICE
.010" [0.25mm] Pack of 5	2212	
.030" [0.76mm] Pack of 5	2730	
.060" [1.5mm] Pack of 5	2176	

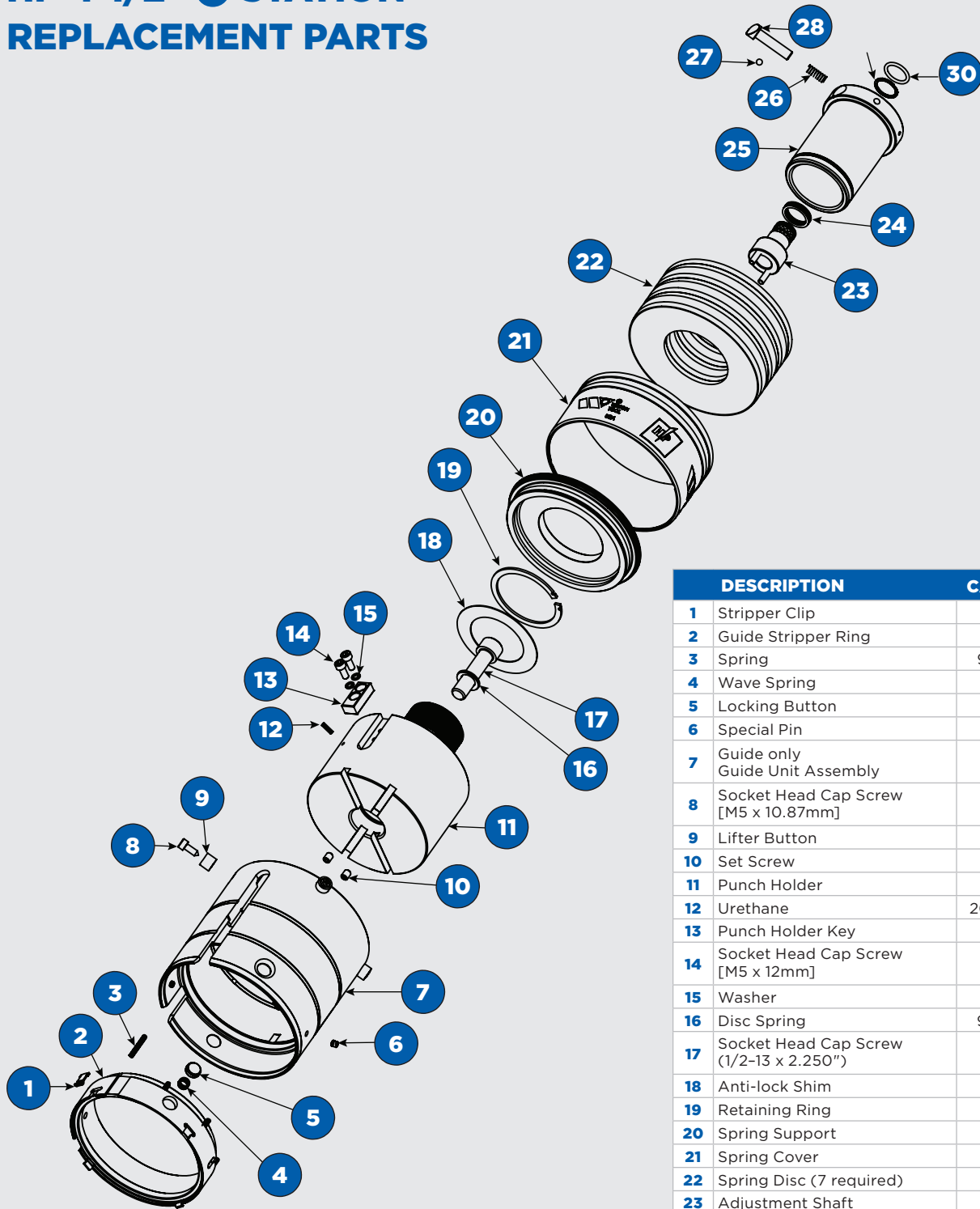
Additional charges may apply to non-standard features. See page 156.

DESCRIPTION	MAX. A DIMENSION	MAX. MATERIAL THICKNESS	NOTES
Guide assemblies achieve angles of 0°, 45°, 90°, 180°, 225°, and 270°.	4.500" [114.3mm] 	.250" [6.35mm] 	<ul style="list-style-type: none"> .062" [1.6mm] rooftop shear is standard on all punches with A Dimension > 2.000" [50.8mm] and width > .250" [6.35mm]. Ultima® premium tool steel available for punches and dies.

STANDARD SHAPES Non-standard shapes available. See pages 136-142.



HP 4-1/2" ⓔ STATION REPLACEMENT PARTS



Cat. No. 5534 Guide Unit Assembly includes:
1, 2, 3, 4, 5, 6, 8, & 9

Cat. No. 5726 Driver Assembly includes:
19, 20, 21, 22, 23, 24, 25, 26, 27, 28, 29 & 30

DESCRIPTION	CAT. NO.
1 Stripper Clip	5521
2 Guide Stripper Ring	5538
3 Spring	971694
4 Wave Spring	8140
5 Locking Button	5519
6 Special Pin	5522
7 Guide only Guide Unit Assembly	5537 5534
8 Socket Head Cap Screw [M5 x 10.87mm]	5210
9 Lifter Button	5209
10 Set Screw	6298
11 Punch Holder	5535
12 Urethane	2020643
13 Punch Holder Key	1862
14 Socket Head Cap Screw [M5 x 12mm]	6110
15 Washer	2112
16 Disc Spring	971690
17 Socket Head Cap Screw (1/2-13 x 2.250")	6325
18 Anti-lock Shim	5413
19 Retaining Ring	5747
20 Spring Support	5741
21 Spring Cover	5561
22 Spring Disc (7 required)	5449
23 Adjustment Shaft	5739
24 Wave Spring	971692
25 Punch Driver	5742
26 Spring	972396
27 Adjustment Locking Ball	972420
28 Index Button	5737
29 Retaining Ring	972441
30 O-Ring	972430

4-1/2" ⓔ

WILSON STYLE

STANDARD 2" Ⓢ STATION – WILSON STYLE

WILSON STYLE 2" Ⓢ



GUIDE ASSEMBLY	CAT. NO.	PRICE
Assembly	5583	
PUNCH	CAT. NO.	PRICE
Round 1/2-13 Thread	1847	
Shape 1/2-13 Thread	1853	
Optima® Coating	—	
STRIPPER	CAT. NO.	PRICE
Round	1848	
Shape	1854	
DIE	CAT. NO.	PRICE
Round Slug Hugger**	2196	
Round Standard	1850	
Shape Slug Hugger® 2*	12964	
Shape Positive	1855	
Shape Negative	1856	

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

DIE SHIM	CAT. NO.	PRICE
.010" [0.25mm] Pack of 10	2210	
.030" [0.76mm] Pack of 10	2726	
.060" [1.5mm] Pack of 10	2174	

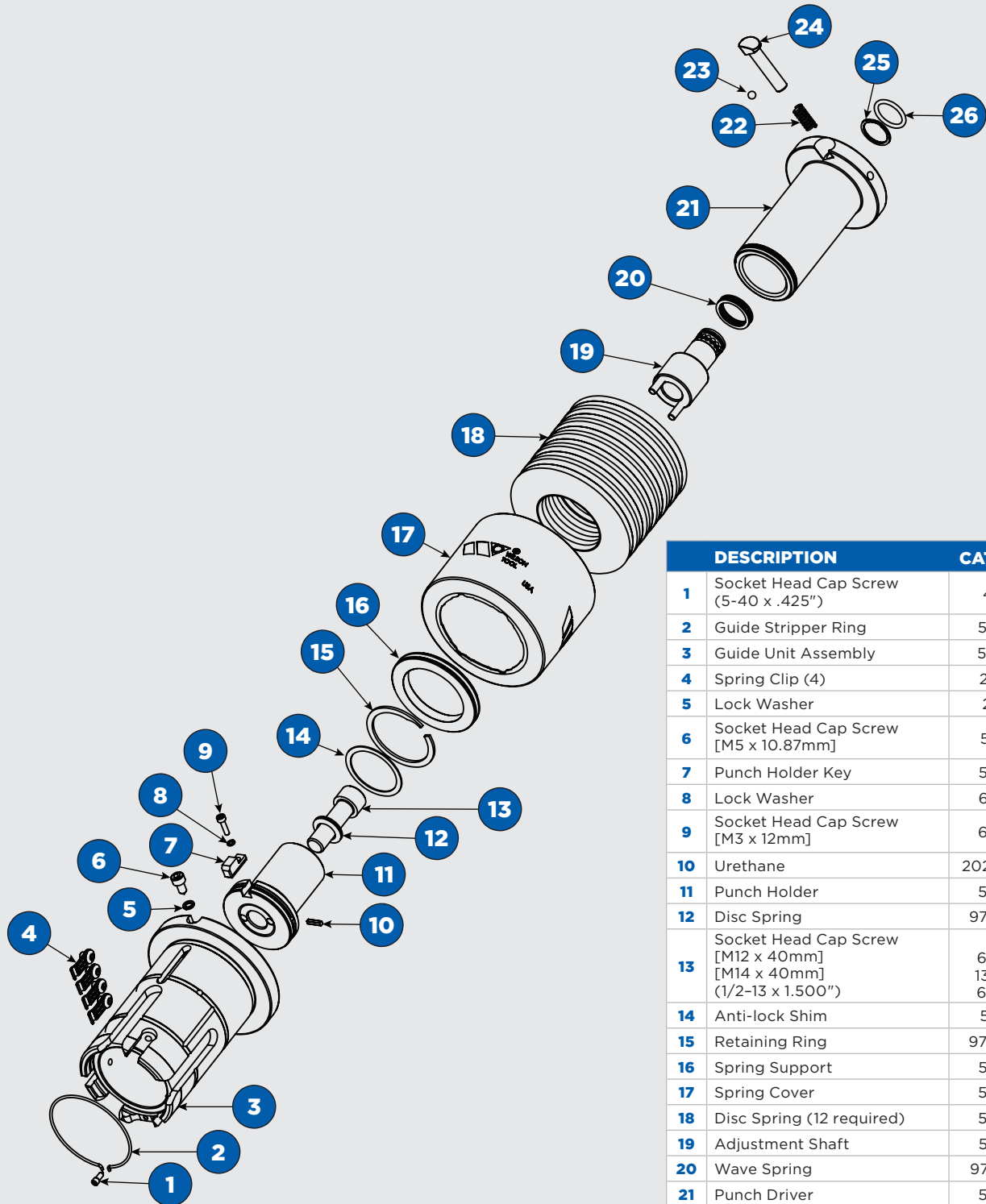
Additional charges may apply to non-standard features. See page 156.

DESCRIPTION	MAXIMUM A DIMENSION	MAXIMUM MATERIAL THICKNESS	NOTES
Standard assembly strippers are held in by a stripper ring or clips. Guide assemblies are keyed for shapes at 0°, 90° and 225°.	2.000" [50.8mm] 	.250" [6.35mm] 	<ul style="list-style-type: none"> All punches shipped with no shear unless specified. Full assemblies ship with guide stripper ring installed; Spring clips are also included 5583 includes M12 bolt Dies available in Ultima® premium tool steel upon request Compatible with M12 & 1/2-13 punches

STANDARD SHAPES Non-standard shapes available. See pages 136-142.



STANDARD 2" Ⓢ STATION REPLACEMENT PARTS



Cat. No. 5420 Guide Unit Assembly includes:
1, 2, 4, 5, & 6

Cat. No. 5729 Driver Assembly includes:
15, 16, 17, 18, 19, 20, 21, 22, 23, 24, 25 & 26

DESCRIPTION	CAT. NO.
1 Socket Head Cap Screw (5-40 x .425")	429
2 Guide Stripper Ring	5035
3 Guide Unit Assembly	5420
4 Spring Clip (4)	2810
5 Lock Washer	2112
6 Socket Head Cap Screw [M5 x 10.87mm]	5197
7 Punch Holder Key	5373
8 Lock Washer	6327
9 Socket Head Cap Screw [M3 x 12mm]	6326
10 Urethane	2020643
11 Punch Holder	5556
12 Disc Spring	971690
13 Socket Head Cap Screw [M12 x 40mm] [M14 x 40mm] (1/2-13 x 1.500")	6605 13843 6606
14 Anti-lock Shim	5412
15 Retaining Ring	972570
16 Spring Support	5748
17 Spring Cover	5693
18 Disc Spring (12 required)	5744
19 Adjustment Shaft	5735
20 Wave Spring	971692
21 Punch Driver	5736
22 Spring	972396
23 Adjustment Locking Ball	972420
24 Driver Lock Button	10539
25 Retaining Ring	972441
26 O-Ring	972430

2" Ⓢ WILSON STYLE

STANDARD 3-1/2" Ⓞ STATION – WILSON STYLE



WILSON STYLE 3-1/2" Ⓞ

GUIDE ASSEMBLY	CAT. NO.	PRICE
Assembly	5584	
PUNCH	CAT. NO.	PRICE
Round 1/2-13 Thread	1863	
Shape 1/2-13 Thread	1868	
Optima® Coating	—	
STRIPPER	CAT. NO.	PRICE
Round	1864	
Shape	1869	
DIE	CAT. NO.	PRICE
Round Slug Hugger**	2198	
Round Standard	1865	
Shape Slug Hugger® 2*	12965	
Shape Positive	1870	
Shape Negative	1871	

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

DIE SHIM	CAT. NO.	PRICE
.010" [0.25mm] Pack of 5	2211	
.030" [0.76mm] Pack of 5	2728	
.060" [1.5mm] Pack of 5	2175	

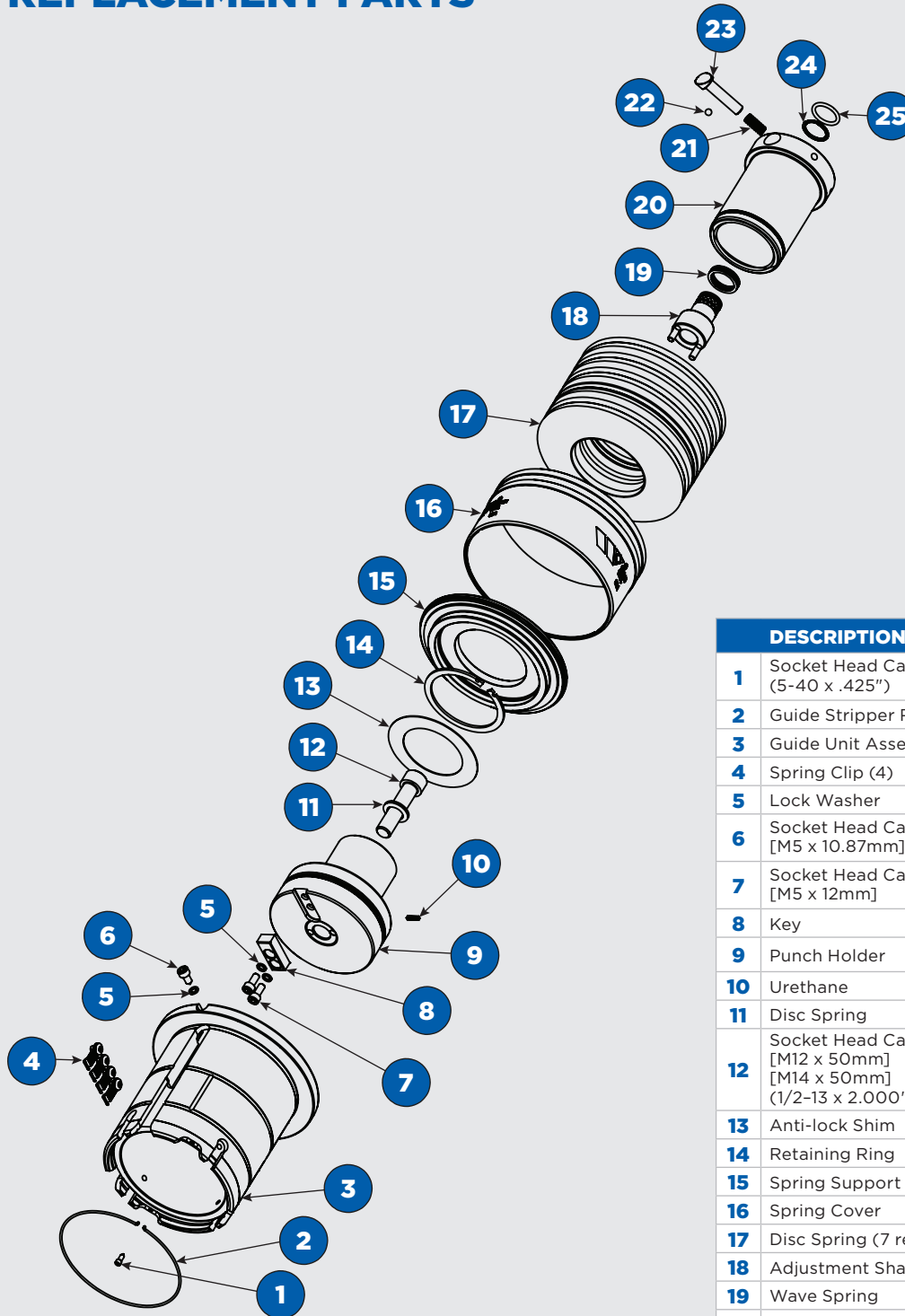
Additional charges may apply to non-standard features. See page 156.

DESCRIPTION	MAXIMUM A DIMENSION	MAXIMUM MATERIAL THICKNESS	NOTES
Standard assembly strippers are held in by a stripper ring or clips. Guide assemblies are keyed for shapes at 0°, 90° and 225°.	3.500" [88.9mm] 	.250" [6.35mm] 	<ul style="list-style-type: none"> .062" [1.6mm] rooftop shear is given to all punches with A Dimension > 2.000" [50.8mm] and width > .250" [6.35mm] 5584 includes M12 bolt Dies available in Ultima® premium tool steel upon request Compatible with M12 & 1/2-13 punches

STANDARD SHAPES Non-standard shapes available. See pages 136-142.



STANDARD 3-1/2" Ⓟ STATION REPLACEMENT PARTS



Cat. No. 5430 Guide Unit Assembly includes:
1, 2, 4, 5, & 6

Cat. No. 5730 Driver Assembly includes:
14, 15, 16, 17, 18, 19, 20, 21, 22, 23, 24, & 25

	DESCRIPTION	CAT. NO.
1	Socket Head Cap Screw (5-40 x .425")	429
2	Guide Stripper Ring	5036
3	Guide Unit Assembly	5430
4	Spring Clip (4)	2810
5	Lock Washer	2112
6	Socket Head Cap Screw [M5 x 10.87mm]	5197
7	Socket Head Cap Screw [M5 x 12mm]	6110
8	Key	1862
9	Punch Holder	5558
10	Urethane	2020643
11	Disc Spring	971690
12	Socket Head Cap Screw (2) [M12 x 50mm] [M14 x 50mm] (1/2-13 x 2.000")	970467 13844 6325
13	Anti-lock Shim	5413
14	Retaining Ring	5747
15	Spring Support	5738
16	Spring Cover	5423
17	Disc Spring (7 required)	5449
18	Adjustment Shaft	5739
19	Wave Spring	971692
20	Punch Driver	5740
21	Spring	972396
22	Adjustment Locking Ball	972420
23	Index Button	5737
24	Retaining Ring	972441
25	O-Ring	972430

3-1/2" Ⓟ

WILSON STYLE

STANDARD 4-1/2" ⓔ STATION – WILSON STYLE

4-1/2" ⓔ

WILSON STYLE



GUIDE ASSEMBLY



PUNCH



STRIPPER



DIE



SHIM

GUIDE ASSEMBLY	CAT. NO.	PRICE
Assembly	5585	
PUNCH	CAT. NO.	PRICE
Round 1/2-13 Thread	1876	
Shape 1/2-13 Thread	1881	
Optima® Coating	—	
STRIPPER	CAT. NO.	PRICE
Round	1877	
Shape	1882	
DIE	CAT. NO.	PRICE
Round Slug Hugger**	2200	
Round Standard	1878	
Shape Slug Hugger® 2*	12967	
Shape Positive	1883	
Shape Negative	1884	

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

DIE SHIM	CAT. NO.	PRICE
.010" [0.25mm] Pack of 5	2212	
.030" [0.76mm] Pack of 5	2730	
.060" [1.5mm] Pack of 5	2176	

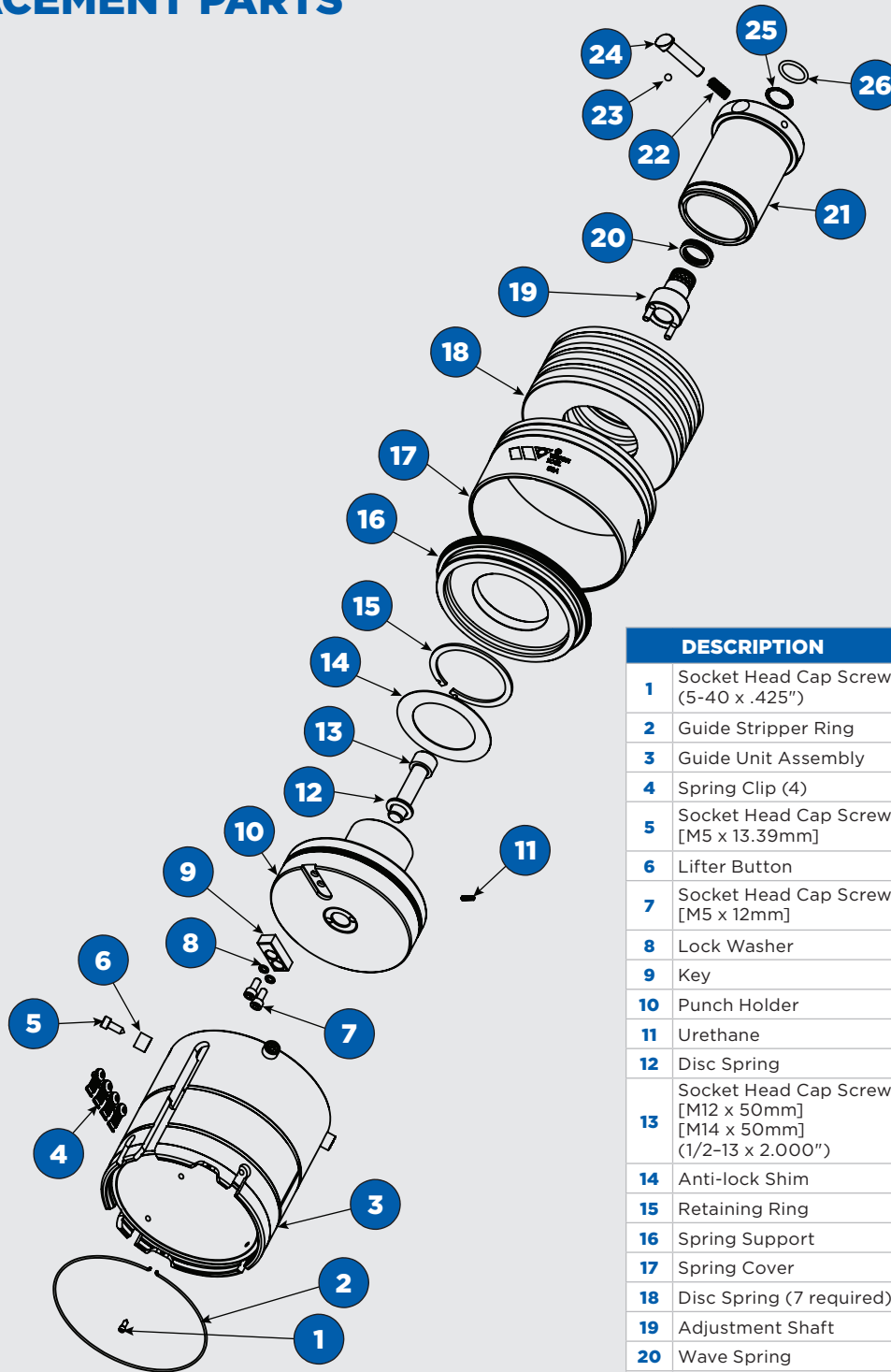
Additional charges may apply to non-standard features. See page 156.

DESCRIPTION	MAXIMUM A DIMENSION	MAXIMUM MATERIAL THICKNESS	NOTES
Standard assembly strippers are held in by a stripper ring or clips. Guide assemblies are keyed for shapes at 0°, 90° and 225°.	4.500" [114.3mm] 	.250" [6.35mm] 	<ul style="list-style-type: none"> .062" [1.6mm] rooftop shear is given to all punches with A Dimension > 2.000" [50.8mm] and width > .250" [6.35mm] 5585 includes M12 bolt Dies available in Ultima® premium tool steel upon request Compatible with M12 & 1/2-13 punches

STANDARD SHAPES Non-standard shapes available. See pages 136-142.



STANDARD 4-1/2" ⓔ STATION REPLACEMENT PARTS



Cat. No. 5438 Guide Unit Assembly includes:
1, 2, 4, 5 & 6

Cat. No 5731 Driver Assembly includes:
15, 16, 17, 18, 19, 20, 21, 22, 23, 24, 25 & 26

DESCRIPTION	CAT. NO.
1 Socket Head Cap Screw (5-40 x .425")	429
2 Guide Stripper Ring	5037
3 Guide Unit Assembly	5438
4 Spring Clip (4)	2810
5 Socket Head Cap Screw [M5 x 13.39mm]	5210
6 Lifter Button	5209
7 Socket Head Cap Screw [M5 x 12mm]	6110
8 Lock Washer	2112
9 Key	1862
10 Punch Holder	5560
11 Urethane	2020643
12 Disc Spring	971690
13 Socket Head Cap Screw [M12 x 50mm] [M14 x 50mm] (1/2-13 x 2.000")	970467 13844 6325
14 Anti-lock Shim	5413
15 Retaining Ring	5747
16 Spring Support	5741
17 Spring Cover	5423
18 Disc Spring (7 required)	5449
19 Adjustment Shaft	5739
20 Wave Spring	971692
21 Punch Driver	5742
22 Spring	972396
23 Adjustment Locking Ball	972420
24 Index Button	5737
25 Retaining Ring	972441
26 O-Ring	972430

4-1/2" ⓔ

WILSON STYLE

BASIX 2" Ⓞ STATION – WILSON STYLE



GUIDE ASSEMBLY	CAT. NO.	PRICE
Assembly	1842	
PUNCH	CAT. NO.	PRICE
Round 1/2-13 Thread	1847	
Shape 1/2-13 Thread	1853	
Optima® Coating	—	
STRIPPER	CAT. NO.	PRICE
Round	1848	
Shape	1854	
DIE	CAT. NO.	PRICE
Round Slug Hugger**	2196	
Round Standard	1850	
Shape Slug Hugger® 2*	12964	
Shape Positive	1855	
Shape Negative	1856	

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

DIE SHIM	CAT. NO.	PRICE
.010" [0.25mm] Pack of 5	2211	
.030" [0.76mm] Pack of 10	2726	
.060" [1.5mm] Pack of 10	2174	

Additional charges may apply to non-standard features. See page 156.

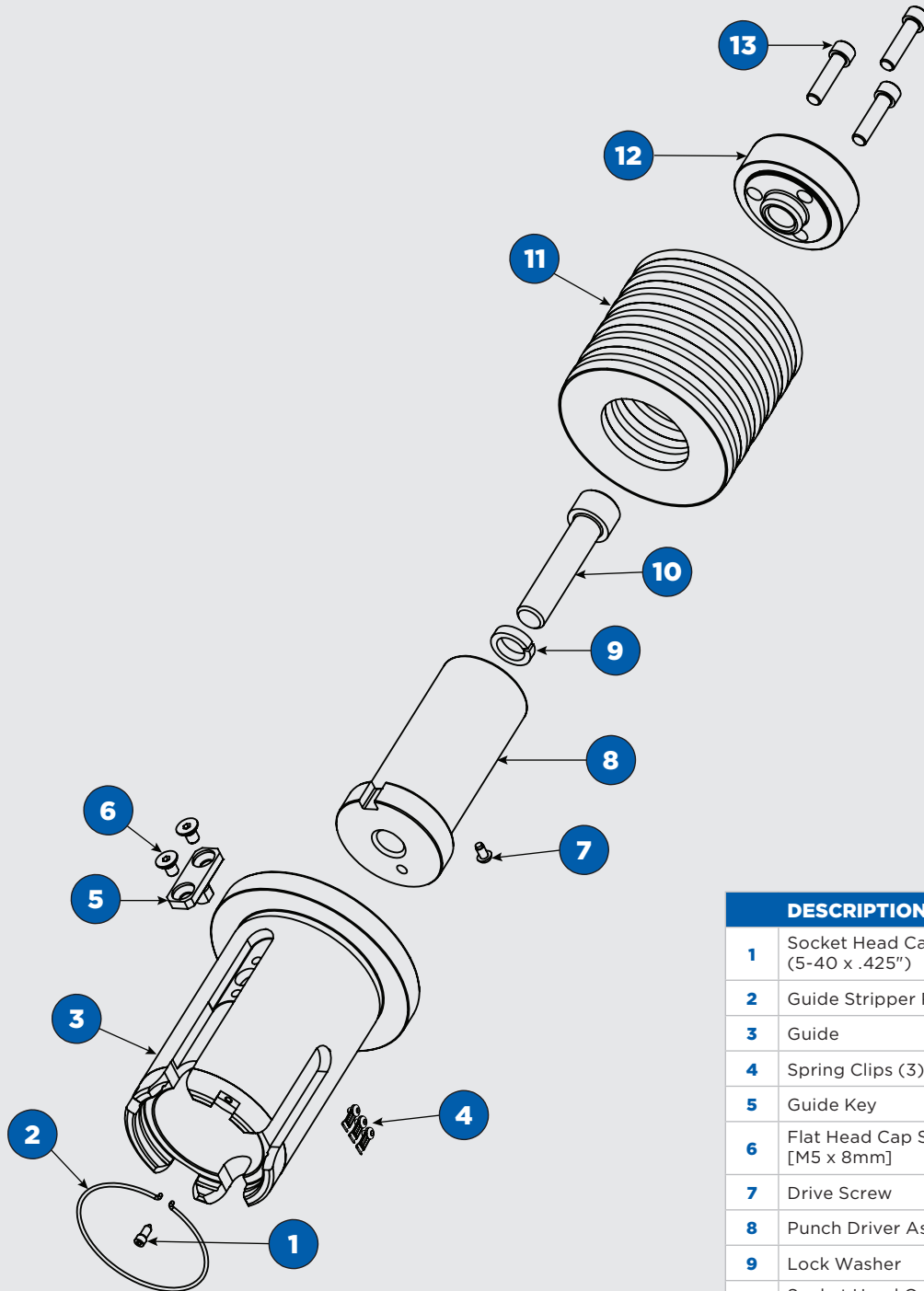
DESCRIPTION	MAXIMUM A DIMENSION	MAXIMUM MATERIAL THICKNESS	NOTES
Basix assemblies are designed to deliver durability and performance at a lower cost with basic features. Guide assemblies are keyed for shapes at 0°, 90° and 225°.	2.000" [50.8mm] 	.250" [6.35mm] 	<ul style="list-style-type: none"> All punches shipped with no shear unless specified 1842 assembly includes M12 bolt Dies available in Ultima® premium tool steel upon request

STANDARD SHAPES Non-standard shapes available. See pages 136-142.



WILSON STYLE 2" Ⓞ

BASIX 2" © STATION REPLACEMENT PARTS



Cat. No. 1845 Driver Assembly includes:
7 & 8

	DESCRIPTION	CAT. NO.
1	Socket Head Cap Screw (5-40 x .425")	429
2	Guide Stripper Ring	5035
3	Guide	1846
4	Spring Clips (3)	2810
5	Guide Key	1834
6	Flat Head Cap Screw [M5 x 8mm]	6567
7	Drive Screw	6666
8	Punch Driver Assembly	1845
9	Lock Washer	432
10	Socket Head Cap Screw (2) [M12 x 55mm] (1/2-13 x 2.250")	6026 6002
11	Disc Spring (11 required)	1844
12	Punch Head	1843
13	Socket Head Cap Screw (.250-28 x 1.000")	6047

BASIX 3-1/2" Ⓞ STATION – WILSON STYLE



GUIDE ASSEMBLY



PUNCH



STRIPPER



DIE



SHIM

GUIDE ASSEMBLY	CAT. NO.	PRICE
Assembly	1857	
PUNCH	CAT. NO.	PRICE
Round 1/2-13 Thread	1863	
Shape 1/2-13 Thread	1868	
Optima® Coating	—	
STRIPPER	CAT. NO.	PRICE
Round	1864	
Shape	1869	
DIE	CAT. NO.	PRICE
Round Slug Hugger**	2198	
Round Standard	1865	
Shape Slug Hugger® 2*	12965	
Shape Positive	1870	
Shape Negative	1871	

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

DIE SHIM	CAT. NO.	PRICE
.010" [0.25mm] Pack of 5	2211	
.030" [0.76mm] Pack of 5	2728	
.060" [1.5mm] Pack of 5	2175	

Additional charges may apply to non-standard features. See page 156.

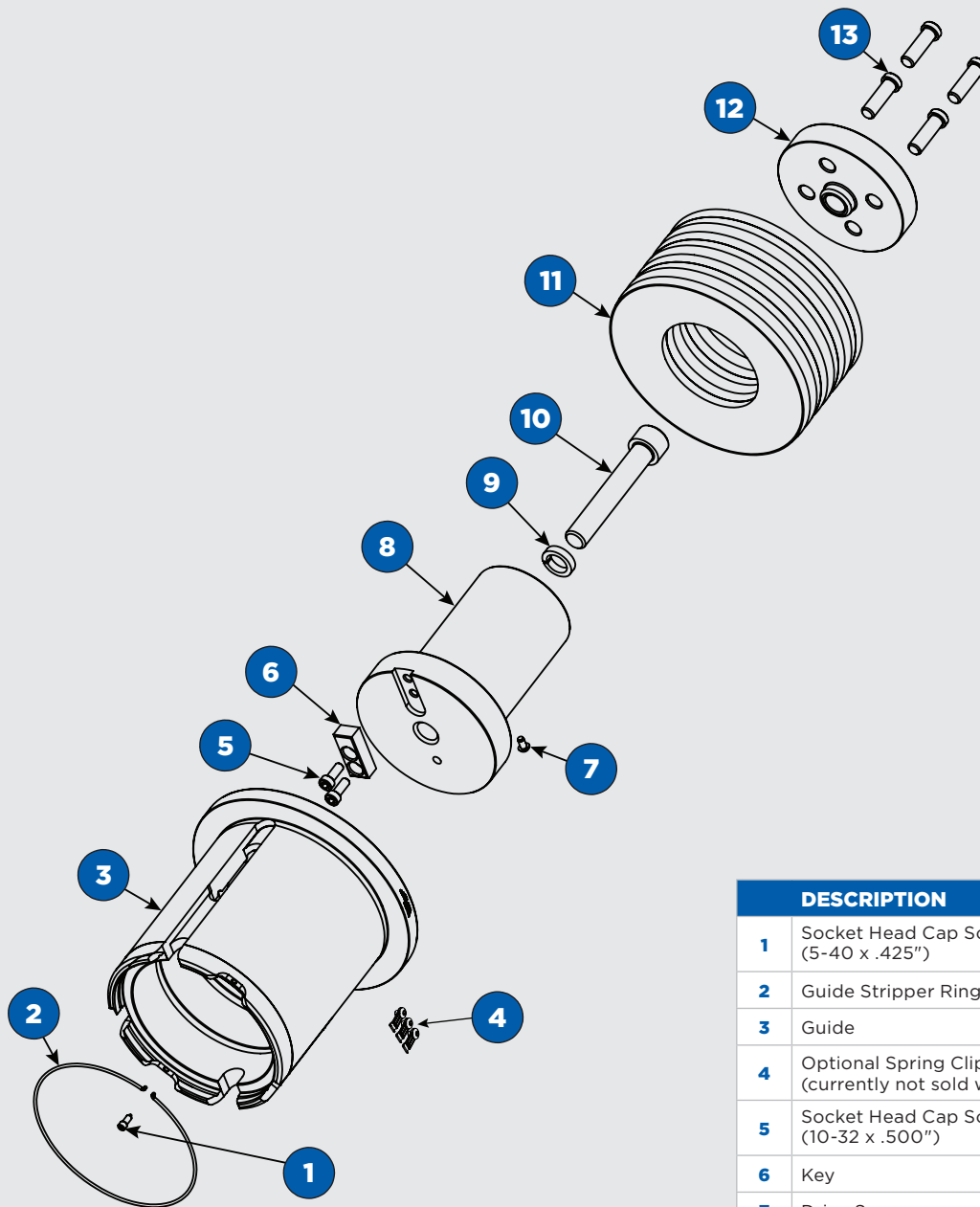
DESCRIPTION	MAXIMUM A DIMENSION	MAXIMUM MATERIAL THICKNESS	NOTES
Basix assemblies are designed to deliver durability and performance at a lower cost with basic features. Guide assemblies are keyed for shapes at 0°, 90° and 225°.	3.500" [88.9mm] 	.250" [6.35mm] 	<ul style="list-style-type: none"> .062" [1.6mm] rooftop shear is given to all punches with A Dimension > 2.000" [50.8mm] and width > .250" [6.35mm] 1857 assembly includes M12 bolt Dies are available in Ultima® premium tool steel upon request

STANDARD SHAPES Non-standard shapes available. See pages 136-142.



WILSON STYLE 3-1/2" Ⓞ

BASIX 3-1/2" ⌀ STATION REPLACEMENT PARTS



Cat. No. 1860 Driver Assembly includes:
7 & 8

	DESCRIPTION	CAT. NO.
1	Socket Head Cap Screw (5-40 x .425")	429
2	Guide Stripper Ring	5036
3	Guide	1861
4	Optional Spring Clips (3) (currently not sold with guide)	2810
5	Socket Head Cap Screw (10-32 x .500")	6010
6	Key	1862
7	Drive Screw	6666
8	Punch Driver Assembly	1860
9	Lock Washer	432
10	Socket Head Cap Screw (2) [M12 x 75mm] (1/2-13 x 3.000")	6027 6003
11	Disc Spring (7 required)	1859
12	Punch Head	1858
13	Low Head Cap Screw (.312-18 x 1.000")	6021

3-1/2" ⌀

WILSON STYLE

BASIX 4-1/2" ⓔ STATION – WILSON STYLE

WILSON STYLE 4-1/2" ⓔ



GUIDE ASSEMBLY



PUNCH



STRIPPER



DIE



SHIM

GUIDE ASSEMBLY	CAT. NO.	PRICE
Assembly	1872	
PUNCH	CAT. NO.	PRICE
Round 1/2-13 Thread	1876	
Shape 1/2-13 Thread	1881	
Optima® Coating	—	
STRIPPER	CAT. NO.	PRICE
Round	1877	
Shape	1882	
DIE	CAT. NO.	PRICE
Round Slug Hugger**	2200	
Round Standard	1878	
Shape Slug Hugger® 2*	12967	
Shape Positive	1883	
Shape Negative	1884	

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

DIE SHIM	CAT. NO.	PRICE
.010" [0.25mm] Pack of 5	2212	
.030" [0.76mm] Pack of 5	2730	
.060" [1.5mm] Pack of 5	2176	

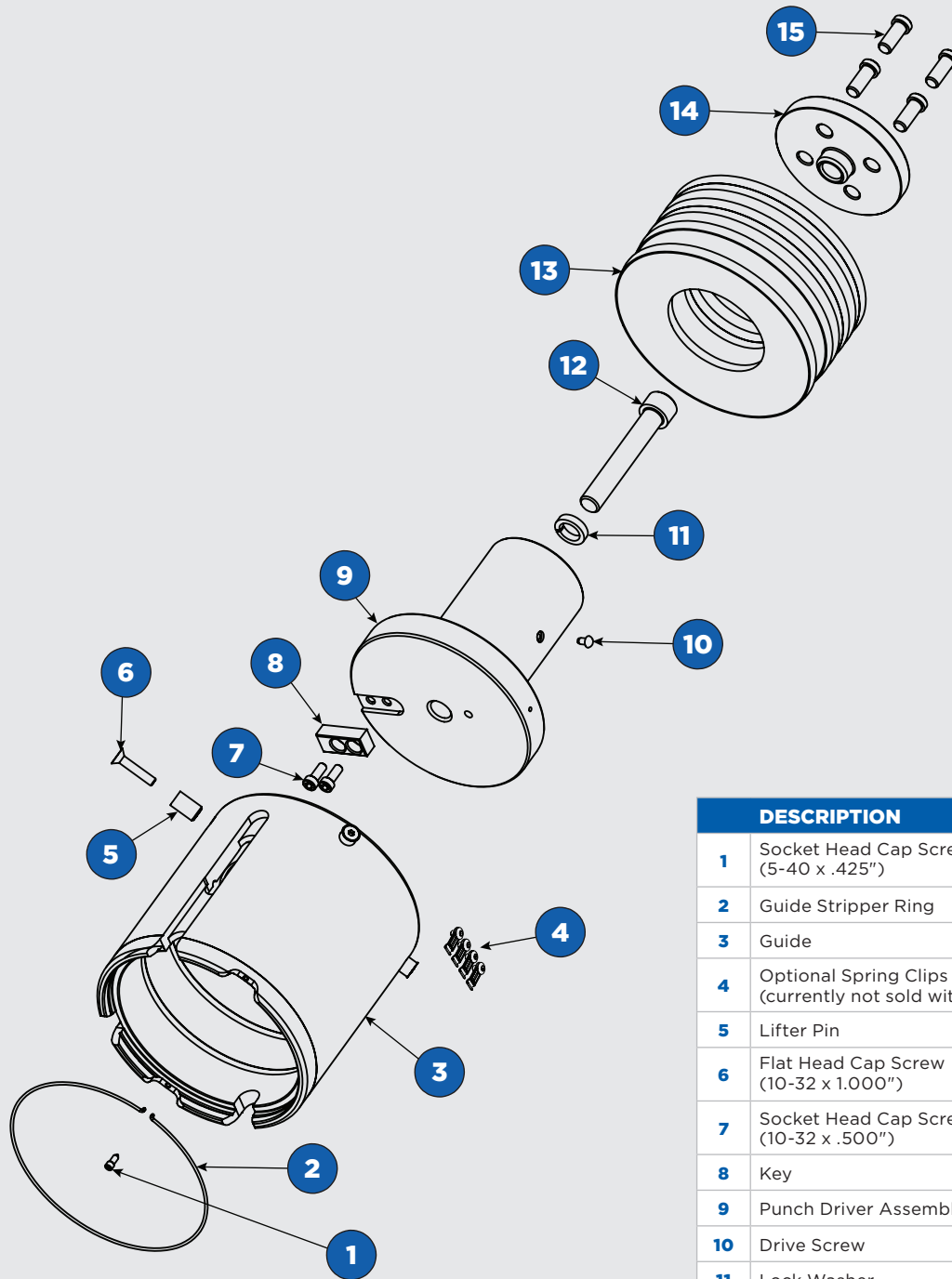
Additional charges may apply to non-standard features. See page 156.

DESCRIPTION	MAXIMUM A DIMENSION	MAXIMUM MATERIAL THICKNESS	NOTES
Basix assemblies are designed to deliver durability and performance at a lower cost with basic features. Guide assemblies are keyed for shapes at 0°, 90° and 225°.	4.500" [114.3mm] 	.250" [6.35mm] 	<ul style="list-style-type: none"> .062" [1.6mm] rooftop shear is given to all punches with A Dimension > 2.000" [50.8mm] and width > .250" [6.35mm] 1872 assembly includes M12 bolt Dies are available in Ultima® premium tool steel upon request

STANDARD SHAPES Non-standard shapes available. See pages 136-142.



BASIX 4-1/2" ⓔ STATION REPLACEMENT PARTS



Cat. No. 1874 Driver Assembly includes:
9 & 10

	DESCRIPTION	CAT. NO.
1	Socket Head Cap Screw (5-40 x .425")	429
2	Guide Stripper Ring	5037
3	Guide	1875
4	Optional Spring Clips (4) (currently not sold with guide)	2810
5	Lifter Pin	1880
6	Flat Head Cap Screw (10-32 x 1.000")	2158
7	Socket Head Cap Screw (10-32 x .500")	6010
8	Key	1862
9	Punch Driver Assembly	1874
10	Drive Screw	6666
11	Lock Washer	432
12	Socket Head Cap Screw (2) [M12 x 75mm] (1/2-13 x 3.000")	6027 6003
13	Disc Spring (7 required)	1859
14	Punch Head	1873
15	Low Head Cap Screw (.312-18 x .750")	6022

4-1/2" ⓔ

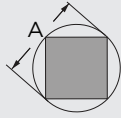
WILSON
STYLE

HP NOTCHER STRIPPER PLATE



MAXIMUM PUNCH A DIMENSION	SHAPE	HP		HP ABS		S-90		S-90 ABS	
		CAT. NO.	PRICE	CAT. NO.	PRICE	CAT. NO.	PRICE	CAT. NO.	PRICE
C STATION									
2.000" [50.8 mm]	Round	2469		5643		5067		5453	
	Shape	2470		5644		5068		5454	
D STATION									
3.500" [88.9mm]	Round	2471		5645		5069		5455	
	Shape	2472		5646		5070		5456	
E STATION									
4.500" [114.3m]	Round	2473		5647		5071		5457	
	Shape	2474		5648		5072		5458	

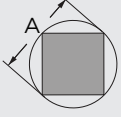
WILSON STYLE

DESCRIPTION	MAX. A DIMENSION	ADVANTAGES	NOTES
The Notcher stripper plate is a hardened tool steel stripper plate that is precision ground to exacting tolerances. Uniquely designed to give the rigidity and slip fit of a special notching unit.	See chart above. 	<ul style="list-style-type: none"> Better guiding, less tool deflection Greater flexibility of tooling applications Longer tool life Standard punch can be used 	Designed to fit Wilson Tool manufactured guide assemblies.

BONDED URETHANE STRIPPER PLATES



STATION	MAX. PUNCH A DIMENSION	SHAPE	CAT. NO.	PRICE
A	.500" [12.7mm]	Round	14863	
		Shape	14864	
B	1.250" [25.4mm]	Round	14866	
		Shape	14867	
C	2.000" [50.8mm]	Round	14869	
		Shape	14870	
D	3.500" [88.9mm]	Round	14872	
		Shape	14873	
		Notcher	14878	
E	4.500" [114.3mm]	Round	14875	
		Shape	14876	

DESCRIPTION	MAX. A DIMENSION	ADVANTAGES	NOTES
Bonded Urethane stripper plates are hardened tool steel stripper plates that have had a layer of urethane bonded to the top surface.	See chart above. 	<ul style="list-style-type: none"> Reduced sheet marking Standard punch can be used 	Designed to fit Wilson Tool manufactured guide assemblies.



WILSON TOOL INTERNATIONAL OFFERS UNIQUE COATINGS TO INCREASE THE LIFE OF YOUR PUNCHES

Wearbeater™

- Titanium nitride (TiN)
- Good for wear on most materials
- Reduces galling on most materials
- Increases lubricity on most materials
- Minimum dia./width for coating = .060" [1.53mm]



Nitrex®

- Surface hardness: HRC 70
- Best for wear on galvanized
- Reduces galling on galvanized
- Better for wear and lubricity on most other materials
- Not recommended for wear on hard materials
- Minimum dia./width for coating = .125" (3.18mm)



Optima®

- Surface hardness: HRC 95
- Outlasts untreated tools by up to 5-7 times
- Best for wear on abrasive materials in piercing applications
- Reduces galling on hard materials
- Increases lubricity by controlling galling on hard materials
- Minimum dia./width for coating = .060" [1.53mm]



Slip-Max®

- Best for reducing galling on soft materials
- Best for forming (stripping) in abrasive materials such as stainless steel and aluminum
- Increases lubricity on all materials
- Not recommended for piercing applications in abrasive materials
- No minimum dia./width for coating



COATING RECOMMENDATION BY APPLICATION	WEARBEATER™	OPTIMA®	NITREX®	SLIP-MAX®
Punch wear piercing varied materials	●	★		
Punch or die wear piercing stainless steel	●	★		
Punch wear piercing galvanized	●	▲	★	
Punch or die wear piercing aluminum	●		▲	★
Galling on punch in stainless steel	●	▲		
Galling on punch in galvanized	●	▲	★	
Galling on punch in aluminum	●		▲	★
Stripping problems when forming in stainless steel	●		▲	★
Stripping problems when forming in aluminum	●			★
Stripping problems when piercing in stainless steel	●	★		
Stripping problems when piercing in aluminum	●		▲	★

● GOOD ▲ BETTER ★ BEST

METRIC STYLE



HPX



H/P2



basix



THICK TURRET TOOLING SOLUTIONS



SMALL STATION ADVANTAGES	HPX	HP2	BASIX
Hardened guides for increased durability	●	●	●
Simple tool-less stripper change	●	●	●
Relieved strippers for extended guide life	●	●	●
Internal and external tool lubrication	●	●	●
Machine lubrication capability (ABS only, all HPX)	●	●	●
OEM compatible	●	●	●
Optima® coated punches available	●	●	●
Slug Hugger® 2 – maximum slug retention	●	●	●
In machine adjustment for faster set ups	●	●	
Easy click length adjustment – no shims or tooling required	●	●	
Maximum available grind life	●	●	
EXP® quick change technology	●		
Made standard from Ultima® premium tool steel	●		
Accepts round or shaped punches in the same assembly	●		
Push button guide release	●		

HPX® 1/2" A STATION – METRIC STYLE



PUNCH AND GUIDE ASSEMBLY



GUIDE



EXP® PUNCH



STRIPPER



DIE



SHIM

Scan QR Code to Explore More HPX®



PUNCH AND GUIDE ASSEMBLY	CAT. NO.	PRICE
Round	14936	
Shape	14937	
Optima® Coating	—	
GUIDE ASSEMBLY	CAT. NO.	PRICE
Assembly only 0° & 90°	14942	
Assembly only 0° & 45°	14943	
Assembly only 0°, 90°, 180° & 270°	14944	
SPRING PACK ASSEMBLY	CAT. NO.	PRICE
Spring Pack Assembly only	14366	
GUIDE	CAT. NO.	PRICE
Round	14076X	
Shape 0°	14077X	
Shape 0° & 45°	14079X	
Shape 0° & 90°	14078X	
PUNCH	CAT. NO.	PRICE
Round	13904	
Shape	13905	
Optima® Coating	—	
STRIPPER	CAT. NO.	PRICE
Round	13045	
Shape	13152	
DIE	CAT. NO.	PRICE
Round Slug Hugger**	2192	
Round Standard	1808	
Shape Slug Hugger* 2*	12959	
Shape Positive	1817	
Shape Negative	1818	
DIE SHIM	CAT. NO.	PRICE
.010" [0.25mm] Pack of 25	2208	
.030" [0.76mm] Pack of 25	2722	
.060" [1.5mm] Pack of 25	2172	

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

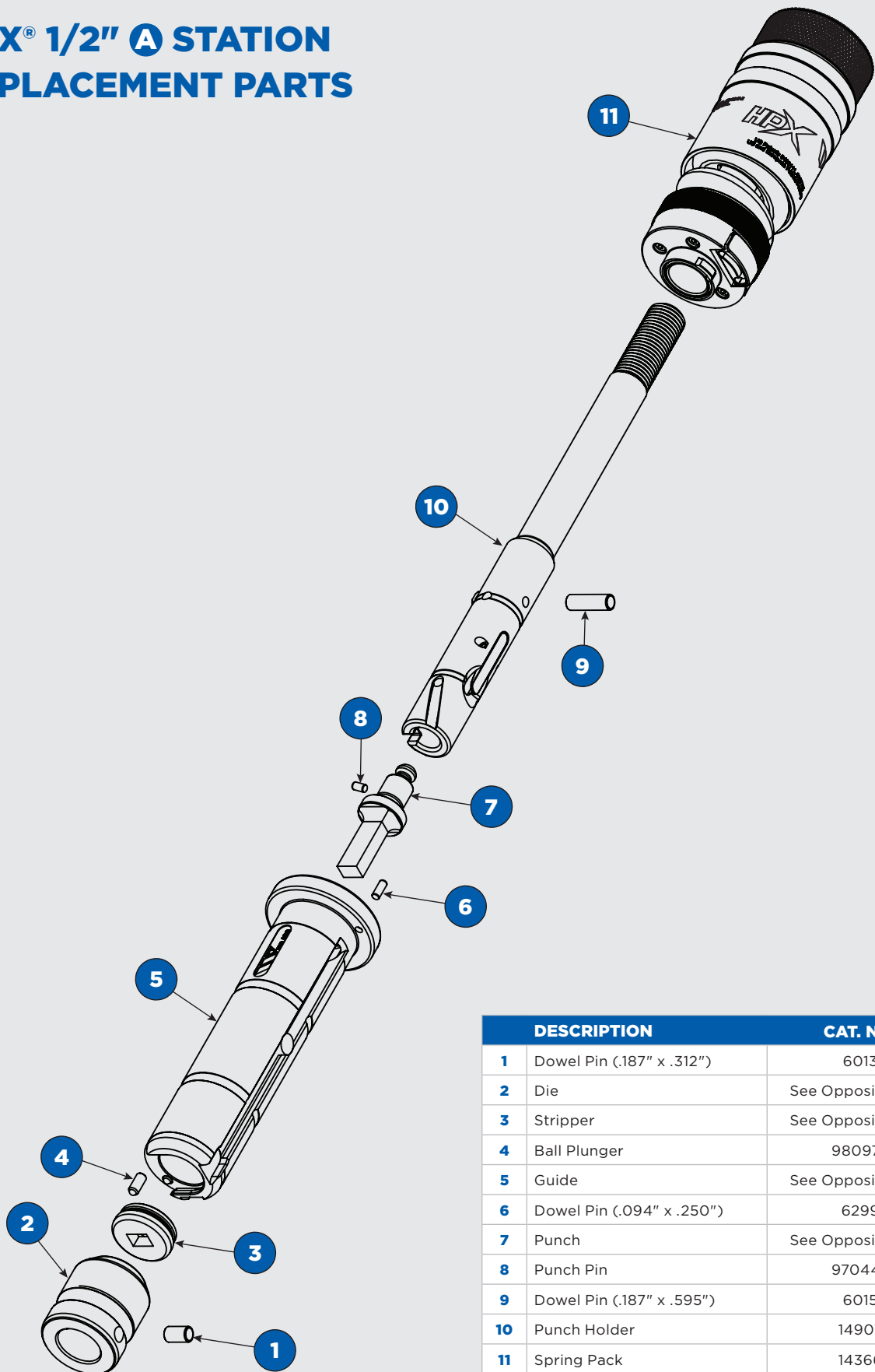
Additional charges may apply to non-standard features. See page 156.

DESCRIPTION	A DIMENSION	MAX. MATERIAL THICKNESS	NOTES
HPX® tooling is Wilson Tool's 'Best' product. It is loaded with all the great features of the HP2 plus the EXP® quick change punch system with Ultima® premium tool steel.	.500" [12.7mm] 	.150" [3.81mm] 	<ul style="list-style-type: none"> Compatible with ABS and non-ABS machines. Ultima® premium tool steel is standard in EXP® punches. Dies are available in Ultima® tool steel upon request.

STANDARD SHAPES Non-standard shapes available. See pages 136-142.



HPX® 1/2" A STATION REPLACEMENT PARTS



	DESCRIPTION	CAT. NO.
1	Dowel Pin (.187" x .312")	6013
2	Die	See Opposite Page
3	Stripper	See Opposite Page
4	Ball Plunger	980973
5	Guide	See Opposite Page
6	Dowel Pin (.094" x .250")	6299
7	Punch	See Opposite Page
8	Punch Pin	970442
9	Dowel Pin (.187" x .595")	6015
10	Punch Holder	14907
11	Spring Pack	14366

1/2" A

METRIC STYLE

HPX® 1-1/4" ⓑ STATION – METRIC STYLE

1-1/4" ⓑ

METRIC STYLE



PUNCH AND GUIDE ASSEMBLY



GUIDE



EXP® PUNCH



STRIPPER



DIE



SHIM

Scan QR Code to Explore More HPX®



PUNCH AND GUIDE ASSEMBLY	CAT. NO.	PRICE
Round	14939	
Shape	14940	
Optima® Coating	—	
GUIDE ASSEMBLY	CAT. NO.	PRICE
Assembly only 0° & 90°	14945	
Assembly only 0° & 45°	14946	
Assembly only 0°, 90°, 180° & 270°	14947	
SPRING PACK ASSEMBLY	CAT. NO.	PRICE
Spring Pack Assembly only	14367	
GUIDE	CAT. NO.	PRICE
Round	14084X	
Shape 0°	14085X	
Shape 0° & 45°	14087X	
Shape 0° & 90°	14086X	
PUNCH	CAT. NO.	PRICE
Round	13916	
Shape	13917	
Optima® Coating	—	
STRIPPER	CAT. NO.	PRICE
Round	2433	
Shape	2432	
DIE	CAT. NO.	PRICE
Round Slug Hugger**	2194	
Round Standard	2021	
Shape Slug Hugger* 2*	12961	
Shape Positive	2025	
Shape Negative	2026	
DIE SHIM	CAT. NO.	PRICE
.010" [0.25mm] Pack of 25	2209	
.030" [0.76mm] Pack of 25	2724	
.060" [1.5mm] Pack of 25	2173	

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

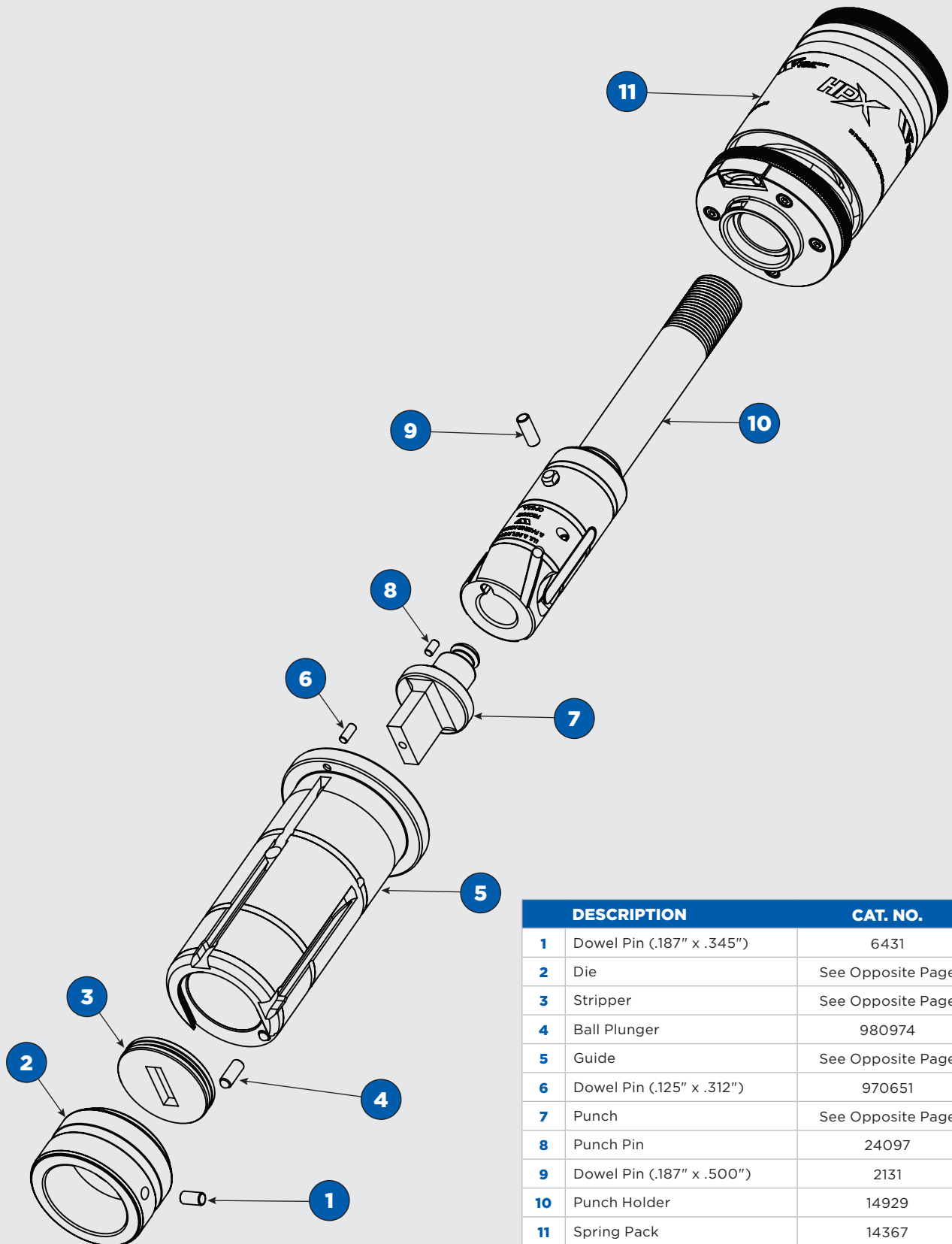
Additional charges may apply to non-standard features. See page 156.

DESCRIPTION	A DIMENSION	MAX. MATERIAL THICKNESS	NOTES
HPX® tooling is Wilson Tool's 'Best' product. It is loaded with all the great features of the HP2 plus the EXP® quick change punch system with Ultima® premium tool steel.	1.250" [31.8mm] 	.250" [6.35mm] 	<ul style="list-style-type: none"> Compatible with ABS and non-ABS machines. Ultima® premium tool steel is standard in EXP® punches. Dies are available in Ultima® tool steel upon request.

STANDARD SHAPES Non-standard shapes available. See pages 136-142.



HPX® 1-1/4" B STATION REPLACEMENT PARTS



	DESCRIPTION	CAT. NO.
1	Dowel Pin (.187" x .345")	6431
2	Die	See Opposite Page
3	Stripper	See Opposite Page
4	Ball Plunger	980974
5	Guide	See Opposite Page
6	Dowel Pin (.125" x .312")	970651
7	Punch	See Opposite Page
8	Punch Pin	24097
9	Dowel Pin (.187" x .500")	2131
10	Punch Holder	14929
11	Spring Pack	14367

1-1/4" B

METRIC STYLE

EXP® 1/2" A STATION – METRIC STYLE



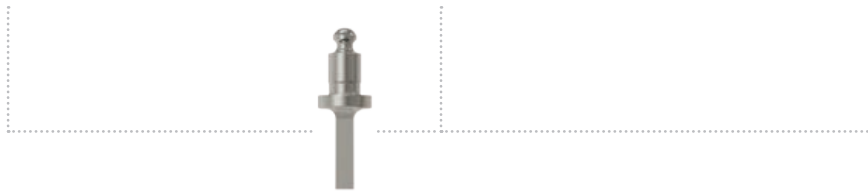
1/2" A

METRIC STYLE

METRIC HP2 & BASIX PUNCH HOLDER		
Compatible with Metric Style Punch and Guide Assemblies		
	CAT. NO.	PRICE
Round	14905	
Shape	14903	

METRIC HP2 & BASIX ABS PUNCH HOLDER		
Compatible with Metric Style Punch and Guide Assemblies		
	CAT. NO.	PRICE
Round	14909	
Shape	14907	

ULTRA PUNCH HOLDER		
Compatible with Ultra Punch and Guide Assemblies		
	CAT. NO.	PRICE
Ultra	15575	



Scan QR Code to Explore More EXP®



EXP® PUNCH		
Compatible with all punch holders above		
EXP® PUNCH	CAT. NO.	PRICE
Round	13904	
Shape	13905	
Optima® Coating	—	

EXP® Punch Grinding Fixture

Fixture for sharpening A and B Station EXP® punches with our innovative XSharp™ Grinder.

CAT. NO.	PRICE
6990	



DESCRIPTION	A DIMENSION	MAX. MATERIAL THICKNESS	NOTES
EXP® punch holders allow you to convert your current Metric Basix punch and guide assemblies to the EXP quick change punch system. Ultima® premium tool steel is standard in EXP punches.	.500" [12.7mm] 	.150" [3.81mm] 	Additional charges may apply to non-standard features. See page 156.

STANDARD SHAPES *Non-standard shapes available. See pages 136-142.*



EXP® 1-1/4" B STATION – METRIC STYLE



METRIC HP2 & BASIX PUNCH HOLDER		
Compatible with Metric Style Punch and Guide Assemblies		
	CAT. NO.	PRICE
Round	14927	
Shape	14925	

METRIC HP2 & BASIX ABS PUNCH HOLDER		
Compatible with Metric Style Punch and Guide Assemblies		
	CAT. NO.	PRICE
Round	14931	
Shape	14929	

ULTRA PUNCH HOLDER		
Compatible with Ultra Punch and Guide Assemblies		
	CAT. NO.	PRICE
Ultra	15577	



Scan QR Code to Explore More EXP®



EXP® PUNCH		
Compatible with all punch holders above		
EXP® Punch	CAT. NO.	PRICE
Round	13916	
Shape	13917	
Optima® Coating	—	

EXP® Punch Grinding Fixture

Fixture for sharpening A and B Station EXP® punches with our innovative XSharp™ Grinder.

CAT. NO.	PRICE
6990	



DESCRIPTION	A DIMENSION	MAX. MATERIAL THICKNESS	NOTES
EXP® punch holders allow you to convert your current Metric Basix punch and guide assemblies to the EXP® quick change punch system. Ultima® premium tool steel is standard in EXP® punches.	1.250" [31.8mm] 	.250" [6.35mm] 	Additional charges may apply to non-standard features. See page 156.

STANDARD SHAPES Non-standard shapes available. See pages 136-142.



HP2 1/2" A STATION – METRIC STYLE



PUNCH AND GUIDE ASSEMBLY



PUNCH (ABS shown)



GUIDE



STRIPPER



DIE



SHIM

PUNCH AND GUIDE ASSEMBLY	CAT. NO.	PRICE	ABS	
			CAT. NO.	PRICE
Round	14052		14054	
Shape	14053		14055	
Optima® Coating	—		—	
Spring Pack Assembly	14153		14153	
PUNCH (ABS Shown)	CAT. NO.	PRICE	CAT. NO.	PRICE
Round, pinned**	14048		13869	
Shape	2182		13870	
Optima® Coating	—		—	
GUIDE	CAT. NO.	PRICE	CAT. NO.	PRICE
Round	14072		14076	
Shape 0°	14073		14077	
Shape 0° & 45°	14075		14079	
Shape 0° & 90° (Option add 180° & 270°)	14074		14078	
STRIPPER	CAT. NO.	PRICE	CAT. NO.	PRICE
Round	13044		13045	
Shape	13143		13152	
DIE	CAT. NO.	PRICE		
Round Slug Hugger**	2192			
Round Standard	1808			
Shape Slug Hugger® 2*	12959			
Shape Positive	1817			
Shape Negative	1818			
DIE SHIM	CAT. NO.	PRICE		
.010" [0.25mm] Pack of 25	2208			
.030" [0.76mm] Pack of 25	2722			
.060" [1.5mm] Pack of 25	2172			

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

Additional charges may apply to non-standard features. See page 156.

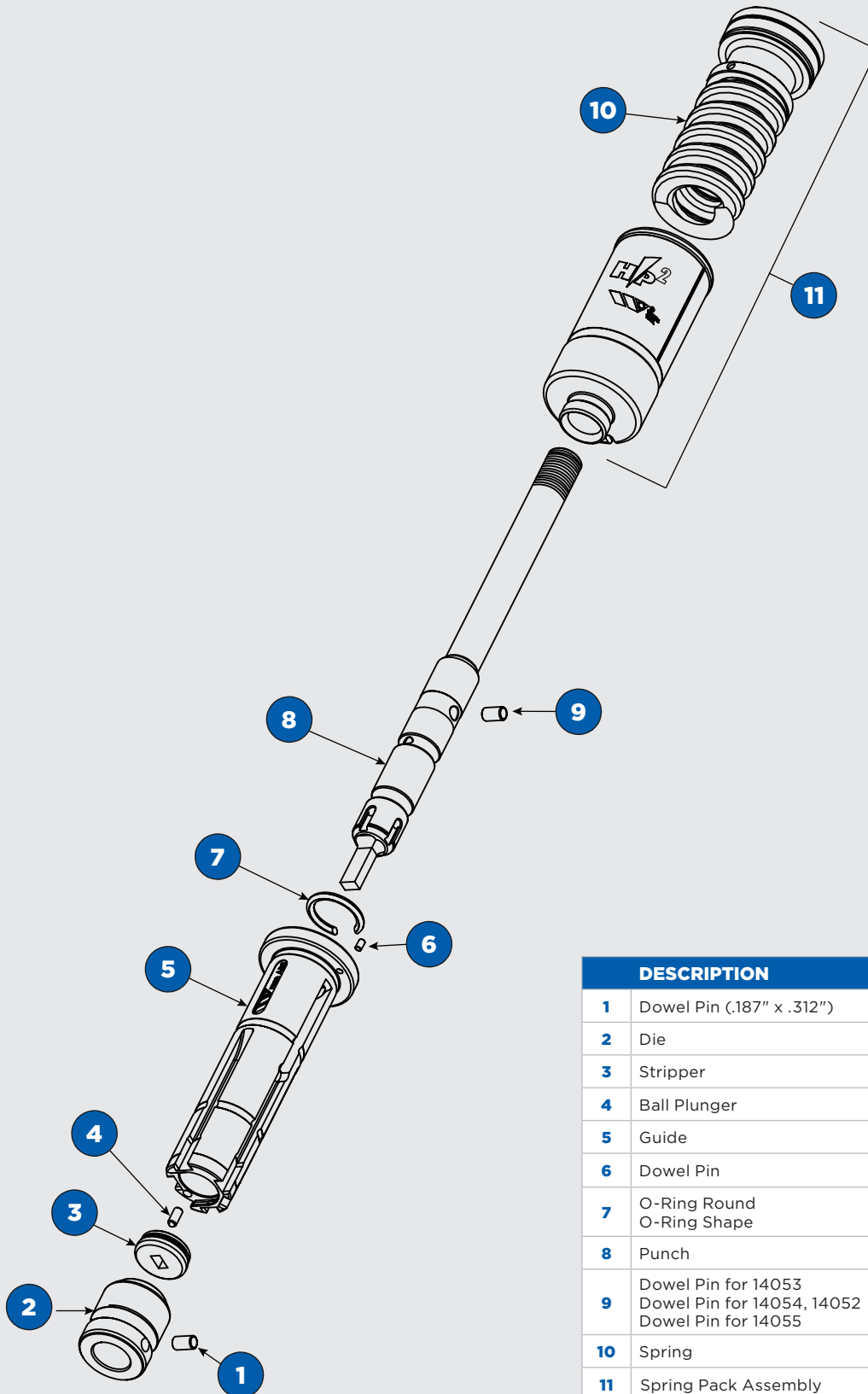
DESCRIPTION	A DIMENSION	MAX. MATERIAL THICKNESS	NOTES
HP2 is Wilson Tool's 'Better' product. It offers a great value with standard features like easy click length adjustment, high grade tool steel, ABS compatible.	.500" [12.7mm] 	.150" [3.81mm] 	**HP2 assemblies require a pinned round punch. Dies are available in Ultima® premium tool steel upon request.

STANDARD SHAPES Non-standard shapes available. See pages 136-142.



1/2" A METRIC STYLE

HP2 1/2" A STATION REPLACEMENT PARTS



	DESCRIPTION	CAT. NO.
1	Dowel Pin (.187" x .312")	6013
2	Die	See Opposite Page
3	Stripper	See Opposite Page
4	Ball Plunger	980973
5	Guide	See Opposite Page
6	Dowel Pin	6299
7	O-Ring Round O-Ring Shape	971303 13069
8	Punch	See Opposite Page
9	Dowel Pin for 14053 Dowel Pin for 14054, 14052 Dowel Pin for 14055	6015 974189 2150
10	Spring	24291
11	Spring Pack Assembly	14153

1/2" A

METRIC STYLE

HP2 1-1/4" ⓑ STATION – METRIC STYLE

1-1/4" ⓑ

METRIC STYLE



PUNCH AND GUIDE ASSEMBLY	CAT. NO.	PRICE	ABS	
			CAT. NO.	PRICE
Round	14056		14058	
Shape	14057		14059	
Optima® Coating	—		—	
Spring Pack Assembly	14172		14172	
PUNCH (ABS Shown)	CAT. NO.	PRICE	CAT. NO.	PRICE
Round, pinned**	14049		13871	
Shape	2184		13872	
Optima® Coating	—		—	
GUIDE	CAT. NO.	PRICE	CAT. NO.	PRICE
Round	14080		14084	
Shape 0°	14081		14085	
Shape 0° & 45°	14083		14087	
Shape 0° & 90° (Option add 180° & 270°)	14082		14086	
STRIPPER	CAT. NO.	PRICE	CAT. NO.	PRICE
Round	1890		2433	
Shape	1917		2432	
DIE	CAT. NO.	PRICE		
Round Slug Hugger**	2194			
Round Standard	2021			
Shape Slug Hugger® 2*	12961			
Shape Positive	2025			
Shape Negative	2026			
DIE SHIM	CAT. NO.	PRICE		
.010" [0.25mm] Pack of 25	2209			
.030" [0.76mm] Pack of 25	2724			
.060" [1.5mm] Pack of 25	2173			

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

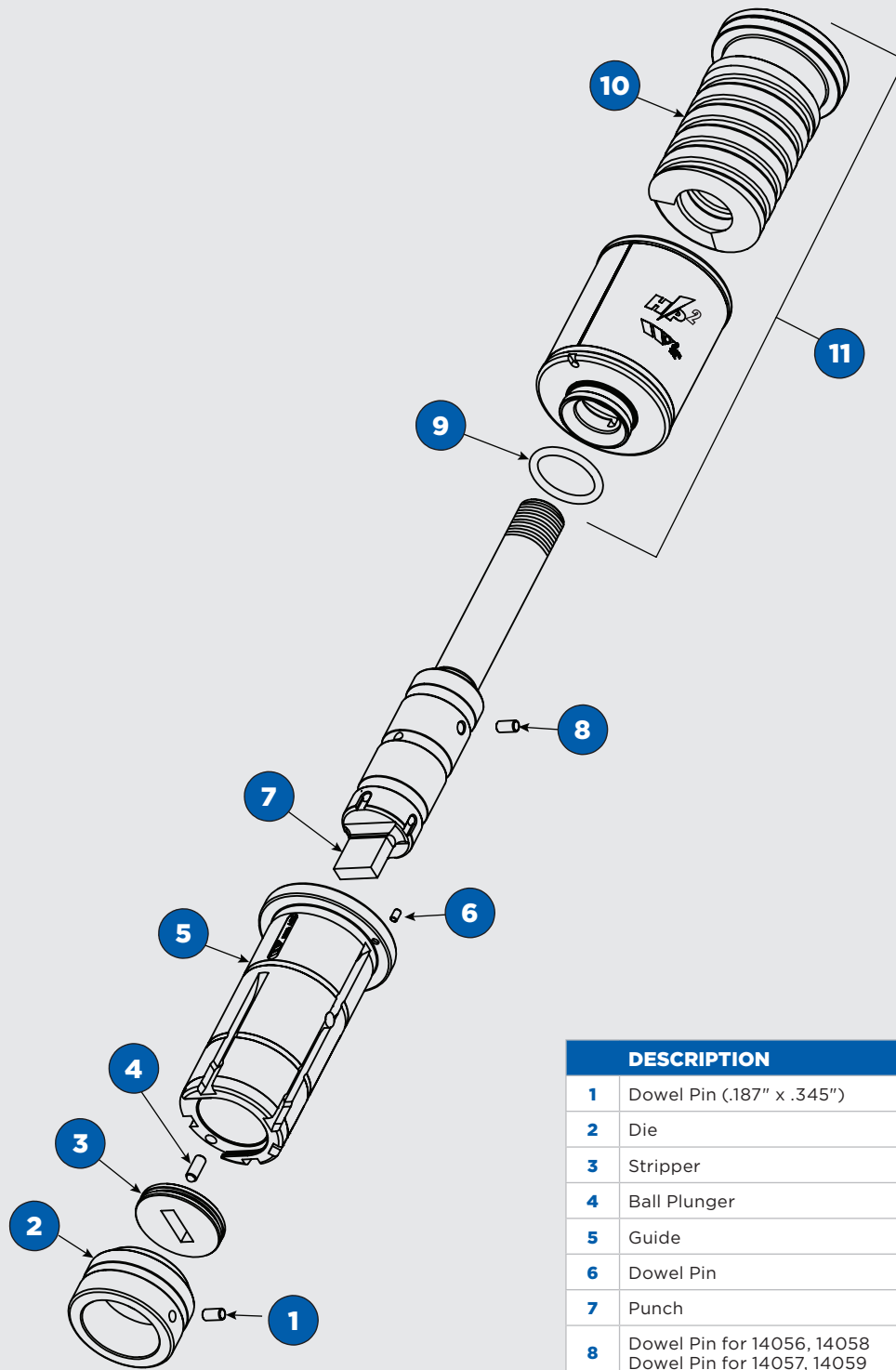
Additional charges may apply to non-standard features. See page 156.

DESCRIPTION	A DIMENSION	MAX. MATERIAL THICKNESS	NOTES
HP2 is Wilson Tool's 'Better' product. It offers a great value with standard features like easy click length adjustment, high grade tool steel, ABS compatible.	1.250" [31.75mm] 	.250" [6.35mm] 	**HP2 assemblies require a pinned round punch. Dies are available in Ultima® premium tool steel upon request.

STANDARD SHAPES Non-standard shapes available. See pages 136-142.



HP2 1-1/4" Ⓑ STATION REPLACEMENT PARTS



	DESCRIPTION	CAT. NO.
1	Dowel Pin (.187" x .345")	6431
2	Die	See Opposite Page
3	Stripper	See Opposite Page
4	Ball Plunger	980974
5	Guide	See Opposite Page
6	Dowel Pin	970651
7	Punch	See Opposite Page
8	Dowel Pin for 14056, 14058 Dowel Pin for 14057, 14059	974189 2131
9	O-Ring	971630
10	Spring	EH200-250
11	Spring Pack Assembly	14172

1-1/4" Ⓑ

METRIC STYLE

BASIX 1/2" A STATION – METRIC STYLE

1/2" A

METRIC STYLE



PUNCH AND GUIDE ASSEMBLY	CAT. NO.	PRICE	ABS	
			CAT. NO.	PRICE
Round	13057		13856	
Shape	13059		13858	
Optima* Coating	—		—	
PUNCH (ABS Shown)	CAT. NO.	PRICE	CAT. NO.	PRICE
Round	2183		13827	
Shape	2182		13870	
Optima* Coating	—		—	
GUIDE	CAT. NO.	PRICE	CAT. NO.	PRICE
Round	13065		13073	
Shape 0°	13066		13074	
Shape 0° & 45°	13067		13075	
Shape 0° & 90° (Option add 180° & 270°)	13068		13076	
STRIPPER	CAT. NO.	PRICE	CAT. NO.	PRICE
Round	13044		13045	
Shape	13143		13152	

DIE	CAT. NO.	PRICE
Round Slug Hugger**	2192	
Round Standard	1808	
Shape Slug Hugger® 2*	12959	
Shape Positive	1817	
Shape Negative	1818	

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

DIE SHIM	CAT. NO.	PRICE
.010" [0.25mm] Pack of 25	2208	
.030" [0.76mm] Pack of 25	2722	
.060" [1.5mm] Pack of 25	2172	

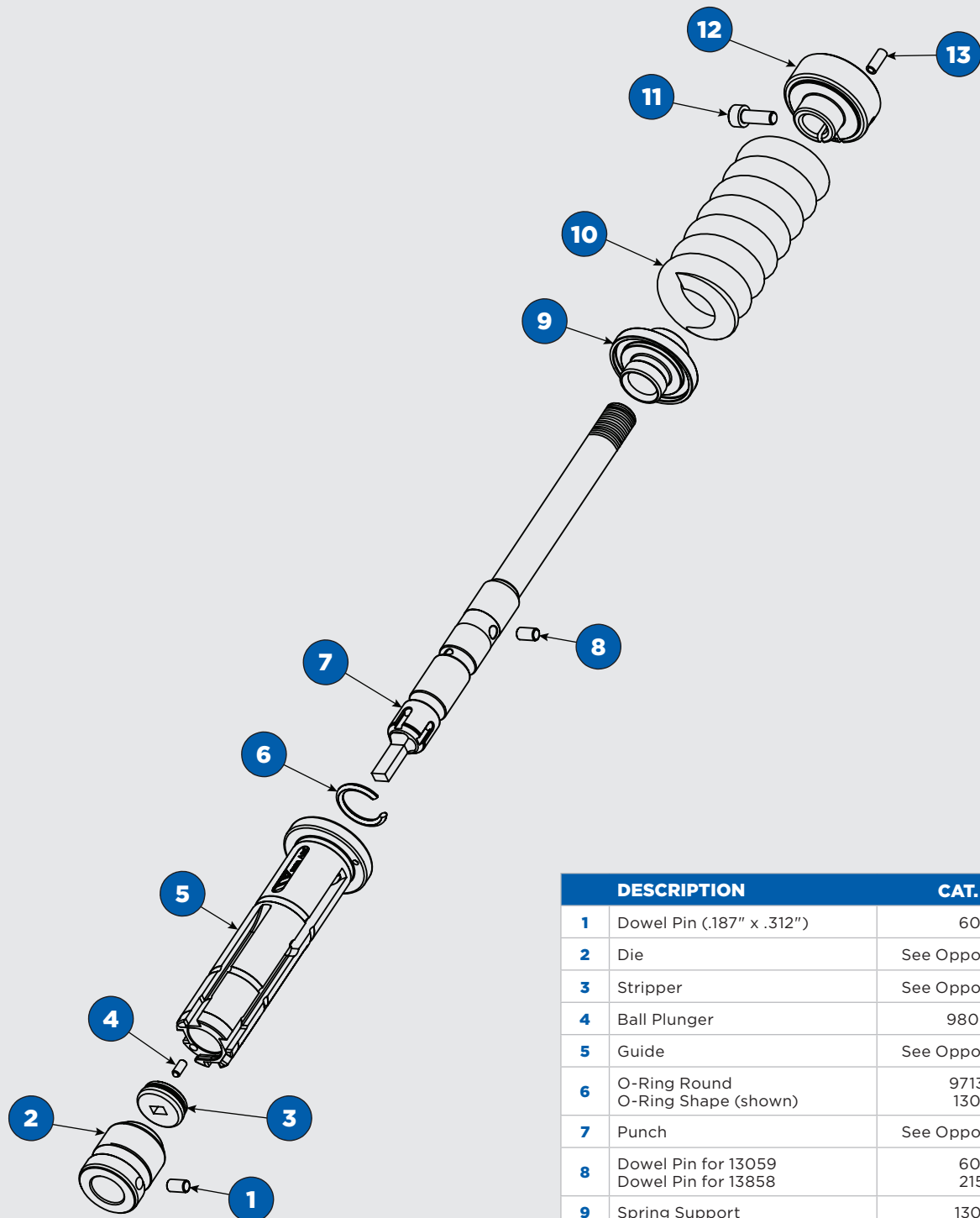
Additional charges may apply to non-standard features. See page 156.

DESCRIPTION	A DIMENSION	MAX. MATERIAL THICKNESS	NOTES
Basix assemblies are designed to deliver durability and performance at a lower cost with basic features. ABS compatible.	.500" [12.7mm] 	.150" [3.81mm] 	Dies are available in Ultima® premium tool steel upon request.

STANDARD SHAPES Non-standard shapes available. See pages 136-142.



BASIX 1/2" A STATION REPLACEMENT PARTS



DESCRIPTION	CAT. NO.
1 Dowel Pin (.187" x .312")	6013
2 Die	See Opposite Page
3 Stripper	See Opposite Page
4 Ball Plunger	980973
5 Guide	See Opposite Page
6 O-Ring Round O-Ring Shape (shown)	971303 13069
7 Punch	See Opposite Page
8 Dowel Pin for 13059 Dowel Pin for 13858	6015 2150
9 Spring Support	13078
10 Spring	13079
11 Socket Head Cap Screw [M5 x 14mm]	970476
12 Punch Head Assembly	14193
13 Polyurethane Plug	13868

1/2" A

METRIC STYLE

BASIX 1-1/4" ⓑ STATION – METRIC STYLE

1-1/4" ⓑ

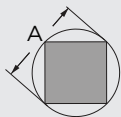
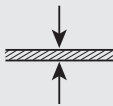
METRIC STYLE



PUNCH AND GUIDE ASSEMBLY	CAT. NO.	PRICE	ABS	
			CAT. NO.	PRICE
Round	13090		13860	
Shape	13092		13862	
Optima® Coating	—		—	
PUNCH (ABS Shown)	CAT. NO.	PRICE	CAT. NO.	PRICE
Round	2185		13828	
Shape	2184		13872	
Optima® Coating	—		—	
GUIDE	CAT. NO.	PRICE	CAT. NO.	PRICE
Round	13413		13097	
Shape 0°	13414		13098	
Shape 0° & 45°	13415		13099	
Shape 0° & 90° (Option add 180° & 270°)	13416		13100	
STRIPPER	CAT. NO.	PRICE	CAT. NO.	PRICE
Round	1890		2433	
Shape	1917		2432	
DIE	CAT. NO.	PRICE		
Round Slug Hugger**	2194			
Round Standard	2021			
Shape Slug Hugger® 2*	12961			
Shape Positive	2025			
Shape Negative	2026			
PUNCH SHIM	CAT. NO.	PRICE		
.060" [1.5mm] Pack of 25	98			
DIE SHIM	CAT. NO.	PRICE		
.010" [0.25mm] Pack of 25	2209			
.030" [0.76mm] Pack of 25	2724			
.060" [1.5mm] Pack of 25	2173			

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

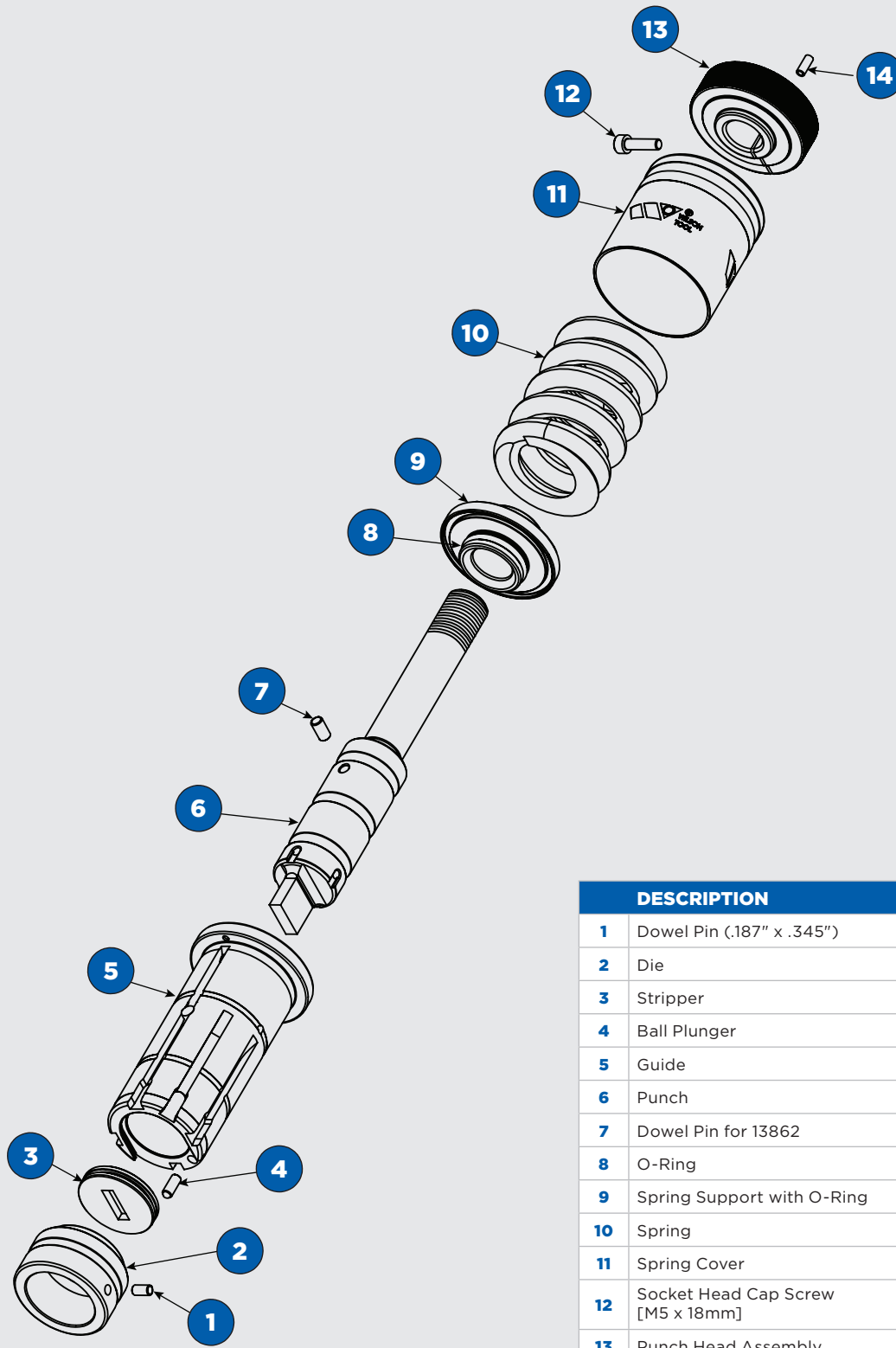
Additional charges may apply to non-standard features. See page 156.

DESCRIPTION	A DIMENSION	MAX. MATERIAL THICKNESS	NOTES
Basix assemblies are designed to deliver durability and performance at a lower cost with basic features. ABS compatible.	1.250" [31.75mm] 	.250" [6.35mm] 	Dies are available in Ultima® premium tool steel upon request.

STANDARD SHAPES Non-standard shapes available. See pages 136-142.



BASIX 1-1/4" Ⓑ STATION REPLACEMENT PARTS



	DESCRIPTION	CAT. NO.
1	Dowel Pin (.187" x .345")	6431
2	Die	See Opposite Page
3	Stripper	See Opposite Page
4	Ball Plunger	980974
5	Guide	See Opposite Page
6	Punch	See Opposite Page
7	Dowel Pin for 13862	2131
8	O-Ring	971630
9	Spring Support with O-Ring	13411
10	Spring	35122
11	Spring Cover	2732
12	Socket Head Cap Screw [M5 x 18mm]	6449
13	Punch Head Assembly	14195
14	Polyurethane Plug	13868

1-1/4" Ⓑ

METRIC STYLE

METRIC STYLE



THICK TURRET TOOLING SOLUTIONS



LARGE STATION ADVANTAGES	HP	STANDARD	BASIX
Up to 50% more bearing surface to reduce side loading	●	●	●
Internal and external lubrication	●	●	●
External keyways at 0°, 90° and 225°	●	●	●
OEM compatible	●	●	●
Punches made from premium hardened tool steel	●	●	●
Optima® coated punches available	●	●	●
Relieved strippers for maximum grind life	●	●	●
Made from hardened tool steel for increased durability	●	●	
Optima® coated keys for superior wear resistance	●	●	
Fast and simple push button length adjustment	●	●	
ABS machine lubrication capability	●	●	
Push button lock release for quick stripper plate removal	●		

HP 2" Ⓢ STATION – METRIC STYLE

2" Ⓢ

METRIC STYLE



GUIDE ASSEMBLY

PUNCH
(M14 ABS shown)

STRIPPER

DIE

SHIM



GUIDE ASSEMBLY	CAT. NO.	PRICE
Assembly M-12	5577	
ABS Assembly M-14	13829	
PUNCH (M14 ABS Shown)	CAT. NO.	PRICE
Round M12 Thread	1933	
Round ABS M14 Thread	13614	
Shape M12 Thread	1934	
Shape ABS M14 Thread	13615	
Optima® Coating	–	
STRIPPER	CAT. NO.	PRICE
Round	1848	
Shape	1854	
Round ABS	5150	
Shape ABS	5151	
DIE	CAT. NO.	PRICE
Round Slug Hugger**	2196	
Round Standard	1850	
Shape Slug Hugger® 2*	12964	
Shape Positive	1855	
Shape Negative	1856	

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

DIE SHIM	CAT. NO.	PRICE
.010" [0.25mm] Pack of 10	2210	
.030" [0.76mm] Pack of 10	2726	
.060" [1.5mm] Pack of 10	2174	

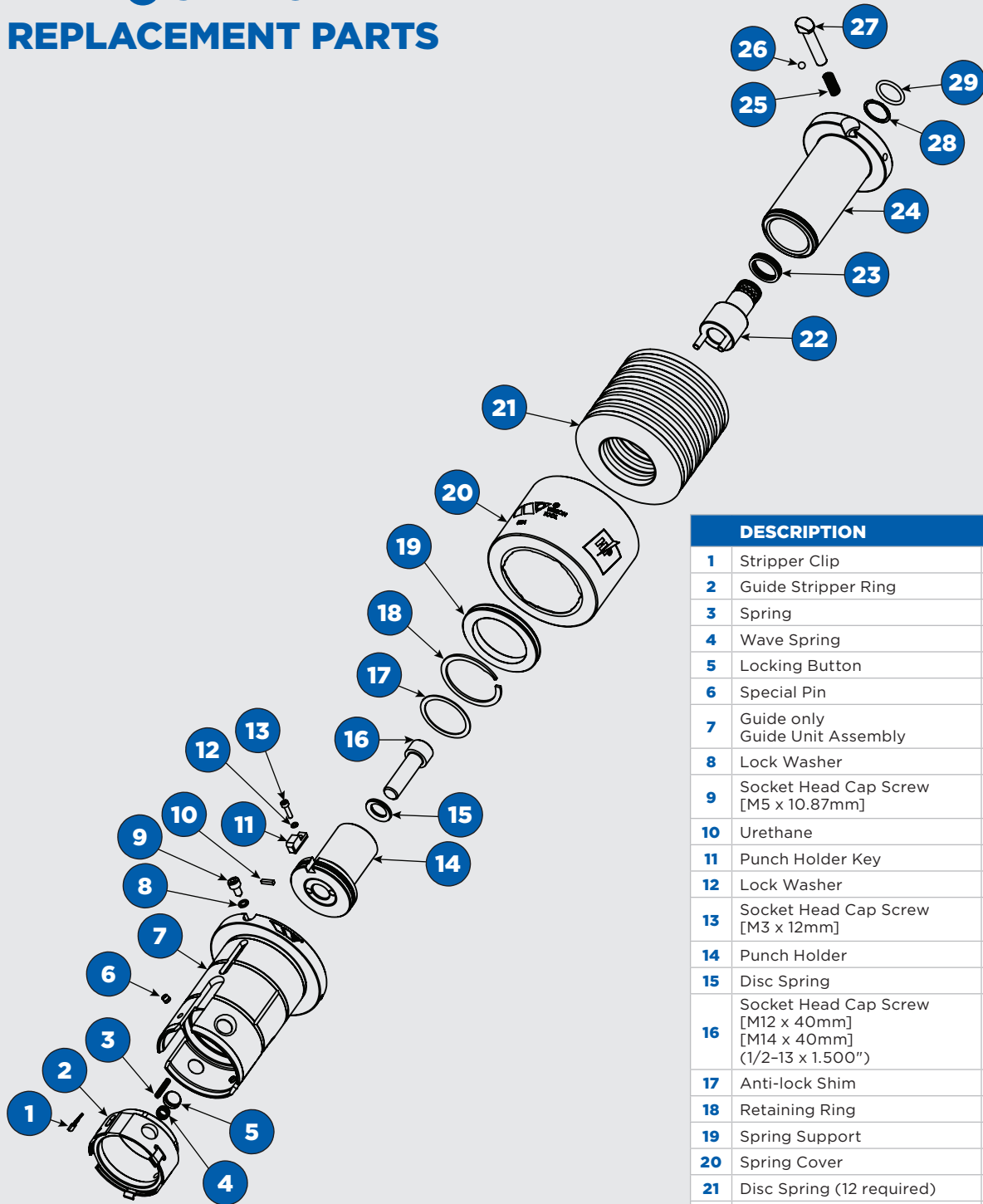
Additional charges may apply to non-standard features. See page 156.

DESCRIPTION	MAXIMUM A DIMENSION	MAXIMUM MATERIAL THICKNESS	NOTES
Push button release for quick stripper plate removal. Guide assemblies are keyed for shapes at 0°, 90° and 225°.	2.000" [50.8mm] 	.250" [6.35mm] 	<ul style="list-style-type: none"> All punches shipped with no shear unless specified 5577 assembly includes 1/2-13 bolt 13829 assembly includes M-12 bolt Dies are available in Ultima® premium tool steel upon request Compatible with M12 & 1/2-13 punches

STANDARD SHAPES Non-standard shapes available. See pages 136-142.



HP 2" Ⓢ STATION REPLACEMENT PARTS



Cat. No. 5509 Guide Unit Assembly includes:
1, 2, 3, 4, 5, 6, 8 & 9

Cat. No. 5724 Driver Assembly includes:
18, 19, 20, 21, 22, 23, 24, 25, 26, 27, 28 & 29

	DESCRIPTION	CAT. NO.
1	Stripper Clip	5521
2	Guide Stripper Ring	5520
3	Spring	971694
4	Wave Spring	8140
5	Locking Button	5519
6	Special Pin	5522
7	Guide only Guide Unit Assembly	5518 5509
8	Lock Washer	2112
9	Socket Head Cap Screw [M5 x 10.87mm]	5197
10	Urethane	2020643
11	Punch Holder Key	5373
12	Lock Washer	6327
13	Socket Head Cap Screw [M3 x 12mm]	6326
14	Punch Holder	5556
15	Disc Spring	971690
16	Socket Head Cap Screw [M12 x 40mm] [M14 x 40mm] (1/2-13 x 1.500")	6605 13843 6606
17	Anti-lock Shim	5412
18	Retaining Ring	972570
19	Spring Support	5748
20	Spring Cover	5517
21	Disc Spring (12 required)	5744
22	Adjustment Shaft	5735
23	Wave Spring	971692
24	Punch Driver	5736
25	Spring	972396
26	Adjustment Locking Ball	972420
27	Driver Lock Button	10539
28	Retaining Ring	972441
29	O-Ring	972430

2" Ⓢ

METRIC STYLE

HP 3-1/2" ⓓ STATION – METRIC STYLE

3-1/2" ⓓ

METRIC STYLE



GUIDE ASSEMBLY	CAT. NO.	PRICE
Assembly M-12	5578	
ABS Assembly M-14	13830	
PUNCH (M14 ABS Shown)	CAT. NO.	PRICE
Round M12 Thread	1937	
Round ABS M14 Thread	13616	
Shape M12 Thread	1938	
Shape ABS M14 Thread	13617	
Optima® Coating	–	
STRIPPER	CAT. NO.	PRICE
Round	1864	
Shape	1869	
Round ABS	5152	
Shape ABS	5153	
DIE	CAT. NO.	PRICE
Round Slug Hugger**	2198	
Round Standard	1865	
Shape Slug Hugger® 2*	12965	
Shape Positive	1870	
Shape Negative	1871	

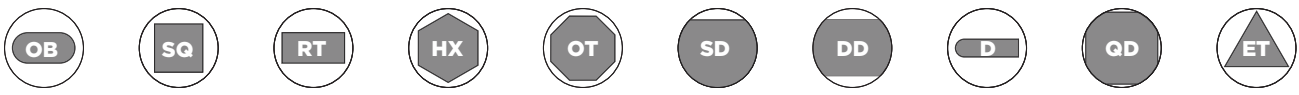
*Slug Hugger® dies must be ordered punch size plus clearance. Size restrictions apply.

DIE SHIM	CAT. NO.	PRICE
.010" [0.25mm] Pack of 5	2211	
.030" [0.76mm] Pack of 5	2728	
.060" [1.5mm] Pack of 5	2175	

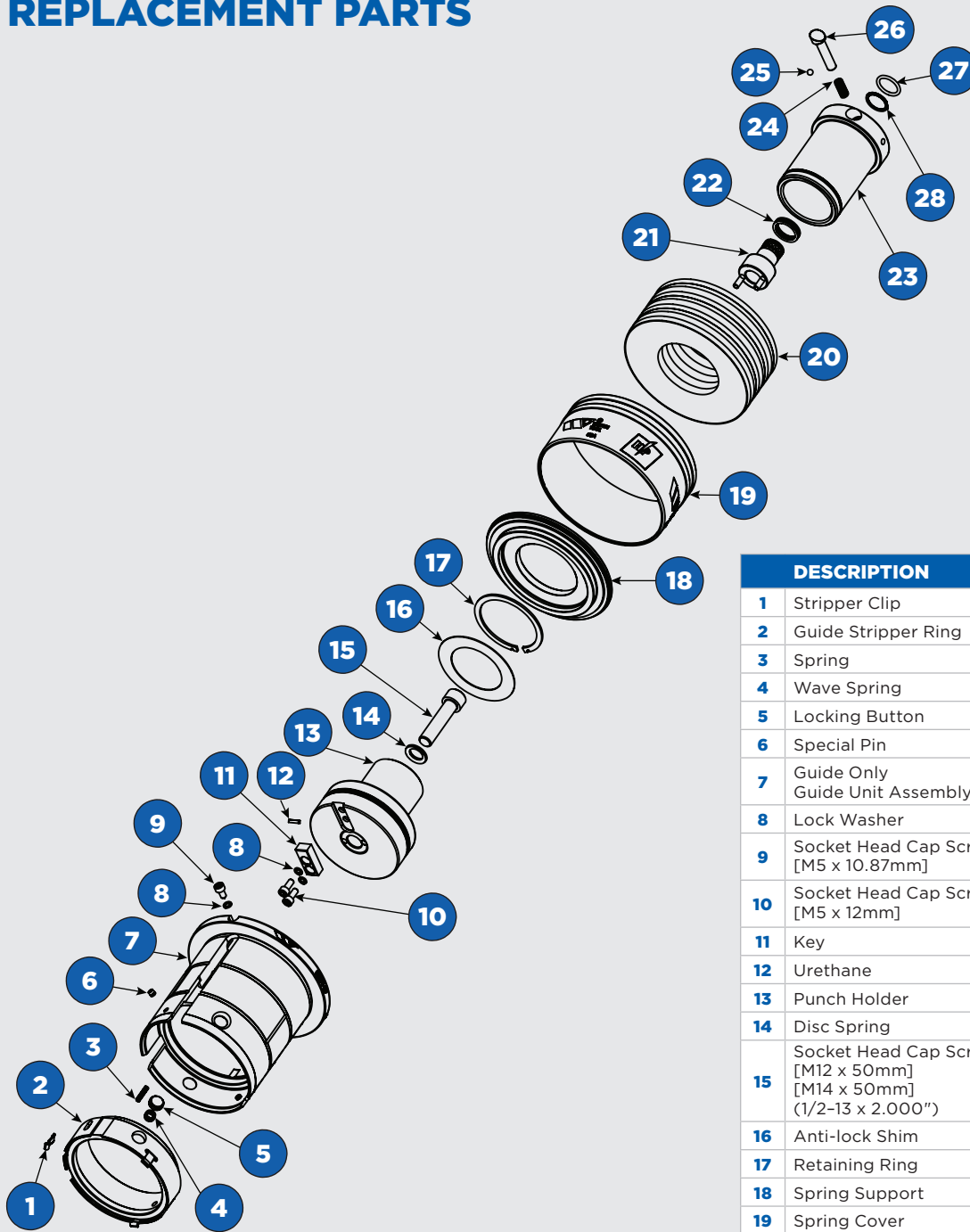
Additional charges may apply to non-standard features. See page 156.

DESCRIPTION	MAXIMUM A DIMENSION	MAXIMUM MATERIAL THICKNESS	NOTES
Push button release for quick stripper plate removal. Guide assemblies are keyed for shapes at 0°, 90° and 225°.	3.500" [88.9mm]	.250" [6.35mm]	<ul style="list-style-type: none"> .062" [1.6mm] rooftop shear is given to all punches with A Dimension > 2.000" [50.8mm] and width > .250" [6.35mm] 5578 assembly includes 1/2-13 bolt 13830 assembly includes M-12 bolt Dies available in Ultima® premium tool steel upon request Compatible with M12 & 1/2-13 punches

STANDARD SHAPES Non-standard shapes available. See pages 136-142.



HP 3-1/2" ⌀ STATION REPLACEMENT PARTS



Cat. No. 5524 Guide Unit Assembly includes:
1, 2, 3, 4, 5, 6, 8 & 9

Cat. No. 5725 Driver Assembly includes:
17, 18, 19, 20, 21, 22, 23, 24, 25, 26, 27 & 28

DESCRIPTION	CAT. NO.
1 Stripper Clip	5521
2 Guide Stripper Ring	5528
3 Spring	971694
4 Wave Spring	8140
5 Locking Button	5519
6 Special Pin	5522
7 Guide Only Guide Unit Assembly	5527 5524
8 Lock Washer	2112
9 Socket Head Cap Screw [M5 x 10.87mm]	5197
10 Socket Head Cap Screw [M5 x 12mm]	6110
11 Key	1862
12 Urethane	2020643
13 Punch Holder	5558
14 Disc Spring	971690
15 Socket Head Cap Screw [M12 x 50mm] [M14 x 50mm] (1/2-13 x 2.000")	970467 13844 6325
16 Anti-lock Shim	5413
17 Retaining Ring	5747
18 Spring Support	5738
19 Spring Cover	5561
20 Disc Spring (7 required)	5449
21 Adjustment Shaft	5739
22 Spring	971692
23 Punch Driver	5740
24 Spring	972396
25 Adjustment Locking Ball	972420
26 Index Button	5737
27 O-Ring	972430
28 Retaining Ring	972441

3-1/2" ⌀

METRIC STYLE

HP 4-1/2" ⓔ STATION – METRIC STYLE



GUIDE ASSEMBLY



PUNCH
(M14 ABS shown)



STRIPPER



DIE



SHIM

GUIDE ASSEMBLY	CAT. NO.	PRICE
Assembly M-12	5579	
ABS Assembly M-14	13831	
PUNCH (M14 ABS Shown)	CAT. NO.	PRICE
Round M12 Thread	1941	
Round ABS M14 Thread	13618	
Shape M12 Thread	1942	
Shape ABS M14 Thread	13619	
Optima® Coating	–	
STRIPPER	CAT. NO.	PRICE
Round	1877	
Shape	1882	
Round ABS	5154	
Shape ABS	5155	
DIE	CAT. NO.	PRICE
Round Slug Hugger**	2200	
Round Standard	1878	
Shape Slug Hugger* 2*	12967	
Shape Positive	1883	
Shape Negative	1884	

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

DIE SHIM	CAT. NO.	PRICE
.010" [0.25mm] Pack of 5	2212	
.030" [0.76mm] Pack of 5	2730	
.060" [1.5mm] Pack of 5	2176	

Additional charges may apply to non-standard features. See page 156.

DESCRIPTION	MAXIMUM A DIMENSION	MAXIMUM MATERIAL THICKNESS	NOTES
Push button release for quick stripper plate removal. Guide assemblies are keyed for shapes at 0°, 90° and 225°.	4.500" [114.3mm] 	.250" [6.35mm] 	<ul style="list-style-type: none"> .062" [1.6mm] rooftop shear is given to all punches with A Dimension > 2.000" [50.8mm] and width > .250" [6.35mm] 5579 includes 1/2-13 bolt 13831 includes M-12 Bolt Dies available in Ultima® premium tool steel upon request Compatible with M12 & 1/2-13 punches

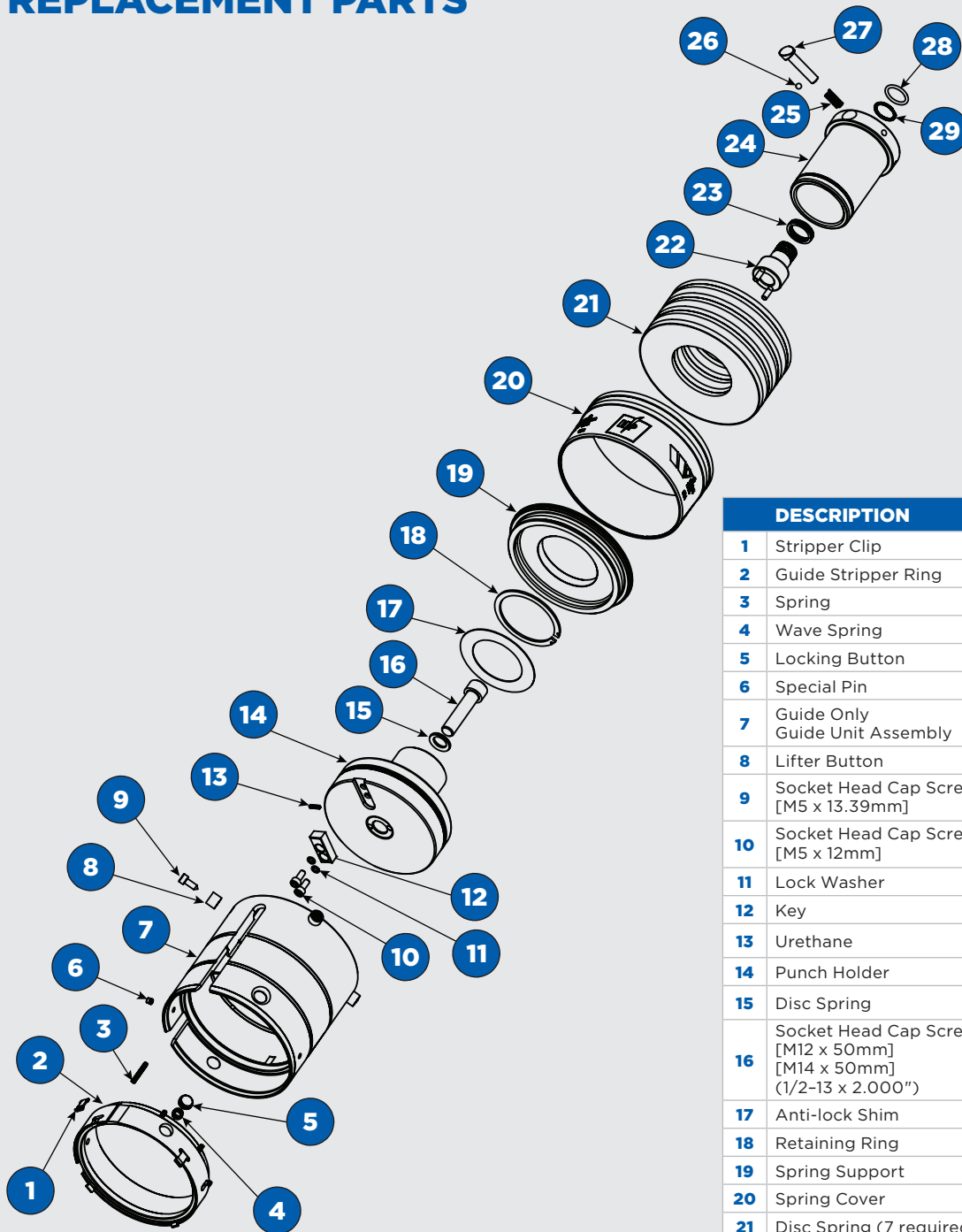
STANDARD SHAPES Non-standard shapes available. See pages 136-142.



4-1/2" ⓔ

METRIC STYLE

HP 4-1/2" Ⓜ STATION REPLACEMENT PARTS



Cat. No. 5534 Guide Unit Assembly includes:
1, 2, 3, 4, 5, 6, 8 & 9

Cat. No. 5726 Driver Assembly includes:
18, 19, 20, 21, 22, 23, 24, 25, 26, 27, 28 & 29

	DESCRIPTION	CAT. NO.
1	Stripper Clip	5521
2	Guide Stripper Ring	5538
3	Spring	971694
4	Wave Spring	8140
5	Locking Button	5519
6	Special Pin	5522
7	Guide Only Guide Unit Assembly	5537 5534
8	Lifter Button	5209
9	Socket Head Cap Screw [M5 x 13.39mm]	5210
10	Socket Head Cap Screw [M5 x 12mm]	6110
11	Lock Washer	2112
12	Key	1862
13	Urethane	2020643
14	Punch Holder	5560
15	Disc Spring	971690
16	Socket Head Cap Screw (2) [M12 x 50mm] [M14 x 50mm] (1/2-13 x 2.000")	970467 13844 6325
17	Anti-lock Shim	5413
18	Retaining Ring	5747
19	Spring Support	5741
20	Spring Cover	5561
21	Disc Spring (7 required)	5449
22	Adjustment Shaft	5739
23	Wave Spring	971692
24	Punch Driver	5742
25	Spring	972396
26	Adjustment Locking Ball	972420
27	Index Button	5737
28	O-Ring	972430
29	Retaining Ring	972441

4-1/2" Ⓜ

METRIC STYLE

STANDARD 2" Ⓢ STATION – METRIC STYLE

2" Ⓢ

METRIC STYLE



GUIDE ASSEMBLY

PUNCH (M14 ABS shown)

STRIPPER

DIE

SHIM



GUIDE ASSEMBLY	CAT. NO.	PRICE
ABS Assembly M-14	13084	
WLS Assembly M-12	5592	
PUNCH (M14 ABS Shown)	CAT. NO.	PRICE
Round M12 Thread	1933	
Round ABS M14 Thread	13614	
Shape M12 Thread	1934	
Shape ABS M14 Thread	13615	
Optima® Coating	–	
STRIPPER	CAT. NO.	PRICE
Round	1848	
Shape	1854	
Round ABS	5150	
Shape ABS	5151	
DIE	CAT. NO.	PRICE
Round Slug Hugger**	2196	
Round Standard	1850	
Shape Slug Hugger® 2*	12964	
Shape Positive	1855	
Shape Negative	1856	

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

DIE SHIM	CAT. NO.	PRICE
.010" [0.25mm] Pack of 10	2210	
.030" [0.76mm] Pack of 10	2726	
.060" [1.5mm] Pack of 10	2174	

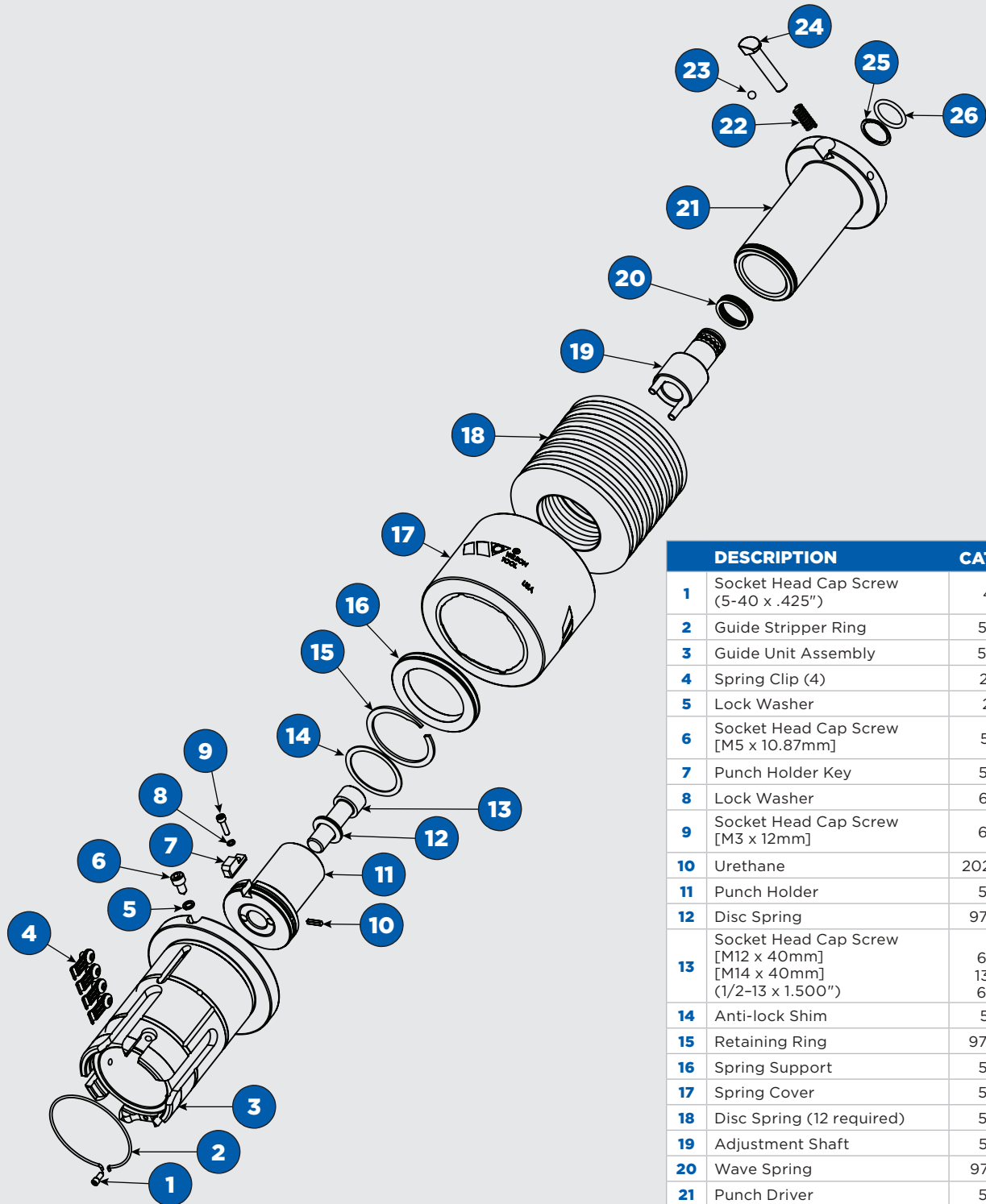
Additional charges may apply to non-standard features. See page 156.

DESCRIPTION	MAXIMUM A DIMENSION	MAXIMUM MATERIAL THICKNESS	NOTES
Standard assembly strippers are held in by a stripper ring or clips. Guide assemblies are keyed for shapes at 0°, 90° and 225°.	2.000" [50.8mm] 	.250" [6.35mm] 	<ul style="list-style-type: none"> All punches shipped with no shear unless specified. Full assemblies ship with guide stripper ring installed; Spring clips are also included 5583 and 5592 include 1/2-13 bolt 13084 includes M-12 bolt Dies available in Ultima® premium tool steel upon request Compatible with M12 & 1/2-13 punches

STANDARD SHAPES Non-standard shapes available. See pages 136-142.



STANDARD 2" Ⓞ STATION REPLACEMENT PARTS



Cat. No. 5420 Guide Unit Assembly includes:
1, 2, 4, 5, & 6

Cat. No. 5729 Driver Assembly includes:
15, 16, 17, 18, 19, 20, 21, 22, 23, 24, 25 & 26

	DESCRIPTION	CAT. NO.
1	Socket Head Cap Screw (5-40 x .425")	429
2	Guide Stripper Ring	5035
3	Guide Unit Assembly	5420
4	Spring Clip (4)	2810
5	Lock Washer	2112
6	Socket Head Cap Screw [M5 x 10.87mm]	5197
7	Punch Holder Key	5373
8	Lock Washer	6327
9	Socket Head Cap Screw [M3 x 12mm]	6326
10	Urethane	2020643
11	Punch Holder	5556
12	Disc Spring	971690
13	Socket Head Cap Screw [M12 x 40mm] [M14 x 40mm] (1/2-13 x 1.500")	6605 13843 6606
14	Anti-lock Shim	5412
15	Retaining Ring	972570
16	Spring Support	5748
17	Spring Cover	5693
18	Disc Spring (12 required)	5744
19	Adjustment Shaft	5735
20	Wave Spring	971692
21	Punch Driver	5736
22	Spring	972396
23	Adjustment Locking Ball	972420
24	Driver Lock Button	10539
25	Retaining Ring	972441
26	O-Ring	972430

STANDARD 3-1/2" ⓓ STATION – METRIC STYLE



GUIDE ASSEMBLY

PUNCH
(M14 ABS shown)

STRIPPER

DIE

SHIM

GUIDE ASSEMBLY	CAT. NO.	PRICE
ABS Assembly M-14	13085	
WLS Assembly M-12	5593	
PUNCH (M14 ABS Shown)	CAT. NO.	PRICE
Round M12 Thread	1937	
Round ABS M14 Thread	13616	
Shape M12 Thread	1938	
Shape ABS M14 Thread	13617	
Optima® Coating	–	
STRIPPER	CAT. NO.	PRICE
Round	1864	
Shape	1869	
Round ABS	5152	
Shape ABS	5153	
DIE	CAT. NO.	PRICE
Round Slug Hugger**	2198	
Round Standard	1865	
Shape Slug Hugger® 2*	12965	
Shape Positive	1870	
Shape Negative	1871	

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

DIE SHIM	CAT. NO.	PRICE
.010" [0.25mm] Pack of 5	2211	
.030" [0.76mm] Pack of 5	2728	
.060" [1.5mm] Pack of 5	2175	

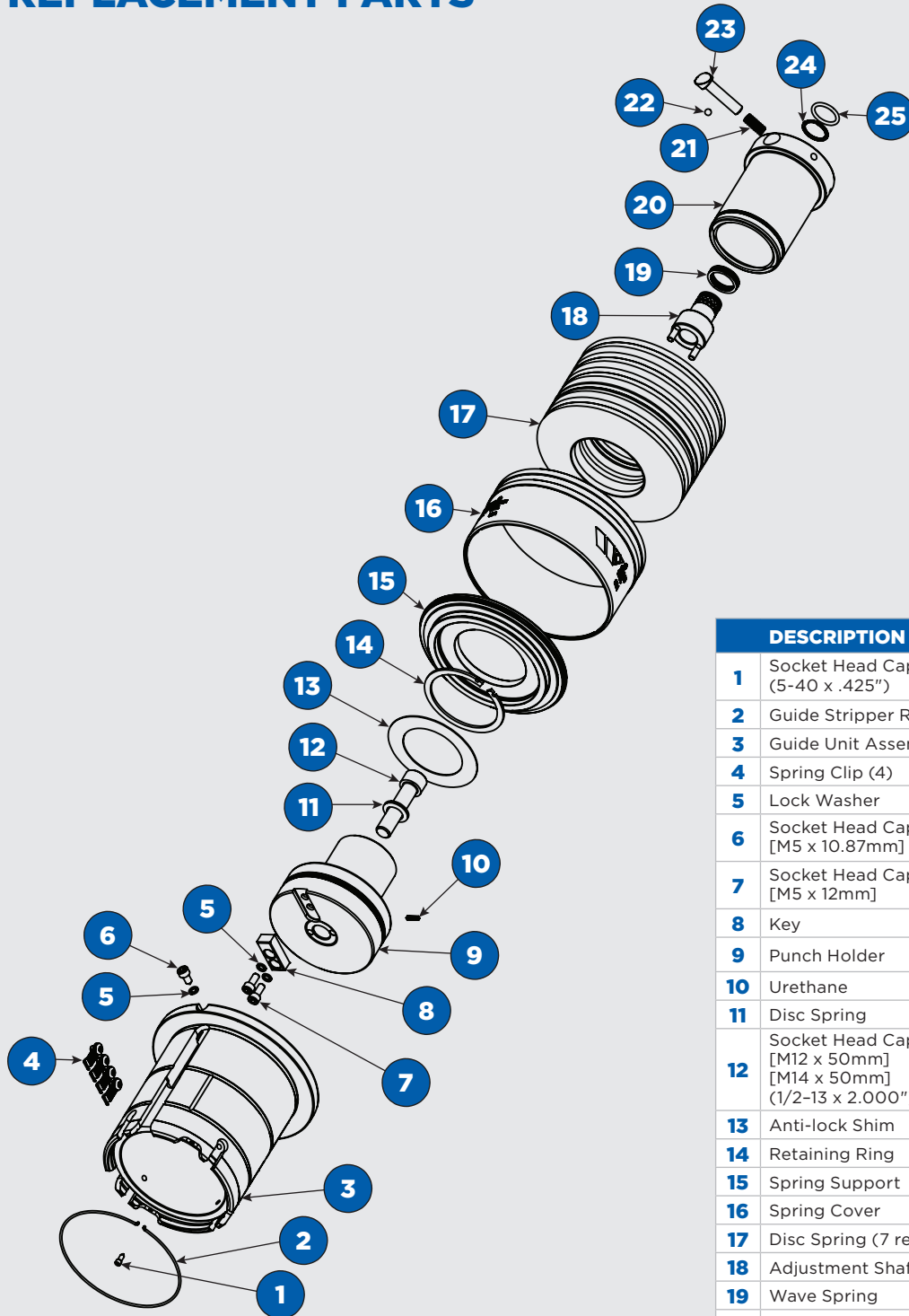
Additional charges may apply to non-standard features. See page 156.

DESCRIPTION	MAXIMUM A DIMENSION	MAXIMUM MATERIAL THICKNESS	NOTES
Standard assembly strippers are held in by a stripper ring or clips. Guide assemblies are keyed for shapes at 0°, 90° and 225°.	3.500" [88.9mm] 	.250" [6.35mm] 	<ul style="list-style-type: none"> .062" [1.6mm] rooftop shear is given to all punches with A Dimension > 2.000" [50.8mm] and width > .250" [6.35mm] 5584 and 5593 include 1/2-13 bolt 13085 includes M-12 bolt Dies available in Ultima® premium tool steel upon request Compatible with M12 & 1/2-13 punches

STANDARD SHAPES Non-standard shapes available. See pages 136-142.



STANDARD 3-1/2" Ⓟ STATION REPLACEMENT PARTS



Cat. No. 5430 Guide Unit Assembly includes:
1, 2, 4, 5, & 6

Cat. No. 5730 Driver Assembly includes:
14, 15, 16, 17, 18, 19, 20, 21, 22, 23, 24, & 25

	DESCRIPTION	CAT. NO.
1	Socket Head Cap Screw (5-40 x .425")	429
2	Guide Stripper Ring	5036
3	Guide Unit Assembly	5430
4	Spring Clip (4)	2810
5	Lock Washer	2112
6	Socket Head Cap Screw [M5 x 10.87mm]	5197
7	Socket Head Cap Screw [M5 x 12mm]	6110
8	Key	1862
9	Punch Holder	5558
10	Urethane	2020643
11	Disc Spring	971690
12	Socket Head Cap Screw (2) [M12 x 50mm] [M14 x 50mm] (1/2-13 x 2.000")	970467 13844 6325
13	Anti-lock Shim	5413
14	Retaining Ring	5747
15	Spring Support	5738
16	Spring Cover	5423
17	Disc Spring (7 required)	5449
18	Adjustment Shaft	5739
19	Wave Spring	971692
20	Punch Driver	5740
21	Spring	972396
22	Adjustment Locking Ball	972420
23	Index Button	5737
24	Retaining Ring	972441
25	O-Ring	972430

3-1/2" Ⓟ

METRIC STYLE

STANDARD 4-1/2" ⓔ STATION – METRIC STYLE

4-1/2" ⓔ

METRIC STYLE



GUIDE ASSEMBLY	CAT. NO.	PRICE
ABS Assembly M-14	13088	
WLS Assembly M-12	5594	
PUNCH (M14 ABS Shown)	CAT. NO.	PRICE
Round M12 Thread	1941	
Round ABS M14 Thread	13618	
Shape M12 Thread	1942	
Shape ABS M14 Thread	13619	
Optima® Coating	–	
STRIPPER	CAT. NO.	PRICE
Round	1877	
Shape	1882	
Round ABS	5154	
Shape ABS	5155	
DIE	CAT. NO.	PRICE
Round Slug Hugger**	2200	
Round Standard	1878	
Shape Slug Hugger® 2*	12967	
Shape Positive	1883	
Shape Negative	1884	

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

DIE SHIM	CAT. NO.	PRICE
.010" [0.25mm] Pack of 5	2212	
.030" [0.76mm] Pack of 5	2730	
.060" [1.5mm] Pack of 5	2176	

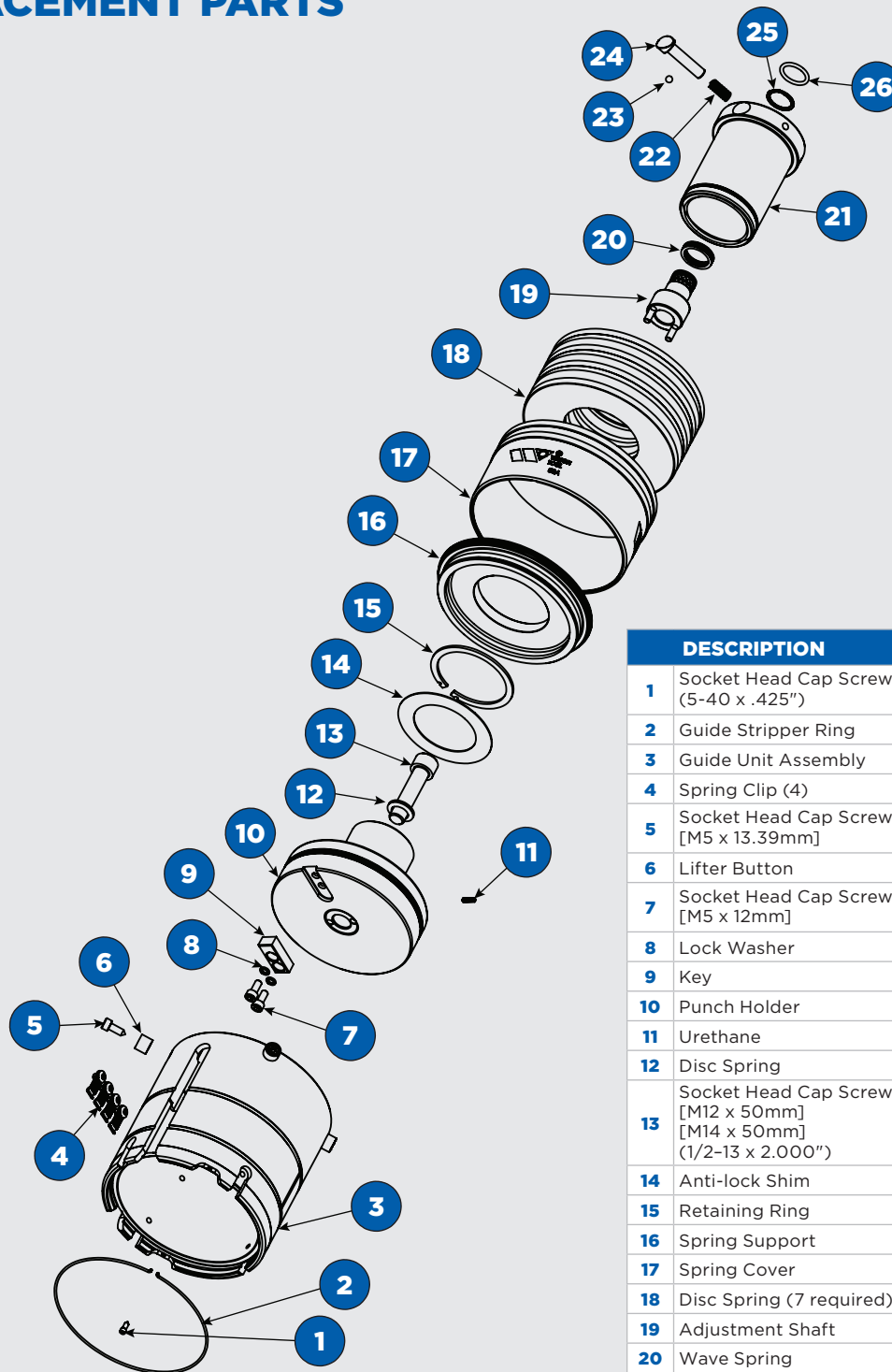
Additional charges may apply to non-standard features. See page 156.

DESCRIPTION	MAXIMUM A DIMENSION	MAXIMUM MATERIAL THICKNESS	NOTES
Standard assembly strippers are held in by a stripper ring or clips. Guide assemblies are keyed for shapes at 0°, 90° and 225°.	4.500" [114.3mm] 	.250" [6.35mm] 	<ul style="list-style-type: none"> .062" [1.6mm] rooftop shear is given to all punches with A Dimension > 2.000" [50.8mm] and width > .250" [6.35mm] 5585 and 5594 include 1/2-13 bolt 13088 includes M-12 bolt Dies available in Ultima® premium tool steel upon request Compatible with M12 & 1/2-13 punches

STANDARD SHAPES Non-standard shapes available. See pages 136-142.



STANDARD 4-1/2" Ⓜ STATION REPLACEMENT PARTS



Cat. No. 5438 Guide Unit Assembly includes:
1, 2, 4, 5 & 6

Cat. No 5731 Driver Assembly includes:
15, 16, 17, 18, 19, 20, 21, 22, 23, 24, 25 & 26

	DESCRIPTION	CAT. NO.
1	Socket Head Cap Screw (5-40 x .425")	429
2	Guide Stripper Ring	5037
3	Guide Unit Assembly	5438
4	Spring Clip (4)	2810
5	Socket Head Cap Screw [M5 x 13.39mm]	5210
6	Lifter Button	5209
7	Socket Head Cap Screw [M5 x 12mm]	6110
8	Lock Washer	2112
9	Key	1862
10	Punch Holder	5560
11	Urethane	2020643
12	Disc Spring	971690
13	Socket Head Cap Screw [M12 x 50mm] [M14 x 50mm] (1/2-13 x 2.000")	970467 13844 6325
14	Anti-lock Shim	5413
15	Retaining Ring	5747
16	Spring Support	5741
17	Spring Cover	5423
18	Disc Spring (7 required)	5449
19	Adjustment Shaft	5739
20	Wave Spring	971692
21	Punch Driver	5742
22	Spring	972396
23	Adjustment Locking Ball	972420
24	Index Button	5737
25	Retaining Ring	972441
26	O-Ring	972430

4-1/2" Ⓜ

METRIC STYLE

BASIX 2" Ⓞ STATION – METRIC STYLE

2" Ⓞ

METRIC STYLE



GUIDE ASSEMBLY	CAT. NO.	PRICE
Assembly	1842	
PUNCH	CAT. NO.	PRICE
Round M12 Thread	1933	
Shape M12 Thread	1934	
Optima® Coating	—	
STRIPPER	CAT. NO.	PRICE
Round	1848	
Shape	1854	
DIE	CAT. NO.	PRICE
Round Slug Hugger**	2196	
Round Standard	1850	
Shape Slug Hugger® 2*	12964	
Shape Positive	1855	
Shape Negative	1856	

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

DIE SHIM	CAT. NO.	PRICE
.010" [0.25mm] Pack of 10	2210	
.030" [0.76mm] Pack of 10	2726	
.060" [1.5mm] Pack of 10	2174	

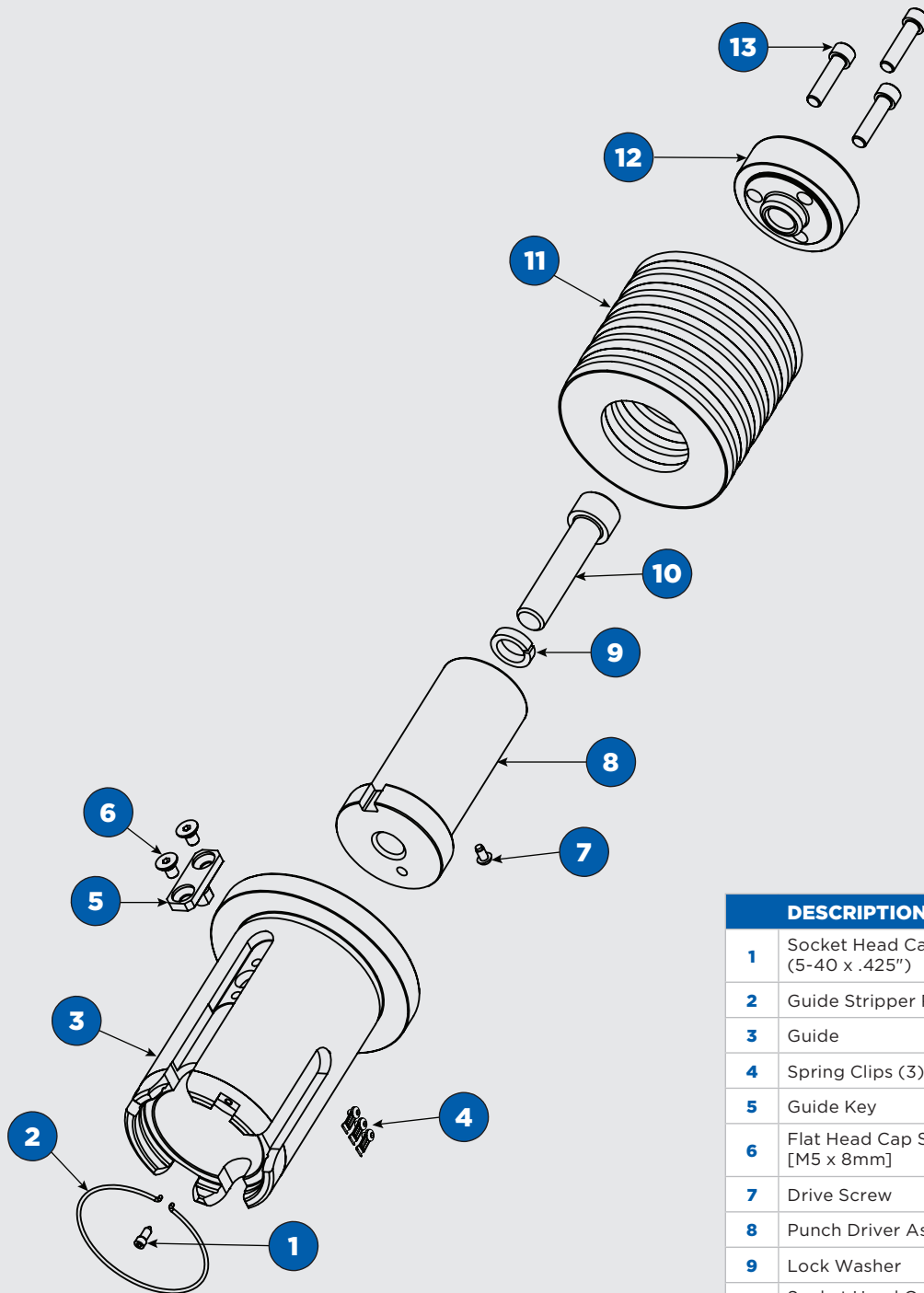
Additional charges may apply to non-standard features. See page 156.

DESCRIPTION	MAXIMUM A DIMENSION	MAXIMUM MATERIAL THICKNESS	NOTES
Basix assemblies are designed to deliver durability and performance at a lower cost with basic features. Guide assemblies are keyed for shapes at 0°, 90° and 225°.	2.000" [50.8mm] 	.250" [6.35mm] 	<ul style="list-style-type: none"> All punches shipped with no shear unless specified 1842 assembly includes 1/2-13 bolt Dies available in Ultima® premium tool steel upon request

STANDARD SHAPES Non-standard shapes available. See pages 136-142.



BASIX 2" Ⓞ STATION REPLACEMENT PARTS



Cat. No. 1845 Driver Assembly includes:
7 & 8

	DESCRIPTION	CAT. NO.
1	Socket Head Cap Screw (5-40 x .425")	429
2	Guide Stripper Ring	5035
3	Guide	1846
4	Spring Clips (3)	2810
5	Guide Key	1834
6	Flat Head Cap Screw [M5 x 8mm]	6567
7	Drive Screw	6666
8	Punch Driver Assembly	1845
9	Lock Washer	432
10	Socket Head Cap Screw (2) [M12 x 55mm] (1/2-13 x 2.250")	6026 6002
11	Disc Spring (11 required)	1844
12	Punch Head	1843
13	Socket Head Cap Screw (.250-28 x 1.000")	6047

2" Ⓞ

METRIC STYLE

BASIX 3-1/2" Ⓞ STATION – METRIC STYLE



GUIDE ASSEMBLY



PUNCH



STRIPPER



DIE



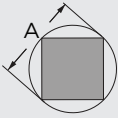
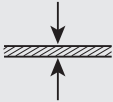
SHIM

GUIDE ASSEMBLY	CAT. NO.	PRICE
Assembly	1857	
PUNCH	CAT. NO.	PRICE
Round M12 Thread	1937	
Shape M12 Thread	1938	
Optima® Coating	—	
STRIPPER	CAT. NO.	PRICE
Round	1864	
Shape	1869	
DIE	CAT. NO.	PRICE
Round Slug Hugger**	2198	
Round Standard	1865	
Shape Slug Hugger® 2*	12965	
Shape Positive	1870	
Shape Negative	1871	

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

DIE SHIM	CAT. NO.	PRICE
.010" [0.25mm] Pack of 5	2211	
.030" [0.76mm] Pack of 5	2728	
.060" [1.5mm] Pack of 5	2175	

Additional charges may apply to non-standard features. See page 156.

DESCRIPTION	MAXIMUM A DIMENSION	MAXIMUM MATERIAL THICKNESS	NOTES
Basix assemblies are designed to deliver durability and performance at a lower cost with basic features. Guide assemblies are keyed for shapes at 0°, 90° and 225°.	3.500" [88.9mm] 	.250" [6.35mm] 	<ul style="list-style-type: none"> .062" [1.6mm] rooftop shear is given to all punches with A Dimension > 2.000" [50.8mm] and width > .250" [6.35mm] 1857 assembly includes 1/2-13 bolt Dies are available in Ultima® premium tool steel upon request

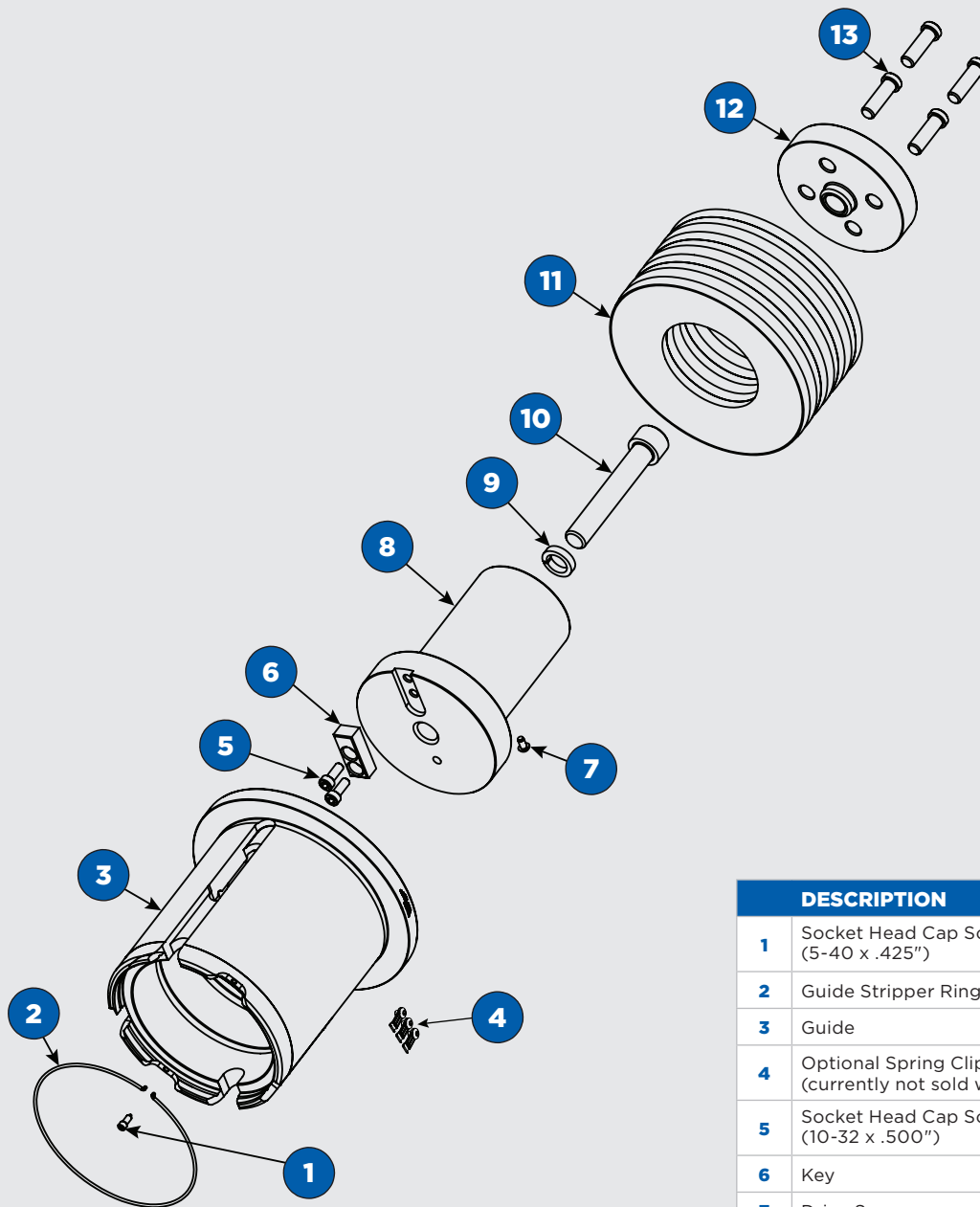
STANDARD SHAPES Non-standard shapes available. See pages 136-142.



3-1/2" Ⓞ

METRIC STYLE

BASIX 3-1/2" ⌀ STATION REPLACEMENT PARTS



Cat. No. 1860 Driver Assembly includes:
7 & 8

	DESCRIPTION	CAT. NO.
1	Socket Head Cap Screw (5-40 x .425")	429
2	Guide Stripper Ring	5036
3	Guide	1861
4	Optional Spring Clips (3) (currently not sold with guide)	2810
5	Socket Head Cap Screw (10-32 x .500")	6010
6	Key	1862
7	Drive Screw	6666
8	Punch Driver Assembly	1860
9	Lock Washer	432
10	Socket Head Cap Screw (2) [M12 x 75mm] (1/2-13 x 3.000")	6027 6003
11	Disc Spring (7 required)	1859
12	Punch Head	1858
13	Low Head Cap Screw (.312-18 x 1.000")	6021

3-1/2" ⌀

METRIC STYLE

BASIX 4-1/2" ⓔ STATION – METRIC STYLE

4-1/2" ⓔ

METRIC STYLE



GUIDE ASSEMBLY



PUNCH



STRIPPER



DIE



SHIM

GUIDE ASSEMBLY	CAT. NO.	PRICE
Assembly	1872	
PUNCH	CAT. NO.	PRICE
Round M12 Thread	1941	
Shape M12 Thread	1942	
Optima® Coating	—	
STRIPPER	CAT. NO.	PRICE
Round	1877	
Shape	1882	
DIE	CAT. NO.	PRICE
Round Slug Hugger**	2200	
Round Standard	1878	
Shape Slug Hugger® 2*	12967	
Shape Positive	1883	
Shape Negative	1884	

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

DIE SHIM	CAT. NO.	PRICE
.010" [0.25mm] Pack of 5	2212	
.030" [0.76mm] Pack of 5	2730	
.060" [1.5mm] Pack of 5	2176	

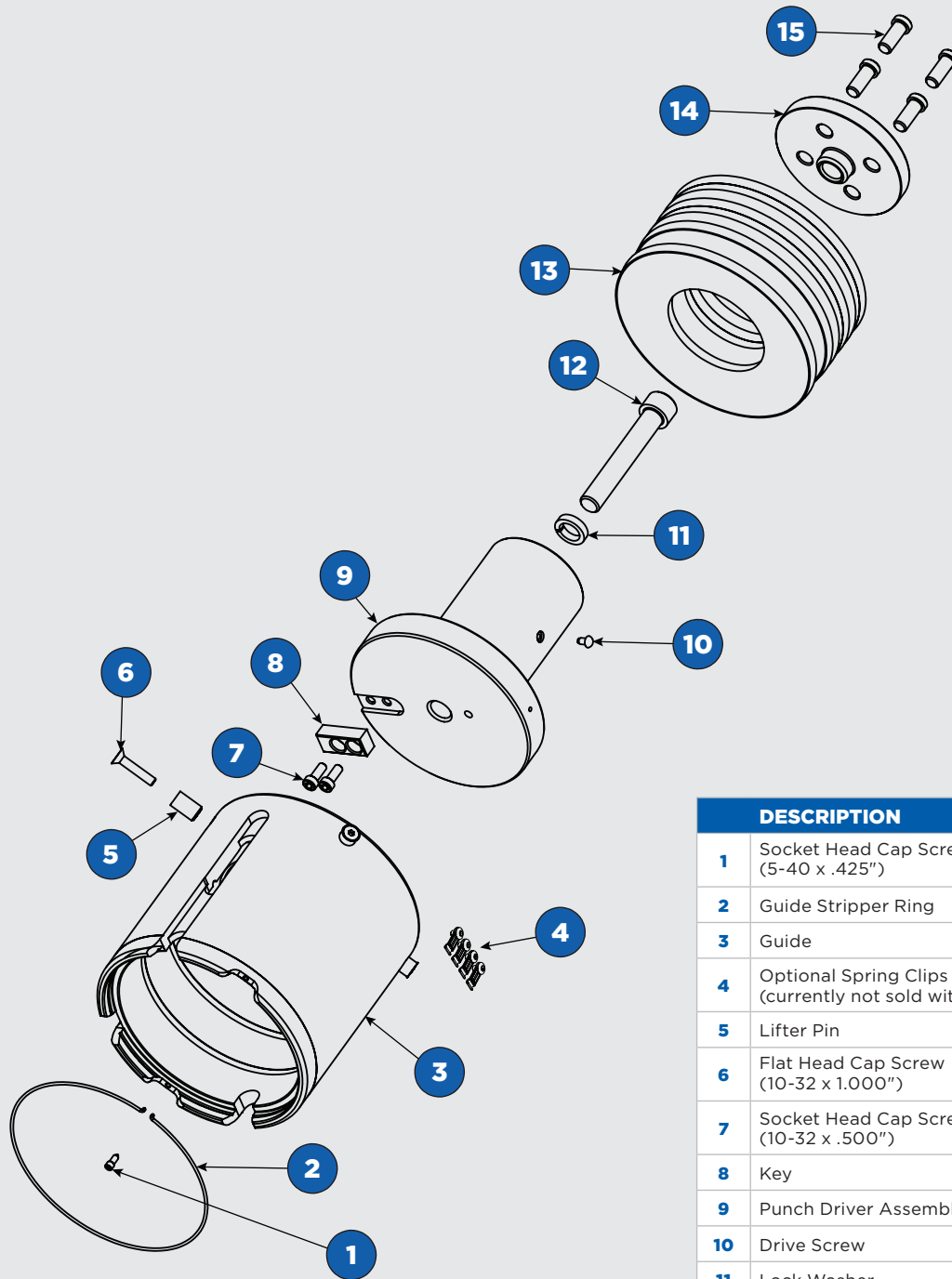
Additional charges may apply to non-standard features. See page 156.

DESCRIPTION	MAXIMUM A DIMENSION	MAXIMUM MATERIAL THICKNESS	NOTES
Basix assemblies are designed to deliver durability and performance at a lower cost with basic features. Guide assemblies are keyed for shapes at 0°, 90° and 225°.	4.500" [114.3mm] 	.250" [6.35mm] 	<ul style="list-style-type: none"> .062" [1.6mm] rooftop shear is given to all punches with A Dimension > 2.000" [50.8mm] and width > .250" [6.35mm] 1872 assembly includes 1/2-13 bolt Dies are available in Ultima® premium tool steel upon request

STANDARD SHAPES Non-standard shapes available. See pages 136-142.



BASIX 4-1/2" Ⓜ STATION REPLACEMENT PARTS



Cat. No. 1874 Driver Assembly includes:
9 & 10

	DESCRIPTION	CAT. NO.
1	Socket Head Cap Screw (5-40 x .425")	429
2	Guide Stripper Ring	5037
3	Guide	1875
4	Optional Spring Clips (4) (currently not sold with guide)	2810
5	Lifter Pin	1880
6	Flat Head Cap Screw (10-32 x 1.000")	2158
7	Socket Head Cap Screw (10-32 x .500")	6010
8	Key	1862
9	Punch Driver Assembly	1874
10	Drive Screw	6666
11	Lock Washer	432
12	Socket Head Cap Screw (2) [M12 x 75mm] (1/2-13 x 3.000")	6027 6003
13	Disc Spring (7 required)	1859
14	Punch Head	1873
15	Low Head Cap Screw (.312-18 x .750")	6022

4-1/2" Ⓜ

METRIC STYLE

ULTIMA® PREMIUM TOOL STEEL IMPROVES DURABILITY AND PERFORMANCE

Available exclusively from Wilson Tool International, Ultima® Premium Tool Steel is engineered to significantly increase wear resistance over conventional tool steels.

A New Level of Performance

Punches and dies made from Ultima tool steel set a new benchmark for durability and performance, dramatically improving tool life when punching materials that are abrasive or have high tensile strength. Ultima excels in applications where ordinary punches wear quickly and is ideal for long-run jobs. It significantly reduces micro chipping, where cutting edge failure most often begins.

Remarkable Downtime Reductions

With up to twice as long between regrinds*, Ultima punches and dies substantially reduce downtime and tool replacement costs. Breaking, chipping, cracking, tool fatigue and other downtime problems are minimized, providing long-term gains in productivity and profitability.

Ultima premium steel punches and dies are especially useful for the toughest applications, but are effective for any job. Viability can be determined by conducting a cost-benefit analysis.

ULTIMA® PREMIUM TOOL STEEL



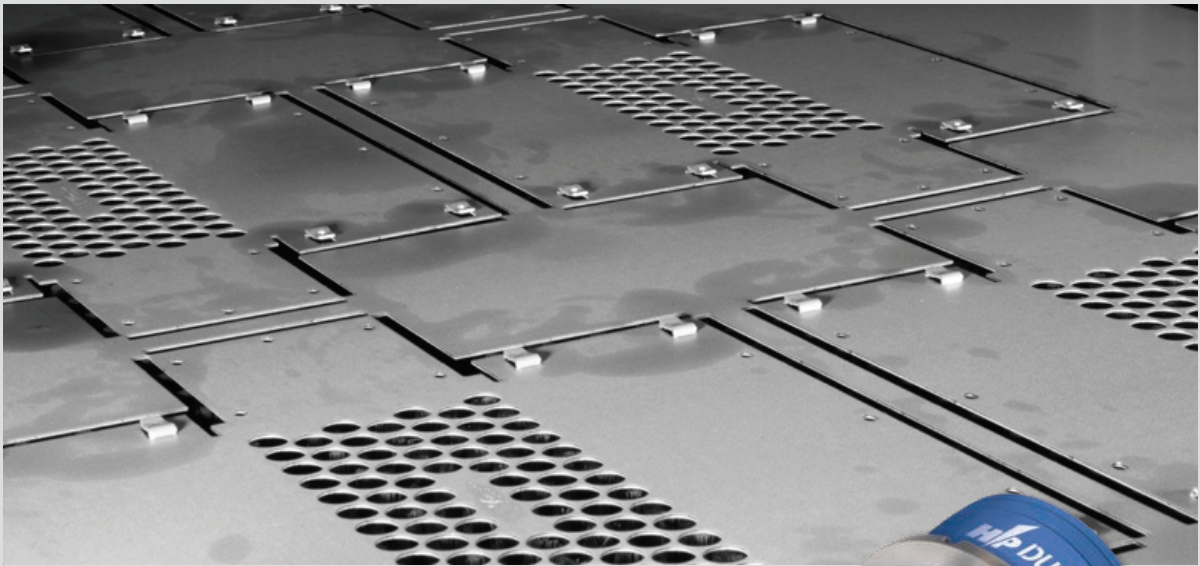
Scan QR Code
to See Ultima®
Premium Tool
Steel Flyer



*Maintenance and sharpening may differ from traditional tooling. Check with your sales engineer or our tooling technicians.



PARTING TOOLS



Parting and slitting are common practices in sheet metal fabrication. Whether you are parting nested parts or straightening the edge of the sheet, you need a product that is rigid and delivers a long tool life.

Wilson Tool developed the HP DuraBlade® and Dura-Die parting products specifically to maximize your productivity for these applications.

HP DuraBlade® features a simple push button adjustment and replaceable cutting blade insert made with Ultima® premium tool steel to significantly increase grind life. The punch blades are supplied flat, or with rooftop shear upon request at no additional charge.

The **Dura-Die parting tool** completes Wilson Tool's ultimate parting solution. When a new die is necessary, simply replace the removable insert and you are quickly back up and running.

When combined with HP DuraBlade, you are able to greatly increase the life of your parting tools. And to help minimize material waste both products are available with a one or two-sided relieved strippers for use in close-to-clamp.



HP DURABLADE® 3-1/2" ⓓ STATION

3-1/2" ⓓ

PARTING TOOL



GUIDE ASSEMBLY



PUNCH



STRIPPER



DIE



SHIM

GUIDE ASSEMBLY	CAT. NO.	PRICE
Assembly	5663	
Assembly ABS / WLS	5653	
PUNCH	CAT. NO.	PRICE
Blade	5657	
Optima® Coating	—	
STRIPPER	CAT. NO.	PRICE
One-Sided Relief	5665	
Two-Sided Relief	5656	
One-Sided Relief ABS	5666	
Two-Sided Relief ABS	5664	
DIE	CAT. NO.	PRICE
Slug Hugger® 2* (relief 2 sides, shape at 90°)	5499	
Slug Hugger® 2* (relief 2 sides, shape at 0°-90°)	5500	
Slug Hugger® 2* (relief 1 side, shape at 90°)	12966	
Slug Hugger® 2* (relief 1 side, shape at 0°-90°)	5501	
Positive (relief 2 sides, shape at 90°)	5101	
Positive (relief 2 sides, shape at 0°-90°)	5328	
Positive (relief 1 side, shape at 90°)	2462	
Positive (relief 1 side, shape at 0°-90°)	5331	
Negative (relief 2 sides, shape at 90°)	5156	
Negative (relief 2 sides, shape at 0°-90°)	5329	
Negative (relief 1 side, shape at 90°)	2463	
Negative (relief 1 side, shape at 0°-90°)	5332	

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

DIE SHIM	CAT. NO.	PRICE
.010" [0.25mm] Pack of 5	2211	
.030" [0.76mm] Pack of 5	2728	
.060" [1.5mm] Pack of 5	2175	

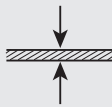
Additional charges may apply to non-standard features. See page 156.

HP DuraBlade® Punch Grinding Fixture

Fixture for sharpening D and E station HP DuraBlade® punches with our innovative XSharp™ Grinder.

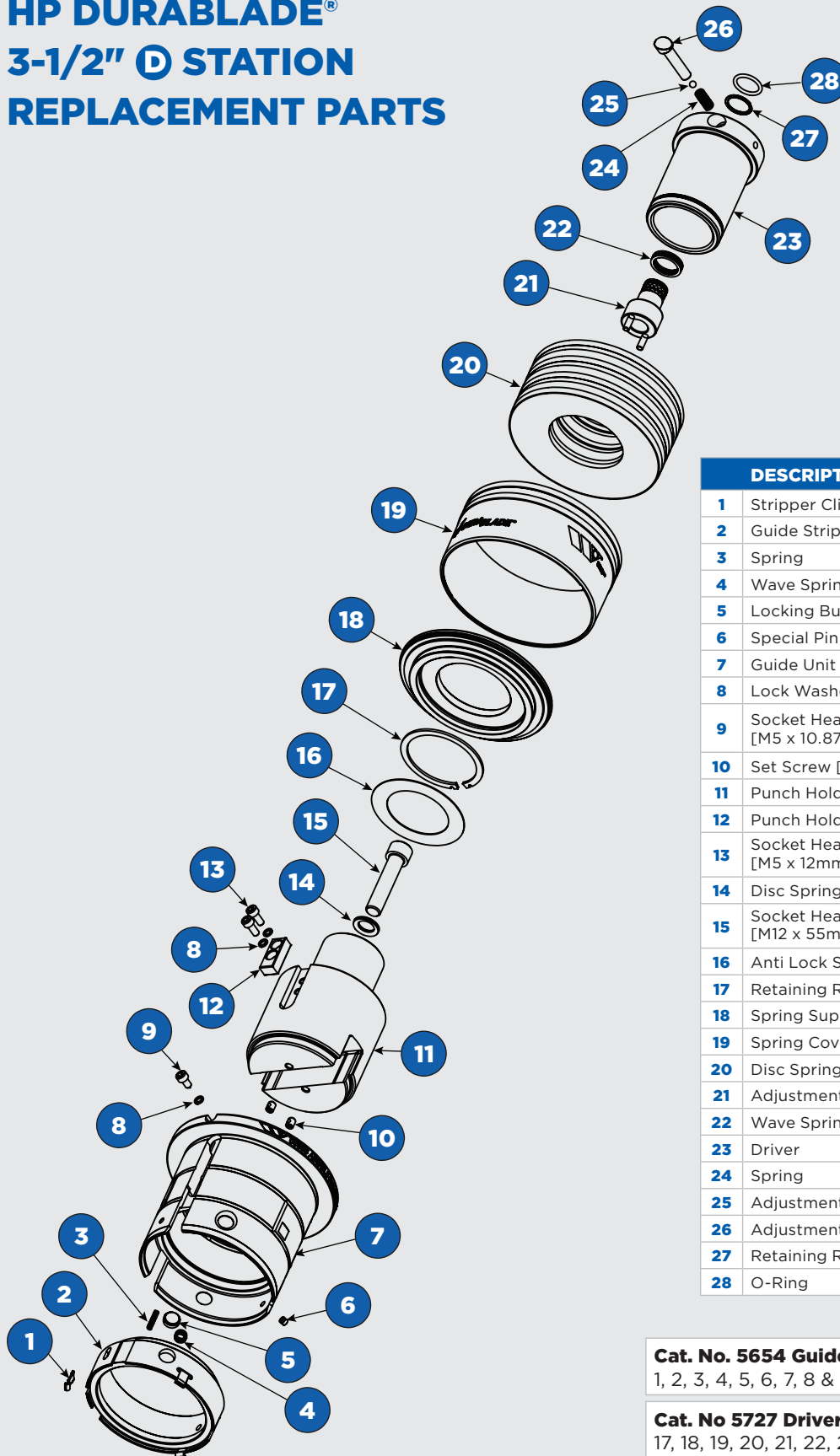
CAT. NO.	PRICE
6933	



DESCRIPTION	MAX. WIDTH FOR BLADE INSERT	MAXIMUM MATERIAL THICKNESS	NOTES
HP DuraBlade® guide assemblies are keyed for shapes at 0°, 45°, and 90°. Punch blades are Ultima® premium tool steel.	.750" [19.05mm]	.250" [6.35mm] 	<ul style="list-style-type: none"> .062" [1.6mm] rooftop shear is given to all punches with A Dimension > 2.000" [50.8mm] and width > .250" [6.35mm]. Ultima® premium tool steel is available on dies.



HP DURABLADE® 3-1/2" ⌀ STATION REPLACEMENT PARTS



	DESCRIPTION	CAT. NO.
1	Stripper Clip	5521
2	Guide Stripper Ring	5528
3	Spring	971694
4	Wave Spring	8140
5	Locking Button	5519
6	Special Pin	5522
7	Guide Unit Only	5659
8	Lock Washer	2112
9	Socket Head Cap Screw [M5 x 10.87mm]	5197
10	Set Screw [M6 x 8mm]	6298
11	Punch Holder with Bushing	5655
12	Punch Holder Key	1862
13	Socket Head Cap Screw [M5 x 12mm]	6110
14	Disc Spring	971690
15	Socket Head Cap Screw [M12 x 55mm]	6026
16	Anti Lock Shim	5413
17	Retaining Ring	5747
18	Spring Support	5738
19	Spring Cover	5679
20	Disc Spring (7 required)	5449
21	Adjustment Shaft	5739
22	Wave Spring	971692
23	Driver	5740
24	Spring	972396
25	Adjustment Locking Ball	972420
26	Adjustment Button	5737
27	Retaining Ring	972441
28	O-Ring	972430

Cat. No. 5654 Guide Unit Assembly includes:
1, 2, 3, 4, 5, 6, 7, 8 & 9

Cat. No 5727 Driver Assembly includes:
17, 18, 19, 20, 21, 22, 23, 24, 25, 26 & 27

3-1/2" ⌀

PARTING TOOL

HP DURABLADE® 4-1/2" E STATION



GUIDE ASSEMBLY



PUNCH



STRIPPER



DIE



SHIM

4-1/2" E PARTING TOOLS

GUIDE ASSEMBLY	CAT. NO.	PRICE
Assembly	5639	
Assembly ABS	5626	
PUNCH	CAT. NO.	PRICE
Blade	5630	
Optima® Coating	—	
STRIPPER	CAT. NO.	PRICE
One-Sided Relief	5641	
Two-Sided Relief	5629	
One-Sided Relief ABS	5642	
Two-Sided Relief ABS	5640	
DIE	CAT. NO.	PRICE
Slug Hugger® 2* (relief 2 sides, shape at 90°)	5502	
Slug Hugger® 2* (relief 2 sides, shape at 0°-90°)	5503	
Slug Hugger® 2* (relief 1 side, shape at 90°)	12968	
Slug Hugger® 2* (relief 1 side, shape at 0°-90°)	5504	
Positive (relief 2 sides, shape at 90°)	5095	
Positive (relief 2 sides, shape at 0°-90°)	5338	
Positive (relief 1 side, shape at 90°)	2465	
Positive (relief 1 side, shape at 0°-90°)	5341	
Negative (relief 2 sides, shape at 90°)	5158	
Negative (relief 2 sides, shape at 0°-90°)	5339	
Negative (relief 1 side, shape at 90°)	2466	
Negative (relief 1 side, shape at 0°-90°)	5342	

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

DIE SHIM	CAT. NO.	PRICE
.010" [0.25mm] Pack of 5	2212	
.030" [0.76mm] Pack of 5	2730	
.060" [1.5mm] Pack of 5	2176	

Additional charges may apply to non-standard features. See page 156.

HP DuraBlade® Punch Grinding Fixture

Fixture for sharpening D and E station HP DuraBlade® punches with our innovative XSharp™ Grinder.

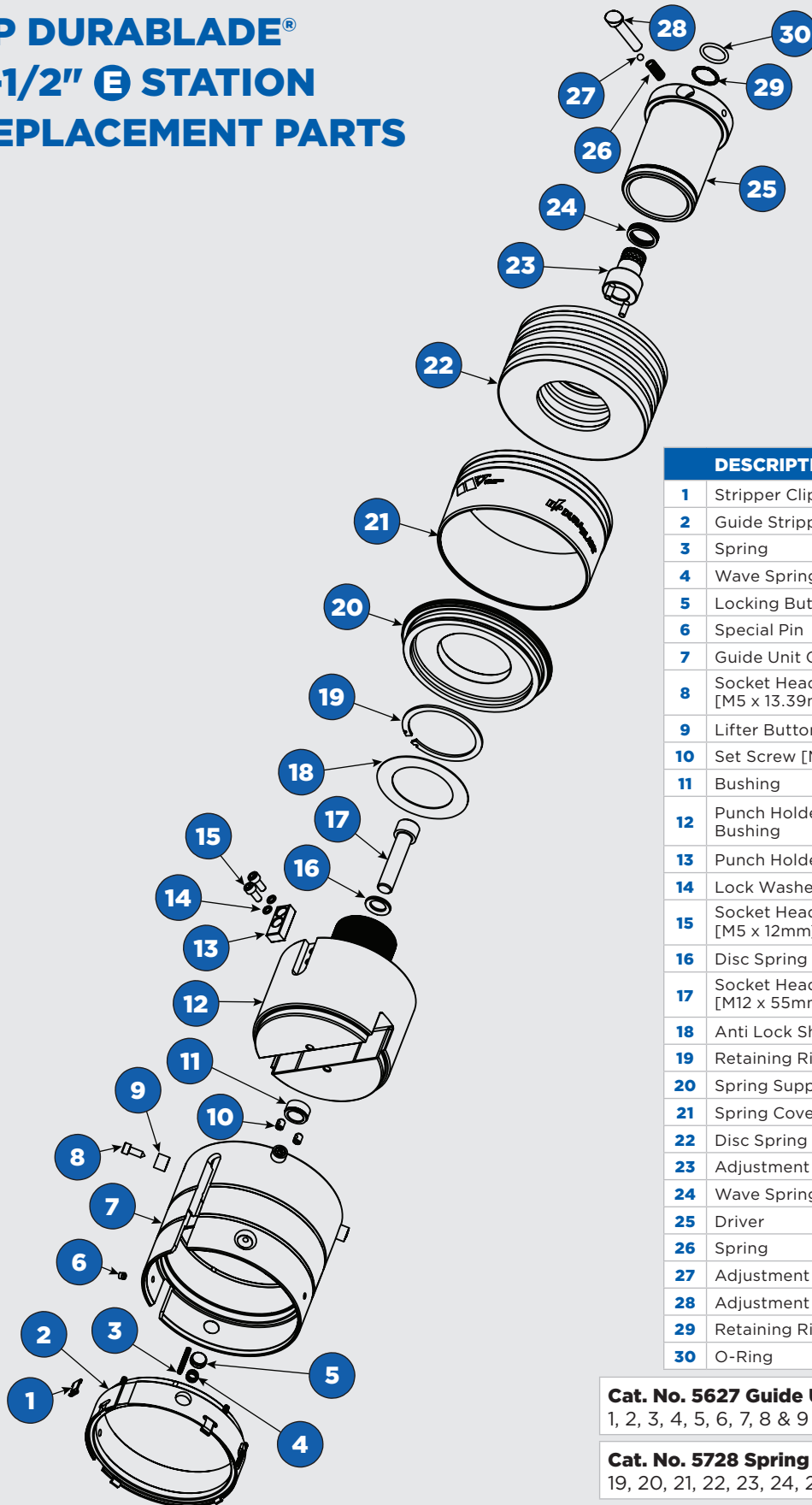
CAT. NO.	PRICE
6933	



DESCRIPTION	MAX. WIDTH FOR BLADE INSERT	MAXIMUM MATERIAL THICKNESS	NOTES
HP DuraBlade® guide assemblies are keyed for shapes at 0°, 45°, and 90°. Punch blades are Ultima® premium tool steel.	.750" [19.05mm]	.250" [6.35mm] 	<ul style="list-style-type: none"> .062" [1.6mm] rooftop shear is given to all punches with A Dimension > 2.000" [50.8mm] and width > .250" [6.35mm]. Ultima® premium tool steel is available on dies.



HP DURABLADE® 4-1/2" E STATION REPLACEMENT PARTS



	DESCRIPTION	CAT. NO.
1	Stripper Clip	5521
2	Guide Stripper Ring	5538
3	Spring	971694
4	Wave Spring	8140
5	Locking Button	5519
6	Special Pin	5522
7	Guide Unit Only	5632
8	Socket Head Cap Screw [M5 x 13.39mm]	5210
9	Lifter Button	5209
10	Set Screw [M6 x 8mm]	6298
11	Bushing	5631
12	Punch Holder with Bushing	5628
13	Punch Holder Key	1862
14	Lock Washer	2112
15	Socket Head Cap Screw [M5 x 12mm]	6110
16	Disc Spring	971690
17	Socket Head Cap Screw [M12 x 55mm]	6026
18	Anti Lock Shim	5413
19	Retaining Ring	5747
20	Spring Support	5741
21	Spring Cover	5679
22	Disc Spring (7 required)	5449
23	Adjustment Shaft	5739
24	Wave Spring	971692
25	Driver	5742
26	Spring	972396
27	Adjustment Locking Ball	972420
28	Adjustment Button	5737
29	Retaining Ring	972441
30	O-Ring	972430

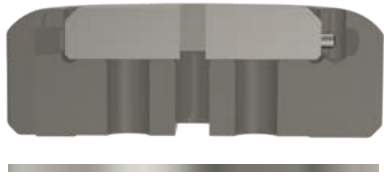
Cat. No. 5627 Guide Unit Assembly includes:
1, 2, 3, 4, 5, 6, 7, 8 & 9

Cat. No. 5728 Spring Pack Assembly includes:
19, 20, 21, 22, 23, 24, 25, 26, 27, 28, 29 & 30

4-1/2" E

PARTING TOOL

DURA-DIE



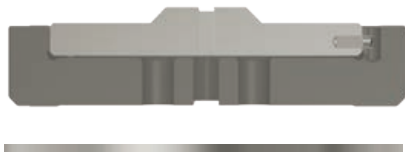
DIE ASSEMBLY

SHIM



KNOCK OUT TOOL

PARTING DURA-DIE	C STATION		D STATION		E STATION	
	CAT. NO.	PRICE	CAT. NO.	PRICE	CAT. NO.	PRICE
Insert — Positive	12991		13008		13013	
Insert — Slug Hugger® 2	12992		13009		13014	
Die Base Assembly at 0° and 90°	12989		13006		13015	
Die Base	12990		13007		13016	
Shim Pack	12995		13012		13017	
Knock Out Tool	24310		24310		24313	
M6 x 10mm Large Retaining Screw (3 required)	24323		24323		24323	
Maximum length	2.008" [51mm]		3.386" [86mm]		4.400" [111.8mm]	
Maximum width	.276" [7mm]		.250" [6.35mm]		.375" [9.52mm]	
Maximum clearance for maximum length	.020" [.51mm]		.040" [1.02mm]		.030" [.76mm]	



DIE ASSEMBLY

SHIM



KNOCK OUT TOOL

CLOSE-TO-CLAMP PARTING DURA-DIE	D STATION		E STATION	
	CAT. NO.	PRICE	CAT. NO.	PRICE
Insert — Positive (relief 2 sides)	13281		13289	
Insert — Slug Hugger® 2 (relief 2 sides)	13282		13290	
Die Base Assembly at 0° and 90°	13276		13284	
Die Base	13278		13286	
Shim Pack	13012		13017	
Knock Out Tool	24310		24313	
M6 x 10mm Large Retaining Screw (3 required)	24323		24323	
Maximum length	3.189" [81mm]		4.400" [111.8mm]	
Maximum width	.276" [7mm]		.375" [9.52mm]	
Maximum clearance for maximum length	.020" [.51mm]		.030" [.76mm]	

NOTES

- All die base assemblies include die base, knock out tool and shim pack
- Die inserts are Ultima® premium tool steel
- Die insert ordered separately



CLOSE-TO-CLAMP REPLACEMENT PARTS



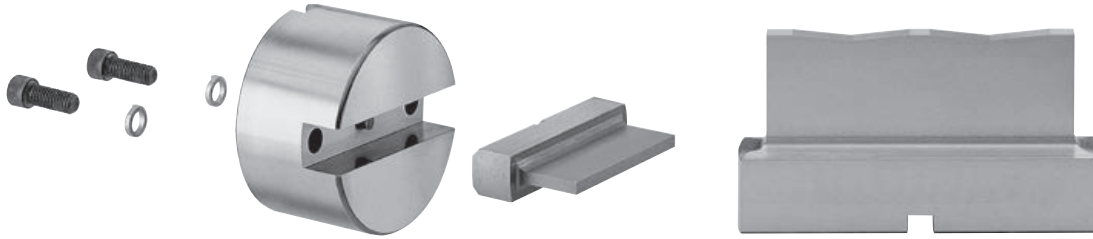
PUNCH	D STATION		E STATION	
	CAT. NO.	PRICE	CAT. NO.	PRICE
Thin Clamps S-80	5027		5029	
Thick Clamp S-80/90	5114		5109	
Optima® Coating	—		—	
STRIPPER	CAT. NO.	PRICE	CAT. NO.	PRICE
Thin Clamps S-80	5100		5094	
Thick Clamp S-80	5115		5110	
Thick Clamp S-90	5399		5400	
Thick Clamp S-90 ABS	5360		5385	
DIE	CAT. NO.	PRICE	CAT. NO.	PRICE
Slug Hugger® 2* (relief 2 sides, shape at 90°)	5499		5502	
Slug Hugger® 2* (relief 2 sides, shape at 0° - 90°)	5500		5503	
Slug Hugger® 2* (relief 1 side, shape at 90°)	12966		12968	
Slug Hugger® 2* (relief 1 side, shape at 0° - 90°)	5501		5504	
Positive (relief 2 sides, shape at 90°)	5101		5095	
Positive (relief 2 sides, shape at 0° - 90°)	5328		5338	
Positive (relief 1 side, shape at 90°)	2462		2465	
Positive (relief 1 side, shape at 0° - 90°)	5331		5341	
Negative (relief 2 sides, shape at 90°)	5156		5158	
Negative (relief 2 sides, shape at 0° - 90°)	5329		5339	
Negative (relief 1 side, shape at 90°)	2463		2466	
Negative (relief 1 side, shape at 0° - 90°)	5332		5342	

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

NOTES

.062" [1.6mm] rooftop shear is given to all punches with A Dimension > 2.000" [50.8mm] and width > .250" [6.35mm].

STANDARD PARTING TOOLS



REPLACEABLE INSERT ASSEMBLY

DESCRIPTION	MAX BLADE WIDTH inch [mm]	C STATION		D STATION		E STATION	
		CAT. NO.	PRICE	CAT. NO.	PRICE	CAT. NO.	PRICE
Body (1/2 - 13)	.750 [19]	S190		1966		1969	
Body (M 12)	.750 [19]	2625		2286		2287	
Body (M 14)	.750 [19]	14730		14731		14732	
Punch Blade	.750 [19]	2590		1967		1970	
Set (1/2 - 13)	.750 [19]	2568		1965		1968	
Set (M 12)	.750 [19]	2624		2372		2373	
Set (M 14)	.750 [19]	14733		14734		14735	

PARTS DESCRIPTION	CAT. NO.	PRICE
Socket Head Cap Screw: 3/8" - 16 x 1-1/2" Long for 2" C Station	6391	
Socket Head Cap Screw: 3/8" - 16 x 1" Long for 3-1/2" D Station and 4-1/2" E Stations	6019	
High Collar Lock Washer for 3/8" Screw	2129	
Dowel Pin: 1/4" Diameter x .450" Long (All Stations)	6004	

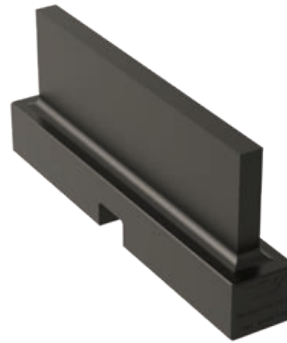
DESCRIPTION	NOTES
<ul style="list-style-type: none"> Optima® coating is standard on punch inserts. Inserts are available as Obround to be used with rectangle die to eliminate 'saw-tooth effect'. Punch insert is compatible with Amada's Insert Parting Tool (.750" wide blade). 	<ul style="list-style-type: none"> Blade insert punches < .375" [9.53mm] in width are shipped with no shear unless specified. Double Valley Shear is recommended for widths of .187" - .375" [4.75mm - 9.53mm] and minimum lengths of 2.000" [50.8mm] when used for nibbling.

HP DuraBlade® Punch Grinding Fixture

Fixture for sharpening D and E station HP DuraBlade® punches with our innovative XSharp™ Grinder.

CAT. NO.	PRICE
6933	





MATE STYLE BLADES

MAX BLADE WIDTH inch [mm]	C STATION		D STATION		E STATION	
	CAT. NO.	PRICE	CAT. NO.	PRICE	CAT. NO.	PRICE
MATE STYLE BLADE						
.708 [18]	15547		14046		14047	
Optima® Coating	—		—		—	



AMADA STYLE BLADES

C STATION			D STATION			E STATION		
MAX BLADE WIDTH inch [mm]	CAT. NO.	PRICE	MAX BLADE WIDTH inch [mm]	CAT. NO.	PRICE	MAX BLADE WIDTH inch [mm]	CAT. NO.	PRICE
AMADA STYLE BLADE ALPHA								
—	—	—	.787 [20]	14044		.787 [20]	14045	
—	—	—	Optima® Coating	—		Optima® Coating	—	
AMADA STYLE BLADE STANDARD								
1.102 [28]	14180		.630 [16]	14201		.630 [16]	14202	
Optima® Coating	—		Optima® Coating	—		Optima® Coating	—	

ULTRA REPLACEMENT TOOLING

Wilson Tool International supplies punches and strippers that are 100% compatible with Ultra® guide assemblies and holders from Mate Precision Tooling®. These punches include the industry's most durable WB tool steel and are available with Wilson Tool's patented Optima® coating.

In addition, these products are backed by the industry's leading service organization, meaning that your order will be delivered on time, every time.

Now you can order all your tooling from the supplier offering the most comprehensive product lines for punch press and press brake tooling solutions.

- Optima® coating available for punches
- Large station punches are M-12



	A STATION		B STATION		C STATION		D STATION		E STATION	
	CAT. NO.	PRICE	CAT. NO.	PRICE	CAT. NO.	PRICE	CAT. NO.	PRICE	CAT. NO.	PRICE
ULTRA PUNCH										
Round	13715		13717		—	—	—	—	—	—
Shape	13716		13718		—	—	—	—	—	—
ULTRA STRIPPER										
Round	15500		15504		15508		15512		15516	
Shape	15501		15505		15509		15513		15517	
Round ABS	15502		15506		15510		15514		15518	
Shape ABS	15503		15507		15511		15515		15519	

Mate Ultra is a trademark of Mate Precision Technology.

MULTI-TOOLS



Multi-Tools enable you to load the equivalent of 3, 8, or even 20 smaller tools in a single station. This increases your turret capacity and reduces set-up times and costs. Wilson Tool's Multi-Tools are engineered with the strongest available tool steel.

MTX R Series

With easier than ever tool-less adjustments and changes, with no additional tooling inventory needed. With HP and EXP® thick turret punches, strippers and dies, you can maximize grind life and lower tooling costs.

- Punch at any angle from 0-360°
- 3 station and 8 station options
- Adjust punch length with a simple twist of the punch driver
- Visual guide groove makes setting tool length a snap
- Punches are held in the 'up' position when not in use, leaving material mark-free
- Internal lube port keeps all parts moving smoothly
- Optional coatings provide exceptional wear resistance

MT7A

This consolidates up to seven punches into a single tool, reducing multiple set-ups. The drop-in style allows punches to be loaded or unloaded quickly and easily and accepts all styles of A Station punch and guide assemblies and dies.

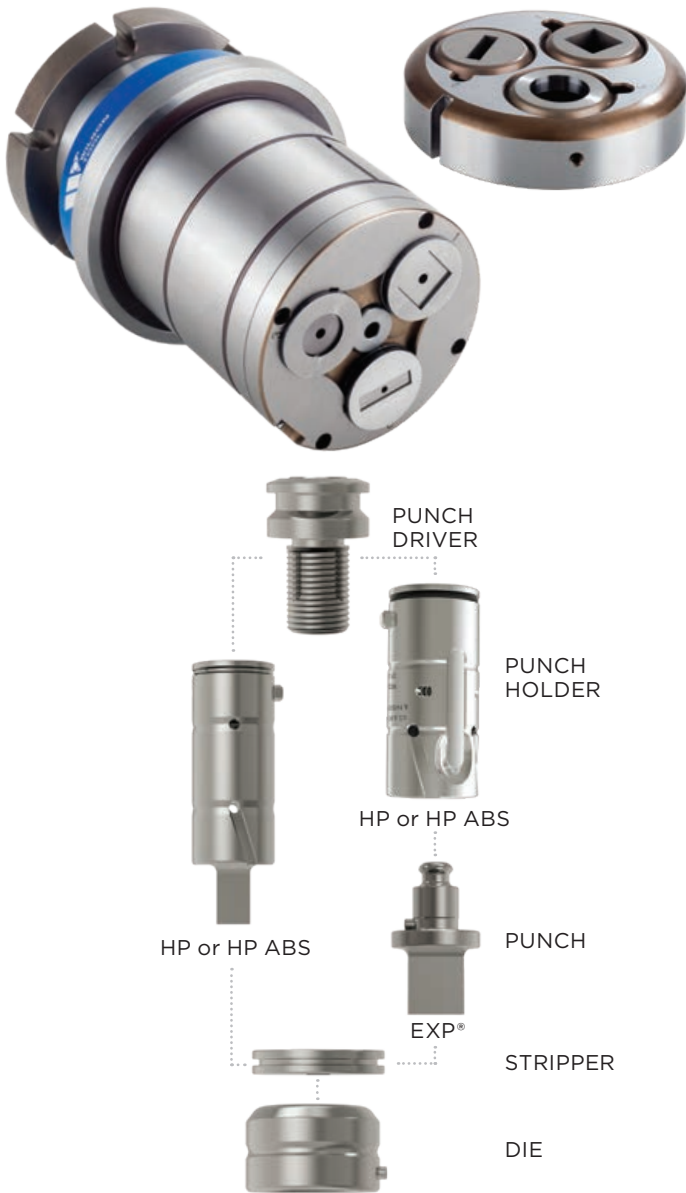


Scan QR Code to
See More Multi-Tools



MTX3Ri ROTATIONAL – INDEXABLE MULTI-TOOLS

MULTI-TOOL



UPPER & LOWER ASSEMBLY	CAT. NO.
MTX3Ri Assembly Tool kit with punch drivers included	Call Sales Desk
PUNCH DRIVER	CAT. NO.
Punch Driver	45481
Tool Kit	7024
PUNCH	CAT. NO.
HP Round*	2407
HP Shape*	2408
HP Round ABS*	2398
HP Shape ABS*	2399
EXP* Round**	13916
EXP* Shape**	13917
Optima* Coating	—

*Requires a punch driver
**Requires an EXP* punch holder and driver

PUNCH HOLDER	CAT. NO.
EXP* Shape HP	14917
EXP* Shape HP ABS	14913
STRIPPER	CAT. NO.
Round	1890
Shape	1917
Round ABS	2433
Shape ABS	2432
DIE	CAT. NO.
Round Slug Hugger**	2194
Round Standard	2021
Shape Slug Hugger* 2*	12961
Shape Positive	2025
Shape Negative	2026

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

INFORMATION NEEDED	MACHINE COMPATIBILITY	MAXIMUM A DIMENSION	MAXIMUM MATERIAL THICKNESS
<ul style="list-style-type: none"> Machine Make Machine Model Machine Serial Number 	Available for the following machine makes: <ul style="list-style-type: none"> Prima Power LVD Strippit Durma Baykal Murata Wiedemann Thick 	1.250" [31.75mm]	16 Tons Max [142 Kn] .250" [6.35mm]

STANDARD SHAPES Non-standard shapes available. See pages 136-142.



MTX8Ri ROTATIONAL – INDEXABLE MULTI-TOOLS

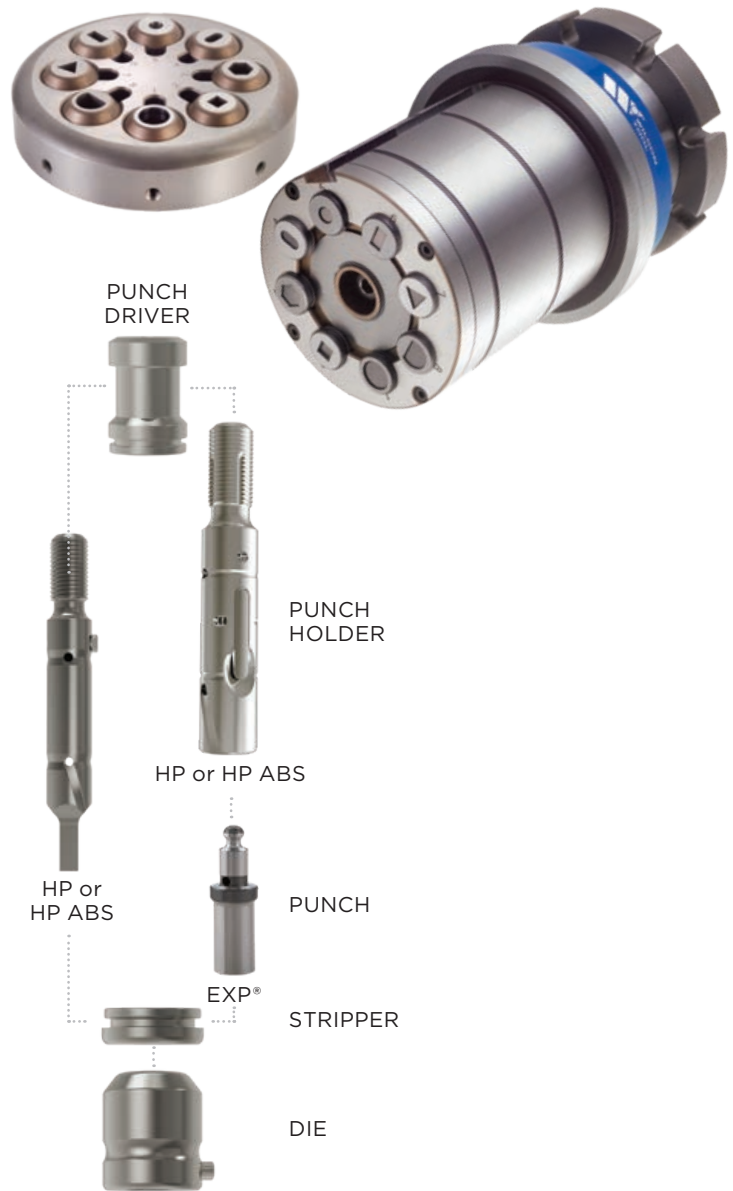
UPPER & LOWER ASSEMBLY	CAT. NO.
MTX8Ri Assembly Tool kit with punch drivers included	Call Sales Desk
PUNCH DRIVER	CAT. NO.
Punch Driver	45493
Tool Kit	7025
PUNCH	CAT. NO.
HP Round*	2405
HP Shape*	2406
HP Round ABS*	2385
HP Shape ABS*	2389
EXP® Round**	13904
EXP® Shape**	13905
Optima® Coating	—

*Requires a punch driver

**Requires an EXP® punch holder and driver

PUNCH HOLDER	CAT. NO.
EXP® Shape HP	14895
EXP® Shape HP ABS	14891
STRIPPER	CAT. NO.
Round	13044
Shape	13143
Round ABS	13045
Shape ABS	13152
DIE	CAT. NO.
Round Slug Hugger**	2192
Round Standard	1808
Shape Slug Hugger® 2*	12959
Shape Positive	1817
Shape Negative	1818

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



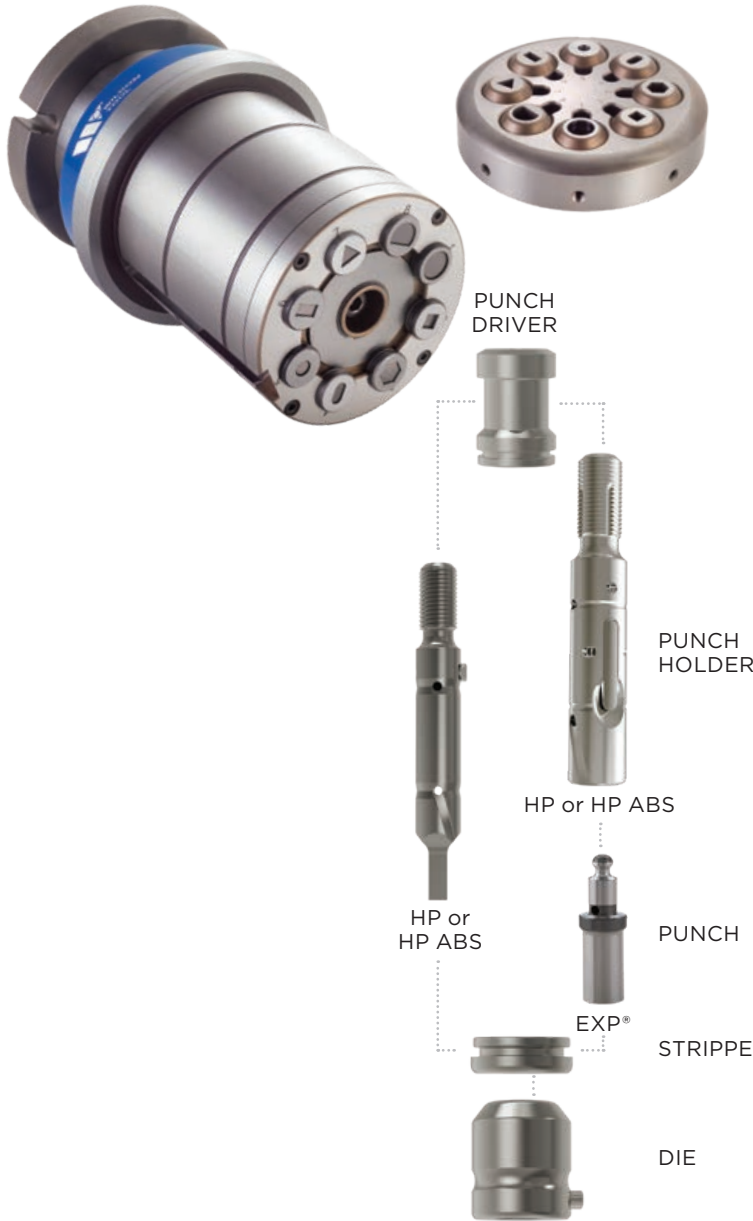
MULTI-TOOL

INFORMATION NEEDED	MACHINE COMPATIBILITY	MAXIMUM A DIMENSION	MAXIMUM MATERIAL THICKNESS
<ul style="list-style-type: none"> Machine Make Machine Model Machine Serial Number 	Available for the following machine makes: <ul style="list-style-type: none"> Prima Power LVD Strippit Durma Baykal Murata Wiedemann Thick 	.500" [12.7mm]	7 Tons Max [62 Kn] .250" [6.35mm]

STANDARD SHAPES Non-standard shapes available. See pages 136-142.



MTX8i INDEXABLE MULTI-TOOL



UPPER & LOWER ASSEMBLY	CAT. NO.
MTX8i Tool kit with punch drivers included	Call Sales Desk
PUNCH DRIVER	CAT. NO.
Punch Driver	45493
Tool Kit	7025
PUNCH	CAT. NO.
HP Round*	2405
HP Shape*	2406
HP Round ABS*	2385
HP Shape ABS*	2389
EXP® Round**	13904
EXP® Shape**	13905
Optima® Coating	—

*Requires a Punch Driver
 **Requires an EXP® punch holder and driver

PUNCH HOLDER	CAT. NO.
EXP® Shape HP	13975
EXP® Shape HP ABS	13906
STRIPPER	CAT. NO.
Round	13044
Shape	13143
Round ABS	13045
Shape ABS	13152
DIE	CAT. NO.
Round Slug Hugger**	2192
Round Standard	1808
Shape Slug Hugger® 2*	12959
Shape Positive	1817
Shape Negative	1818

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

INFORMATION NEEDED	MACHINE COMPATIBILITY	MAXIMUM A DIMENSION	MAXIMUM MATERIAL THICKNESS
<ul style="list-style-type: none"> Machine Make Machine Model Machine Serial Number 	Available for the following machine makes: <ul style="list-style-type: none"> Prima Power 	.500" [12.7mm]	7 Tons Max [62 Kn] / .250" [6.35mm]

STANDARD SHAPES Non-standard shapes available. See pages 136-142.



MT20i MULTI-TOOL

UPPER & LOWER ASSEMBLY	CAT. NO.
MT20i	Call Sales Desk
PUNCH	CAT. NO.
Round	6838
Shape	6839
Optima® Coating	—
STRIPPER	CAT. NO.
Round	6829
Shape	35079
DIE	CAT. NO.
Round Slug Hugger**	6185
Round Standard	6081
Shape Slug Hugger* 2*	6885
Shape Positive	6149
Shape Negative	6190



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

INFORMATION NEEDED	MACHINE COMPATIBILITY	MAXIMUM A DIMENSION	MAXIMUM MATERIAL THICKNESS
<ul style="list-style-type: none"> Machine Make Machine Model Machine Serial Number 	Available for the following machine makes: <ul style="list-style-type: none"> Prima Power LVD Strippit Goiti Danobat Rainer JFY 	.315" [8mm]	.197" [5mm] mild steel and aluminum .078" [2mm] stainless steel

MT6A AND MT7A MULTI-TOOLS



DESCRIPTION	CAT. NO.
MT6A Punch & Die Assembly	45258
Upper Assembly	45107
Lower Assembly	45241

This Multi-Tool accepts all styles of A Station punch and guide assemblies and dies.



DESCRIPTION	CAT. NO.
MT7A Punch & Die Assembly	13637
Upper Assembly	13638
Lower Assembly	13639

This Multi-Tool accepts all styles of A Station punch and guide assemblies and dies.


STANDARD SHAPES Non-standard shapes available. See pages 136-142.




TOOLING FOR MULTI-TOOLS

MULTI-TOOL


MT3Ri

PUNCH	CAT. NO.
Round Punch & Driver Assembly	35306
Round Punch	2398
Shape Punch & Driver Assembly	35296
Shape Punch	2399
Optima® Coating	—
STRIPPER	CAT. NO.
Round	77232
Shape	77233
DIE	CAT. NO.
Round Slug Hugger**	77236
Round Standard	77234
Shape Slug Hugger* 2*	77237
Shape Positive	77235
Maximum A Dimension 1.250" [31.75mm]	


MT8Ri

PUNCH	CAT. NO.
Round Punch	6835
Shape	6836
Optima® Coating	—
STRIPPER	CAT. NO.
Round	474
Shape	473
DIE	CAT. NO.
Round Slug Hugger**	6177
Round Standard	6164
Shape Slug Hugger* 2*	6889
Shape Positive	6165
Shape Negative	6178
Maximum A Dimension .630" [16mm]	


MT 6-16 & MT 10-16

PUNCH	CAT. NO.
Round Punch	6075
Shape	6076
Optima® Coating	—
STRIPPER	CAT. NO.
Round	6073
Shape	77233
DIE	CAT. NO.
Round Slug Hugger**	6187
Round Standard	6077
Shape Slug Hugger* 2*	6883
Shape Positive	6078
Shape Negative	6192
Maximum A Dimension .630" [16mm]	


MT 12-8

PUNCH	CAT. NO.
Round Punch	6080
Optima® Coating	—
STRIPPER	CAT. NO.
Round	6079
DIE	CAT. NO.
Round Slug Hugger**	6185
Round Standard	6081
Maximum A Dimension .315" [8mm]	

MT 6-24 & MT 8-24

PUNCH	CAT. NO.
Round Punch	6150
Shape	6153
Optima® Coating	—
STRIPPER	CAT. NO.
Round	6151
Shape (.750" [19.05mm] maximum A Dimension)	6827
Shape (7.756" [19.05mm] A Dimension)	6154
DIE	CAT. NO.
Round Slug Hugger**	6189
Round Standard	6152
Shape Slug Hugger* 2* .750" maximum	6886
Shape Slug Hugger* 2* > .750"	6887
Shape Positive .750" maximum	6828
Shape Positive > .750"	6155
Shape Negative .750" maximum	6830
Shape Negative > .750"	6194
Maximum A Dimension .945" [24mm]	

MT 20-8 & MT 24-8

PUNCH	CAT. NO.
Round Punch	6080
Shape	6147
Optima® Coating	—
STRIPPER	CAT. NO.
Round	6146
Shape	6148
DIE	CAT. NO.
Round Slug Hugger**	6185
Round Standard	6081
Shape Slug Hugger* 2*	6885
Shape Positive	6149
Shape Negative	6190
Maximum A Dimension .315" [8mm]	

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



SPECIALS

YOU NEED BETTER SOLUTIONS, FASTER!

Wilson Tool International approaches every special tooling request with a “never say no” attitude. And with the fastest lead times in the industry, your special tooling will arrive when you need it.

Scan QR Code to
Access Our Templates
for Punching Specials



Incorporating forming applications into your fabrication can add value to your processes while reducing cost by boosting efficiencies and eliminating secondary operations.

No matter how unique your requirement, Wilson Tool works with you to design and manufacture punch press tooling that meet the needs of your most demanding application. Our highly skilled engineers and toolmakers combine unmatched experience with specialized manufacturing systems to produce products that meet any challenge.

Wilson Tool forming tools are manufactured with high grade materials to maximize tool life and machine up time. They are engineered with features like positive stopping to ensure you consistently get a form to your specifications on every hit. And when working with challenging material, Wilson Tool offers solutions like coatings to improve stripping and reduce sheet marking. Each special tool is tested using our in-house punch presses, and a sample is included with every forming special tool we ship. Wilson Tool specials are manufactured to our superior quality standards and tolerances and with the shortest lead times available.

QUICKTAP® TAPPING TOOLS

SPECIALS

Scan QR Code to See QuickTap® Tapping Tools in Action



APPLICATION	TAP RANGE
<p>Create high precision threads at any programmed location on the sheet.</p> <ul style="list-style-type: none"> • Taps available in imperial or metric sizes • Available for most major brands of thick turret style punch presses. 	<p>B Station: #2-56 - 10-32 or M2.5 - M5 metric</p> <p>C Station: #2-56-12-24 or M2.5 - M5 metric</p> <p>D Station: #10-24 - 3/8-16 or M6 - M10 metric</p>
ADVANTAGES	INFORMATION NEEDED
<ul style="list-style-type: none"> • Fast! Tap a hole or an extruded hole with every machine stroke, up to 200 holes per minute. • Built-in tapping fluid injection system is synchronized with the machine stroke to reduce wear and breakage. • Taps are easily changed, with no disassembly required. • Works on a wide range of material. • Stock size pitch inserts and taps are available for fast delivery. 	<ul style="list-style-type: none"> • Machine Make • Machine Model • Machine Serial Number



QUICKTAP® TAPPING TOOLS

DESCRIPTION	SIZE	CAT. NO.	PRICE
QuickTap® Tapping Kit*	B Station	14950	
	C Station	14478	
	D Station	14480	
QuickTap® Endure Tapping Oil	5 Gallons	14525	
QuickTap® Vapor Tapping Oil	5 Gallons	14526	
QuickTap® Tapping Tool Lubricant	1 Quart	989941	
Prolong Grease Cartridge	14 oz.	987487	
Ejector Repair Kit	—	14504	



*Kit includes all items needed to install, operate and maintain the tool except tapping oil.

TAP SIZE	TIN COATED		TICN COATED	
	CAT. NO.	PRICE	CAT. NO.	PRICE
B / C STATION TAPS[†]				
2-56, H3	987449		987450	
4-40, H3	—	—	987452	
4-40, H5	987451		—	—
4-40, H7	987453		—	—
6-32, H5	987454		987455	
6-32, H7	987456		—	—
8-32, H5	987458		987459	
8-32, H7	987460		987479	
10-24, H6	987461		987447	
10-32, H6	987462		987463	
12-24, H6*	987464*		987465*	
M2.5 x .45 D5	987466		987467	
M3 x .5 D5	987469		987470	
M3 x .5 D7	987471		—	—
M3.5 x .6 D6	987468		—	—
M4 x .7 D6	987472		987474	
M5 x .8 D7	987475		987476	
D STATION TAPS[†]				
10-24, H6	987461		—	—
12-24, H6	987464		—	—
1/4-20, H6	987478		—	—
1/4-28, H6	987858		—	—
5/16-18, H7	987667		—	—
3/8-16, H5	987546		—	—
M6 x 1.0, D8	987480		987481	
M8 x 1.25 D9	987681		—	—
M10 x 1.5, D10	987682		—	—

[†]Additional sizes available upon request.

*Not available for B Station tool. Only available for C Station tool.

PITCH INSERT ASSEMBLIES	CAT. NO.	PRICE
B / C STATION ASSEMBLIES		
#20	14476	
#24	14443	
#24 HD	14444	
#28	14498	
#32	14445	
#32 HD	14446	
#36	14447	
#40	14448	
#48	14449	
#56	14450	
M2 x .40	14451	
M2.5 x .45	14452	
M2.6 x .45	14499	
M3 x .5	14453	
M3.5 x .6	14454	
M4 x .7	14455	
M5 x .8	14456	
M5 x .8 HD	14457	
D STATION ASSEMBLIES		
#16	14639	
#18	14638	
#20	14637	
#24	14636	
#28	14634	
#32	14632	
M6 x 1.0	14640	
M8 x 1.25	14641	
M10 x 1.5	14642	

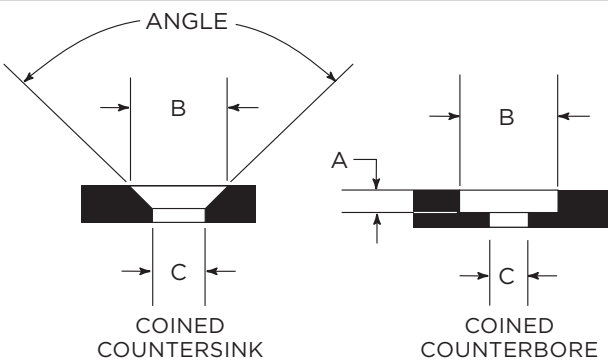
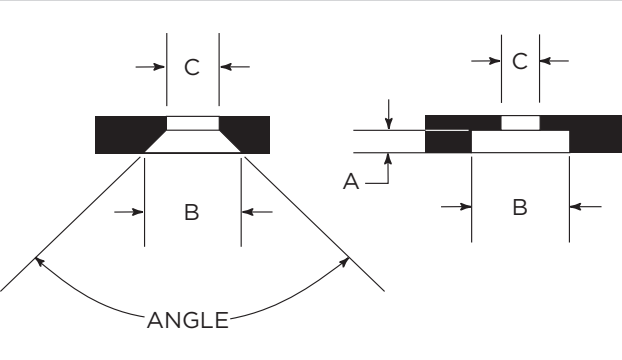
SPECIALS

COINING TOOLS — FORM-DOWN / FORM-UP



Scan QR Code to Access Our
Templates for Punching Specials

SPECIALS

FORM-DOWN	FORM-UP
	
<p>Estimated pre-punch formula: $B - [(B - C) \times .75] = \text{Pre-punch}$</p>	

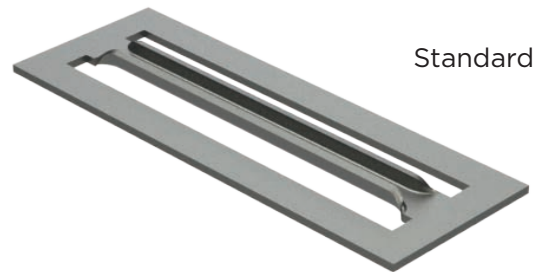
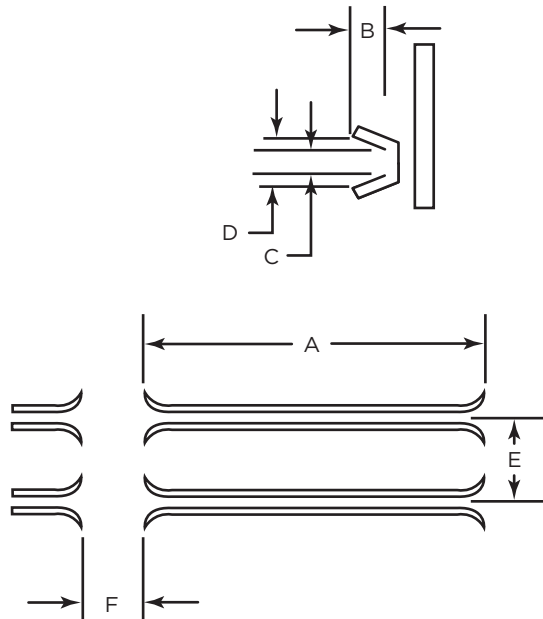
COMMON IN STATION SIZES

A	B	C	D	E
1/2"	1-1/4"	2"	3-1/2"	4-1/2"

APPLICATION	ADVANTAGES	INFORMATION NEEDED
Coining tools are used for forming countersinks and counter bores for screws or to deburr the edge of a hole.	<ul style="list-style-type: none"> • Coining on the punch press eliminates costs and time when compared to a secondary operation of machining countersinks. • Interchangeable inserts for form down countersinks allow you to easily change coin sizes and reduce tooling costs • Form up coin dies are self-stripping • Multiple coating options available to aid in stripping 	<ul style="list-style-type: none"> • Machine Model • Material thickness and type • Angle, coin Diameter B, thru-hole size with or without Pilot C • Form-up or form-down



CARD GUIDE — FORM-UP



Standard



Wrap Around



Closed End



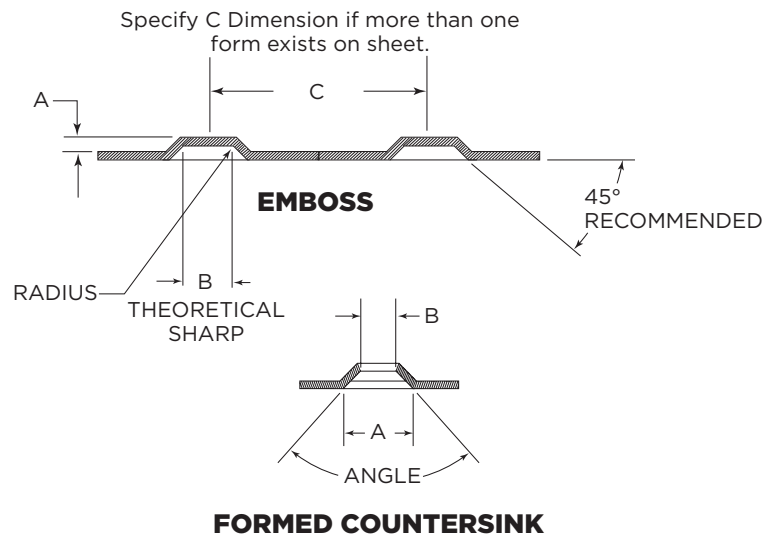
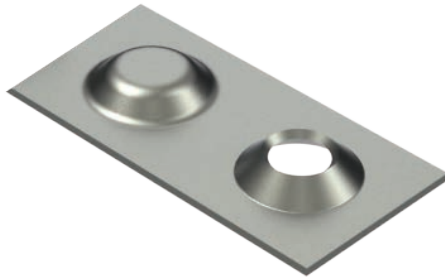
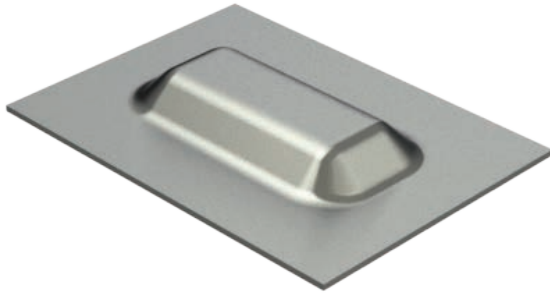
Scan QR Code to Access Our Templates for Punching Specials

COMMON IN STATION SIZES



APPLICATION	ADVANTAGES	INFORMATION NEEDED
<ul style="list-style-type: none"> A card guide is used for retaining printed circuit boards that require standard lead-in or special lead-in shapes. Wilson Tool will estimate the web of material to be formed on all card guides and the pre-punch shape and size on special lead-in card guides. 	<ul style="list-style-type: none"> The replaceable insert design allows for lower costs and conversion to different size card guides Fast and simple length adjustment Special lead-ins are available Built in stripping for best results Tooling is ABS capable Multiple coating options available to aid in stripping 	<ul style="list-style-type: none"> Machine Model Material thickness and type Dimensional drawing or electronic file — center-to-center location and narrowest pre-punch. Pre-punch shape rectangle, obround, or rectangle with radius corners

EMBOSS — FORM-DOWN / FORM-UP



SPECIALS

COMMON IN STATION SIZES

A	B	C	D	E
1/2"	1-1/4"	2"	3-1/2"	4-1/2"

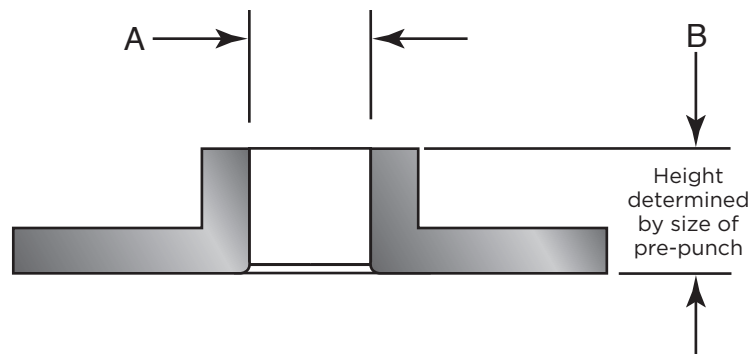
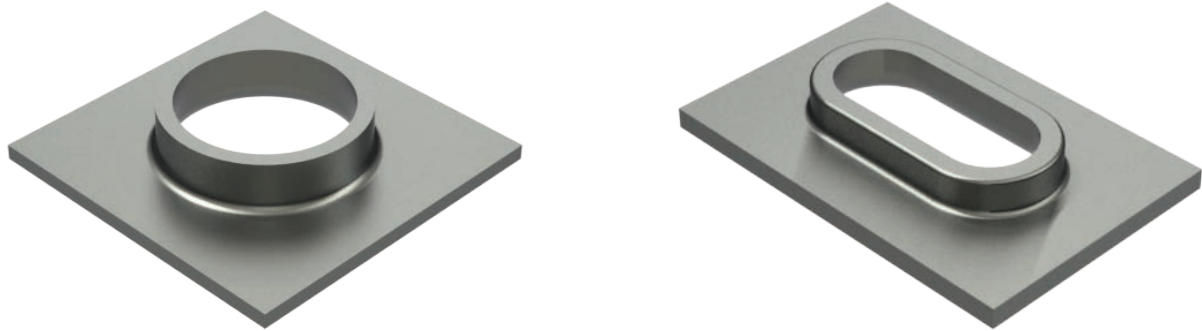


Scan QR Code to Access Our Templates for Punching Specials

APPLICATION	ADVANTAGES	INFORMATION NEEDED
<ul style="list-style-type: none"> Embosses, dimples and forming tools are typically used to create stand-offs, spacers, countersinks, locks for nuts. Logo embosses and other special shapes can be manufactured easily when an electronic file is provided. 	<ul style="list-style-type: none"> All tools are made to achieve a consistent high quality form. Form up designs are self-stripping. A and B Station embosses are full body designs to give maximum bearing area to sheet. Large station tools are a punch, stripper, and die design that will fit your existing holder assembly. 	<ul style="list-style-type: none"> Machine Model Material thickness and type Dimensional drawing or electronic file Form-up or form-down Style of large station guide assembly



EXTRUSION



COMMON IN STATION SIZES

A	B	C	D	E
1/2"	1-1/4"	2"	3-1/2"	4-1/2"



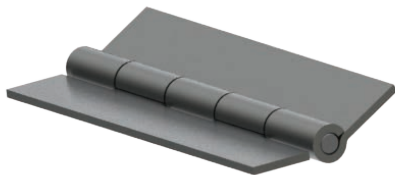
Scan QR Code to Access Our Templates for Punching Specials

APPLICATION	ADVANTAGES	INFORMATION NEEDED
<p>Extrusions are used in a broad spectrum of applications:</p> <ul style="list-style-type: none"> • Self-tapping screws • Cooling tube holders • Air flow applications • Tread plates 	<ul style="list-style-type: none"> • B Station extrusions are an insert style for fast and economical replacement. • Form-down extrusions are designed to be self-stripping, providing consistent and trouble-free operation. • The large station universal holder provides cost savings and flexibility. Purchase only a punch tip, ejector and die assembly to change size. • The large station holder is ABS capable. • Multiple coating options available to aid in stripping. 	<ul style="list-style-type: none"> • Machine Model • Material thickness and type • I.D. and height or screw size and type • Tolerance of I.D. • Form-up or form-down • Specify center-to-center if more than one extrusion exists on the sheet

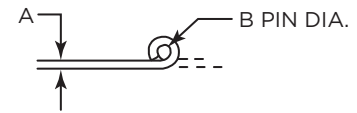
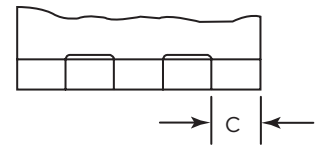
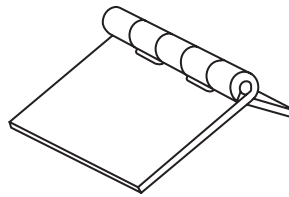
HINGE TOOL



Standard Fully Curled Hinge



Offset Fully Curled Hinge



One-Hit Half Knuckle Hinge



Scan QR Code to Access Our Templates for Punching Specials



Scan QR Code to See Hinge Tool in Action

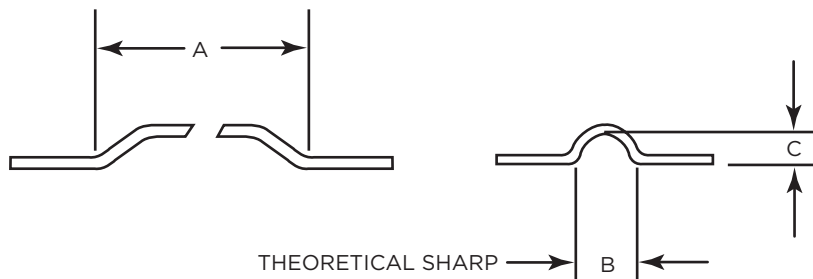
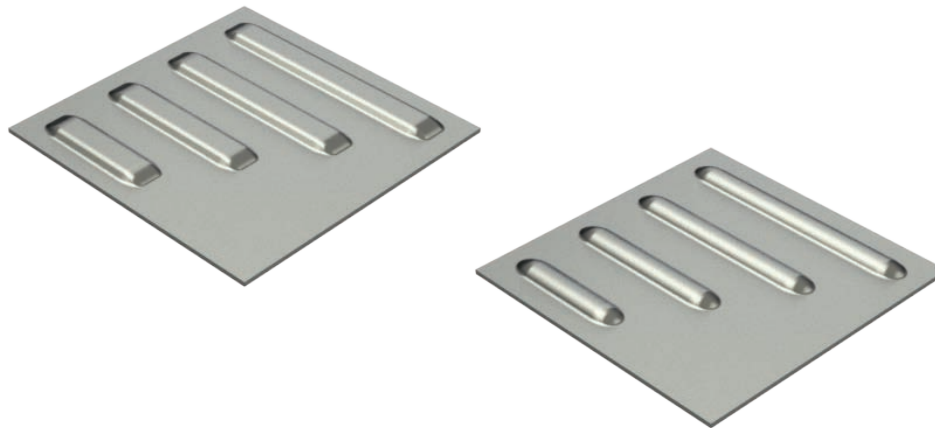
COMMON IN STATION SIZES

A	B	C	D	E
1/2"	1-1/4"	2"	3-1/2"	4-1/2"

APPLICATION	ADVANTAGES	INFORMATION NEEDED
Integrating a formed hinge on the edge of the sheet in your turret machine eliminates the need for costly hardware and a secondary operation to weld or fasten them.	<ul style="list-style-type: none"> Wilson Tool's one-hit hinge tool is achieved with 1 set of tools. Standard hinge is achieved with 2 sets of tools. Offset hinge requires 3 sets of tools. 	<ul style="list-style-type: none"> Machine Model Material thickness A and type Dimensional drawing or electronic file — inside diameter or pin size B Knuckle size C



PROGRESSIVE RIB



COMMON IN STATION SIZES

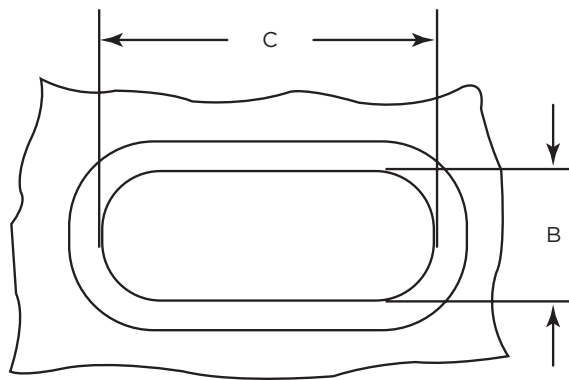
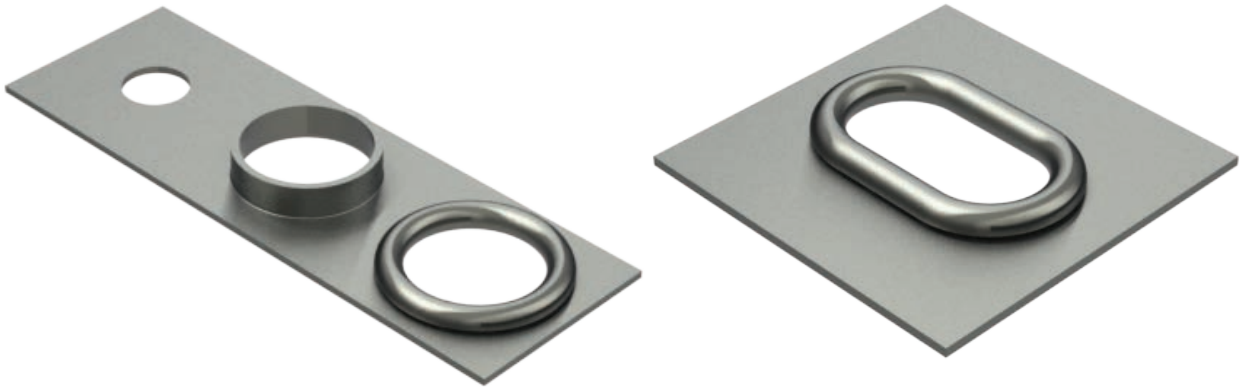
A	B	C	D	E
1/2"	1-1/4"	2"	3-1/2"	4-1/2"



Scan QR Code to Access Our Templates for Punching Specials

APPLICATION	ADVANTAGES	INFORMATION NEEDED
<ul style="list-style-type: none"> A progressive rib produces quality stiffening ribs, programmable to any length. Rounded or flat top ribs are available. For best results, inside radius should be equal to or greater than the height. Run in nibbling mode recommended (incremental moves should be equal to the material thickness or less). 	<p>The large station universal holder provides fast and easy length adjustments, cost savings and flexibility:</p> <ul style="list-style-type: none"> Purchase a punch tip and die to change size The same upper holder can be used for electrical knockouts, extrusions, and lance and forms. <p>When changing material thicknesses, only one component is required.</p> <p>The large station holder is ABS capable.</p>	<ul style="list-style-type: none"> Machine Model Material thickness and type Dimensional drawing or electronic file Specify center-to-center if more than one form exists on the sheet

ROLLOVER TOOL



ROLLOVER



HEMMING

COMMON IN STATION SIZES

A	B	C	D	E
1/2"	1-1/4"	2"	3-1/2"	4-1/2"

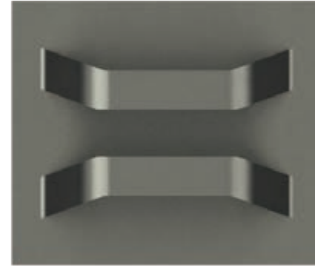
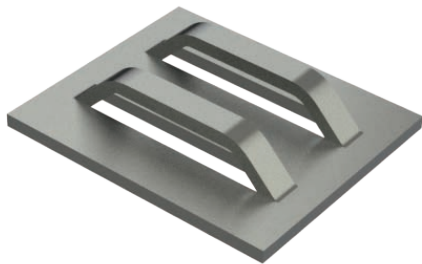
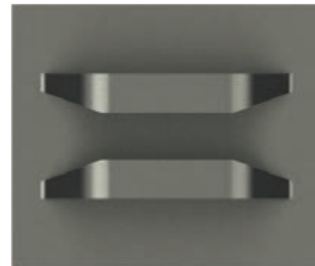
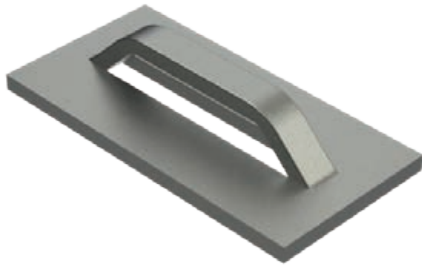


Scan QR Code to Access Our Templates for Punching Specials

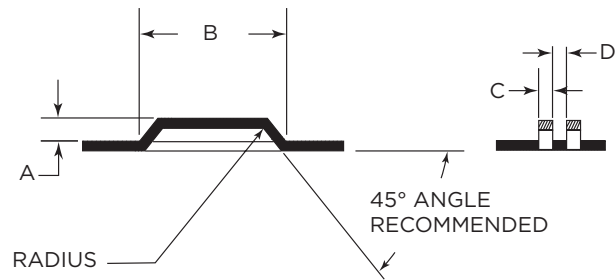
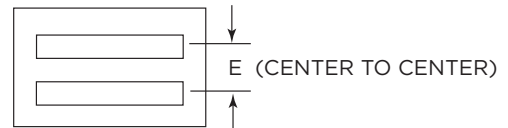
APPLICATION	ADVANTAGES	INFORMATION NEEDED
<p>Rollover and hemming tools can be used in many applications such as hand holds, wire feeds and grommets.</p> <ul style="list-style-type: none"> Rollover is achieved in three operations: <ol style="list-style-type: none"> Pre-punch (developed by Wilson Tool free of charge) Form-up extrusion Rollover Hemming is achieved in three operations: <ol style="list-style-type: none"> Pre-punch (developed by Wilson Tool free of charge) Form-up extrusion Flare & Flatten. 	<ul style="list-style-type: none"> Reduces costly secondary operations and handling. Designed and manufactured to produce consistent results. Multiple coating options available to extend tool life. 	<ul style="list-style-type: none"> Machine Model Material thickness and type Diameter or length and width of opening C and B Tolerance of opening What type of application (hand hold, wire feed, etc.) Style of guide assembly



BRIDGE LANCE & FORM



Scan QR Code to Access Our Templates for Punching Specials

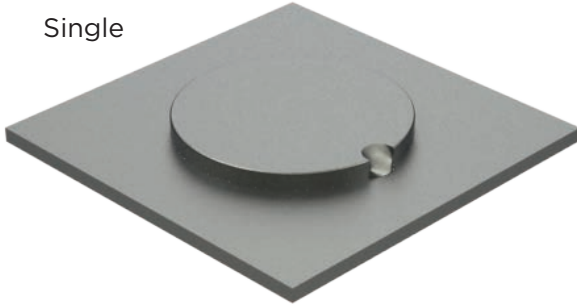


COMMON IN STATION SIZES				
A	B	C	D	E
1/2"	1-1/4"	2"	3-1/2"	4-1/2"

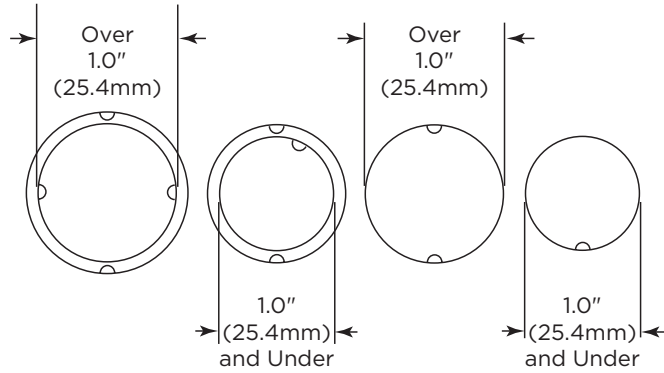
APPLICATION	ADVANTAGES	INFORMATION NEEDED
Bridge style lance and forms can be used for: <ul style="list-style-type: none"> • shear stops • locators • card guides • dividers • ventilation • wire tie downs 	The Wilson Tool design creates a positive form ensuring a high quality, consistent part. Small and large station holders provide both cost savings and flexibility: <ul style="list-style-type: none"> • Purchase only a punch tip, ejector and die assembly to change size. • Use the same upper holder for other applications. Special lead-ins available. Form-down bridges are made self-stripping. The large station holder is ABS ready. Multiple coating options available to aid in stripping.	<ul style="list-style-type: none"> • Machine Model • Material thickness and type • Dimensional drawing or electronic file for relief • Top, side and end views • Form-up or form-down

EKO — ELECTRICAL KNOCKOUT

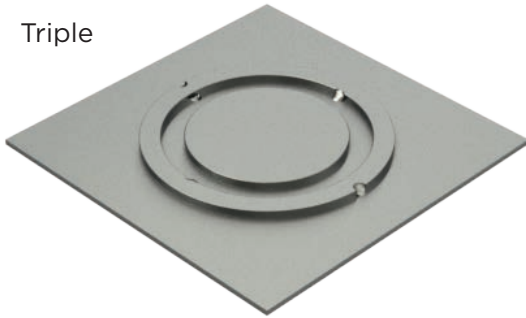
Single



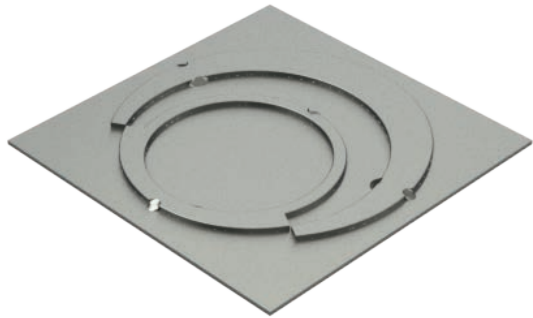
Standard Wilson Tool Tab Location



Triple



SPECIALS



Quad Tangential



Scan QR Code to Access Our Templates for Punching Specials

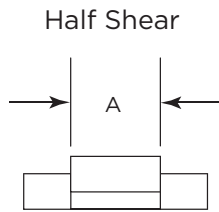
COMMON IN STATION SIZES



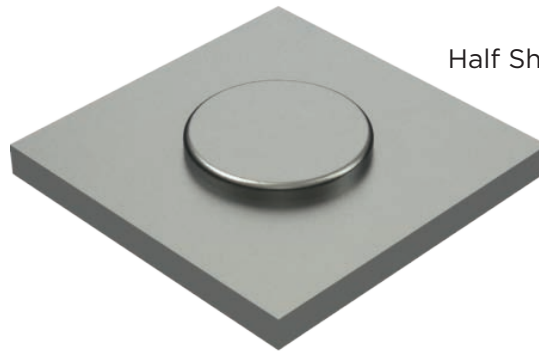
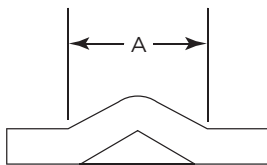
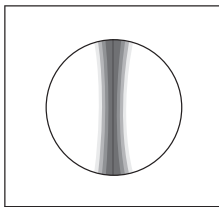
APPLICATION	ADVANTAGES	INFORMATION NEEDED
<p>Electrical knockouts (EKOs) are used to create connection points for cable pathways. Available for:</p> <ul style="list-style-type: none"> • Single • Double (concentric or tangential) • Triple (concentric or tangential) • Quad (concentric or tangential) • Standard and special shapes <p>Single or multiple tools can be used to produce the desired number of EKOs for your requirements.</p>	<p>Wilson Tool's EKO design has full stripping in both upper and lower units, which produce good quality, reliable knockouts every time.</p> <p>The universal holder provides both cost savings and flexibility.</p> <ul style="list-style-type: none"> • Purchase only a punch tip, ejector and die assembly to change size. • Use the same upper holder for other applications. <p>The large station holder is ABS capable. Multiple coating options available for extending tool life.</p>	<ul style="list-style-type: none"> • Machine Model • Material thickness, type or range • Actual diameter • Specify center-to-center if more than one knockout exists on the sheet. • Form-up or form-down



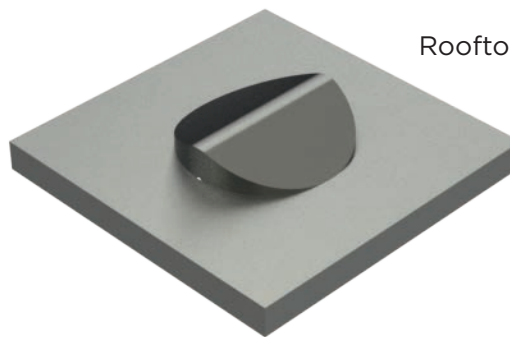
HALF SHEAR / ROOFTOP HALF SHEAR



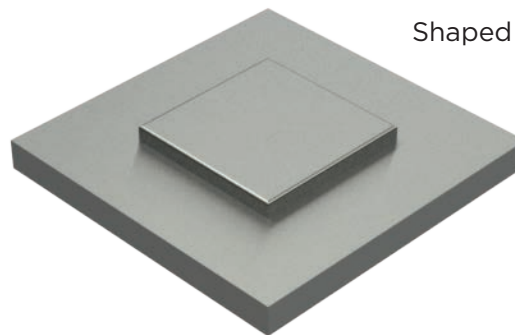
Rooftop Half Shear



Half Shear



Rooftop Half Shear



Shaped Half Shear

COMMON IN STATION SIZES

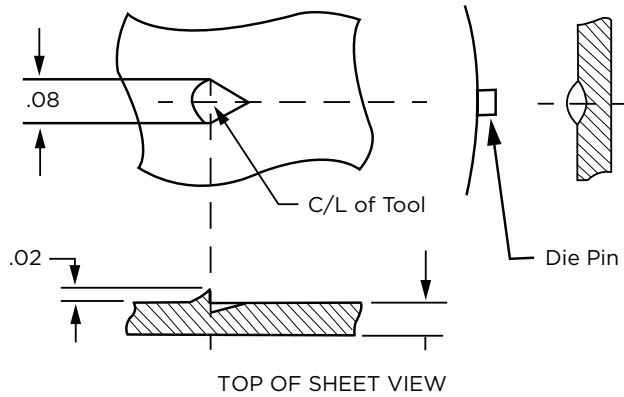


Scan QR Code to Access Our Templates for Punching Specials

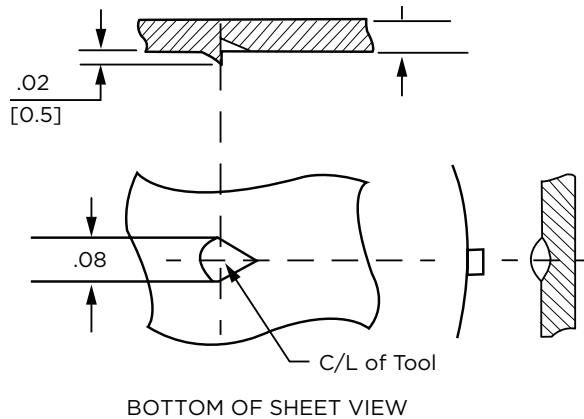
APPLICATION	ADVANTAGES	INFORMATION NEEDED
<p>The half shear is an easy-to-use tool that allows you to put in shear buttons and spot welding locators to the accuracy of your punch press.</p> <ul style="list-style-type: none"> • Round half shears make excellent locators for angular shearing. • Rooftop half shears have approximately a 3 gauge material thickness range. 	<ul style="list-style-type: none"> • Form-up half shears are available in stock sizes. • B Station form-up half shears have replaceable inserts up to .375" [9.53mm] diameter in lower unit. • Rooftop half shears give you greater height protrusion compared to a standard half-shear when using thinner material. • Half shears can be used on a .125" [3.17 mm] range of material. 	<ul style="list-style-type: none"> • Machine Model • Material thickness and type (or range) • Diameter or shape (on top of sheet) • Specify center-to-center if more than one exists on the sheet. • Form-up or form-down

SCRATCH TOOL

Top of Sheet



Bottom of Sheet



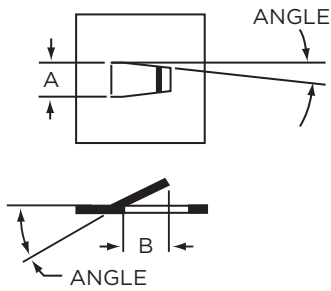
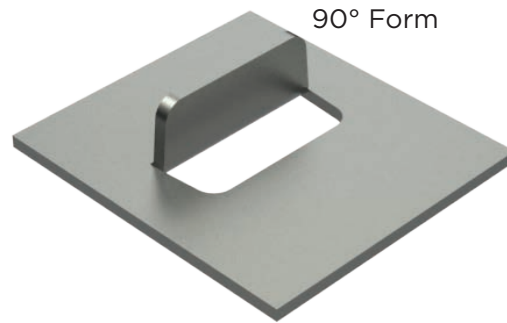
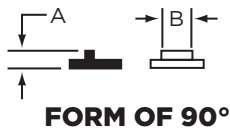
COMMON IN STATION SIZES

A	B	C	D	E
1/2"	1-1/4"	2"	3-1/2"	4-1/2"

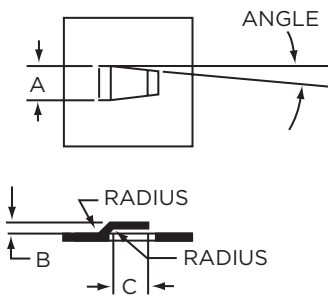
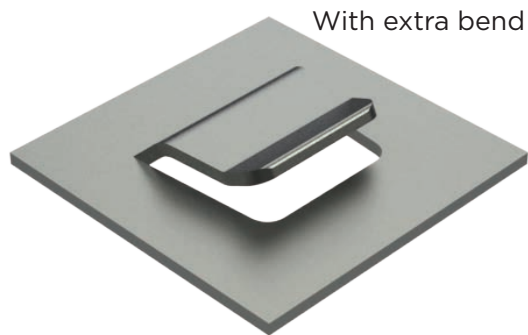
APPLICATION	ADVANTAGES	INFORMATION NEEDED
<p>The scratch form can be used for spot welding locators, locators for angular shearing and shear stops.</p> <ul style="list-style-type: none"> • Height of the stop is .020" - .030" [.5mm - .8mm] • Tool is designed with relief for .500" [12.7mm] centers 	<ul style="list-style-type: none"> • Punches a range of material from .036" - .125" [.91mm - 3.18mm] • Can be used in an Auto Index station 	<ul style="list-style-type: none"> • Machine Model • Material thickness and type • Specify top or bottom of the sheet scratch



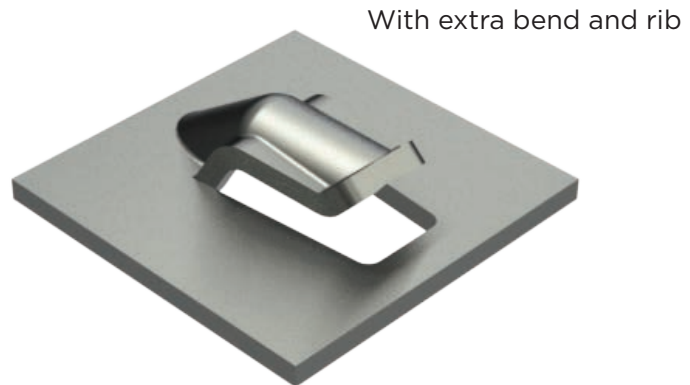
LANCE & FORMS



OTHER THAN 90°



OTHER THAN 90°



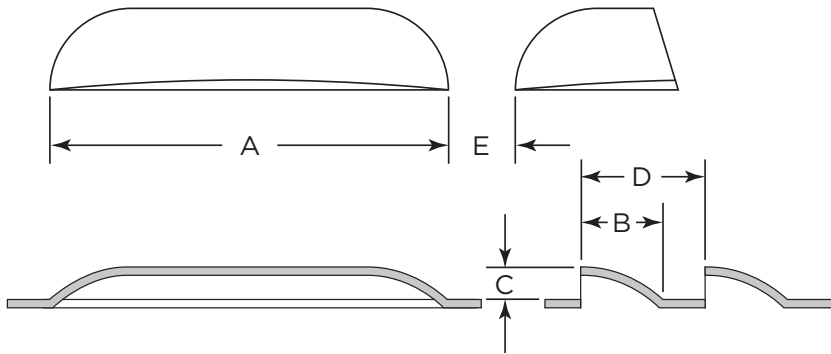
COMMON IN STATION SIZES



Scan QR Code to Access Our Templates for Punching Specials

APPLICATION	ADVANTAGES	INFORMATION NEEDED
<p>Lance and forms are used for a variety of applications, including:</p> <ul style="list-style-type: none"> • Air flow • Decoration • Location markers • Shear tabs • Wire harnesses • Clip attachments 	<p>High-quality lance and forms are assured with Wilson's positive form and self-stripping design.</p> <p>Lance and form other than 90° holder provides both cost savings and flexibility;</p> <ul style="list-style-type: none"> • Purchase only a punch tip, ejector and die assembly to change size; • Use the same upper holder for other applications. <p>The large station holder is ABS capable. Multiple coating options available to extend tool life.</p>	<ul style="list-style-type: none"> • Machine Model • Material thickness and type • Dimensional drawing or electronic file and pattern if relief is required. • Style of large station guide assembly — for lance and forms of 90° only (e.g. series 80/90, Old Style, etc.) • A taper of 5° per side should be added (if possible) to aid in stripping large station lance and forms. • Form-up or form-down

LOUVERS



COMMON IN STATION SIZES

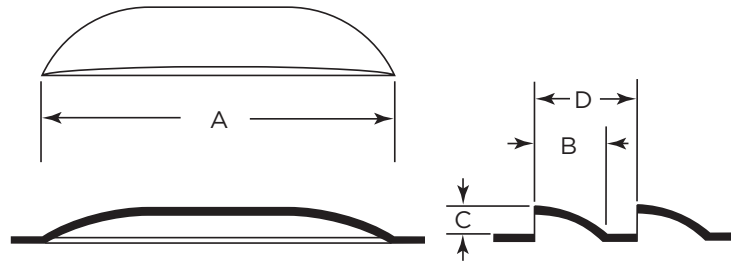


Scan QR Code to Access Our Templates for Punching Specials

APPLICATION	ADVANTAGES	INFORMATION NEEDED
<ul style="list-style-type: none"> Louvers are used in a variety of industry applications that require airflow; electrical enclosures, HVAC, and food service equipment. Single hit louvers can be placed back to back (no web between louvers.) 	<p>Lower costs with replaceable inserts that can be converted to different size louvers. Stock sizes available.</p> <p>The large station universal holders provide both cost savings and flexibility:</p> <ul style="list-style-type: none"> Purchase only pocket, cutting, and forming inserts to change size. Use the upper holder for other applications <p>Keying at 0°, 90°, 180°, and 270° is standard</p> <p>The large station holder is ABS ready.</p> <p>Multiple coating options available to extend tool life.</p>	<ul style="list-style-type: none"> Machine Model Material thickness and type Dimensional drawing or electronic file



PROGRESSIVE LOUVERS



'A' dimension is programmable to any length.
Form length on first full hit is approximately 2-1/4" [57mm] long.

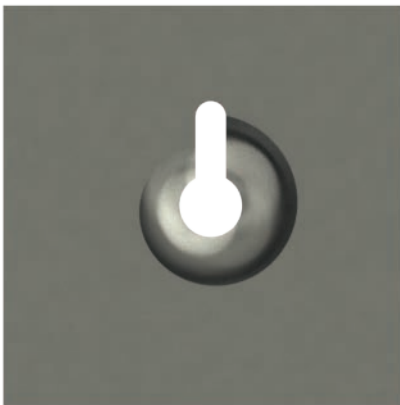
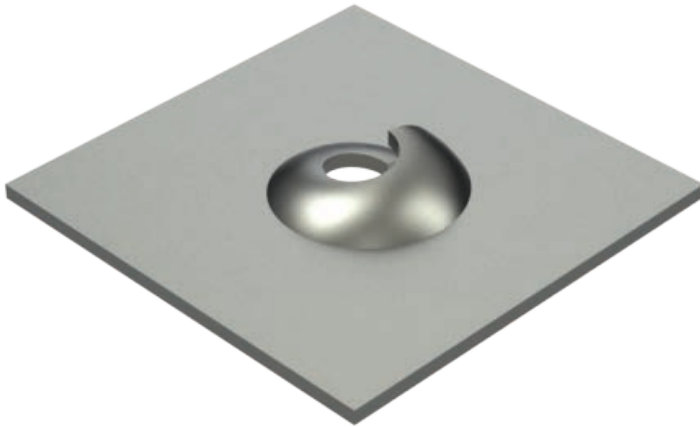
COMMON IN STATION SIZES



Scan QR Code to Access Our
Templates for Punching Specials

APPLICATION	ADVANTAGES	INFORMATION NEEDED
<ul style="list-style-type: none"> Progressive louvers are used in a variety of industry applications that require airflow; Electrical enclosures, HVAC, and food service equipment. The progressive design produces various length louvers to give flexibility using one tool. Run in nibbling mode (recommended incremental moves equal to the material thickness or less). A Do's and Dont's information sheet is provided for ease of programming. 	<p>Lower costs with replaceable inserts that can be converted to different size louvers. Stock sizes available.</p> <p>The large station universal holders provide both cost savings and flexibility:</p> <ul style="list-style-type: none"> Purchase only pocket, cutting, and forming inserts to change size. Purchase only pocket insert when changing material <p>Use the upper holder for other applications. Keying at 0°, 90°, 180°, and 270° is standard. The large station holder is ABS ready. Multiple coating options available to extend tool life.</p>	<ul style="list-style-type: none"> Machine Model Material thickness and type B, C and D Dimensions

THREAD FORM



THREAD FORM	
Screw Type	Thread Size
A	6 - 18 8 - 15 10 - 12 12 - 11 14 - 10 20 - 9
B	6 - 20 8 - 18 10 - 16 12 - 14 1/4 - 14 5/16 - 12
C (Machine Screws)	6 - 32 8 - 32 10 - 24 10 - 32 1/4 - 20 5/16 - 12

THREAD FORM DATA CHART		
MAX. MATERIAL THICKNESS WITH COINING		
Thread Size	inches	mm
6 - 15	.120	3.05
6 - 20	.100	2.54
6 - 32	.048	1.22
7 - 16	.094	2.39
8 - 15	.120	3.05
8 - 18	.094	2.39
8 - 32	.038	0.97
10 - 12	.125	3.18
10 - 16	.100	2.54
10 - 24	.067	1.70
10 - 32	.050	1.27
12 - 11	.120	3.05
12 - 14	.120	3.05
12 - 24	.068	1.73
14 - 10	.140	3.56
20 - 9	.125	3.18
1/4 - 14	.120	3.05
1/4 - 20	.094	2.39
5/16 - 12	.120	3.05
5/16 - 18	.094	2.39
3/16 - 24	.067	1.70
3/8 - 16	.079	2.01
1/2 - 13	.114	2.90
M2.9 x 1.1	.080	2.03
3.5 x 1.3	.100	2.54
3.9 x 1.4	.098	2.49
M4 x 0.7	.062	1.57
M4.2 x 1.4	.074	1.88
4.2 x 1.6	.094	2.39
4.8 x 1.6	.094	2.39
4.8 x 1.8	.100	2.54
M5 x 0.8	.050	1.27
5.5 x 1.8	.120	3.05
M6 x 1.0	.065	1.65
6.3 x 1.8	.120	3.05
M8 x 1.25	.074	1.88
8.0 x 2.1	.120	3.05
M10 x 1.5	.085	2.16
M12 x 1.75	.104	2.64

SPECIALS

COMMON IN STATION SIZES				
A	B	C	D	E
1/2"	1-1/4"	2"	3-1/2"	4-1/2"

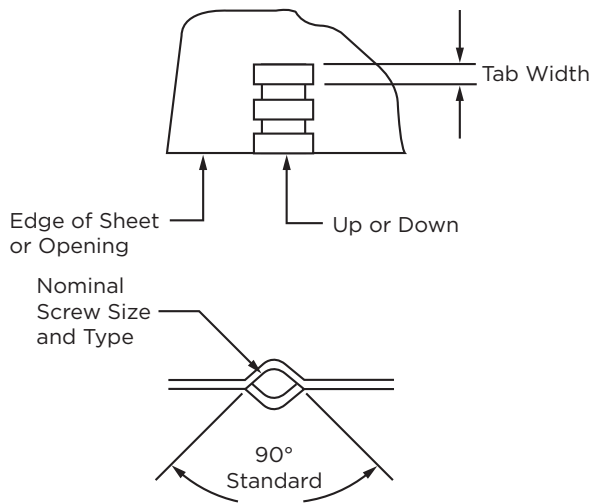
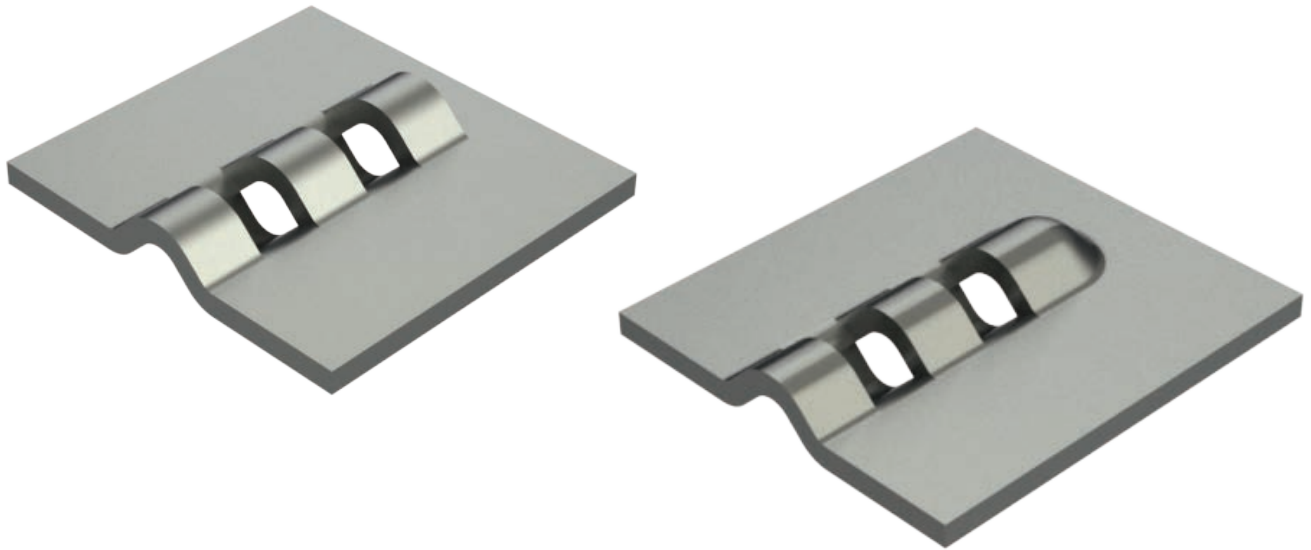


Scan QR Code to Access Our Templates for Punching Specials

APPLICATION	ADVANTAGES	INFORMATION NEEDED
A thread form is a great solution for eliminating secondary operations and supplemental hardware where a threaded hole is required.	<ul style="list-style-type: none"> Reduces costly hardware and assembly time. Coining is included in the design of the tool when material exceeds the recommended thickness up to 2 times. Pre-punch information is provided. Multiple coating options available to extend tool life. 	<ul style="list-style-type: none"> Machine Model Material thickness and type Thread size and type



THREAD LOOP



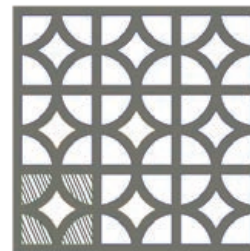
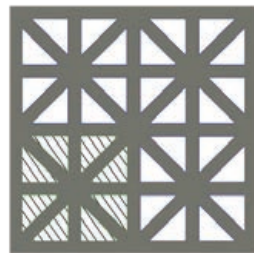
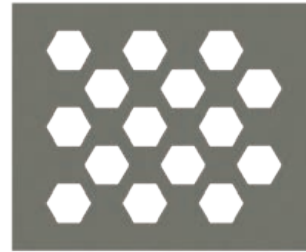
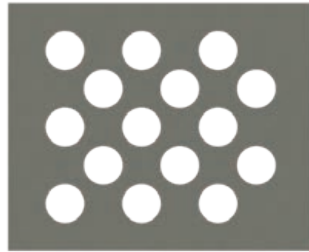
COMMON IN STATION SIZES				
A	B	C	D	E
1/2"	1-1/4"	2"	3-1/2"	4-1/2"



Scan QR Code to Access Our Templates for Punching Specials

APPLICATION	ADVANTAGES	INFORMATION NEEDED
A thread loop is a great solution for eliminating secondary operations and supplemental hardware when a threaded hole is required.	<ul style="list-style-type: none"> The Wilson Tool design gives a positive form, which ensures a high quality part. Reduces costly hardware and assembly time. Multiple coating options available to extend tool life. 	<ul style="list-style-type: none"> Machine Model Material thickness and type Number of thread loop tabs Width of tab Direction of first tab Diameter of opening or screw size and type Dimensional drawing or electronic file

CLUSTER TOOL



COMMON IN STATION SIZES



Scan QR Code to Access Our
Templates for Punching Specials

APPLICATION	ADVANTAGES	INFORMATION NEEDED
<ul style="list-style-type: none"> The cluster tool is the most cost effective method to manufacture perforated patterns and is commonly used for air ventilation, drains and filters. Cluster piercing is ideal for applications where tight tolerance is required on the hole pattern. 	<ul style="list-style-type: none"> Creates maximum number of holes with minimal hits. Saves on machine punching time and costly tool maintenance. Available in any hole size, shape or pattern. Holds tight tolerance from hole to hole. Punch available as solid or replaceable insert style. Wilson Tool's back bending feature on dies can help reduce sheet distortion. Multiple coating options available to extend tool life. Slug Hugger® 2 recommended to eliminate slug pulling. 	<ul style="list-style-type: none"> Machine Model Material type, thickness or range Number of holes in clusters Straight or staggered pattern Center-to-center dimensions Replaceable or solid design Style of large station guide assembly



ID-STAMP



COMMON IN STATION SIZES

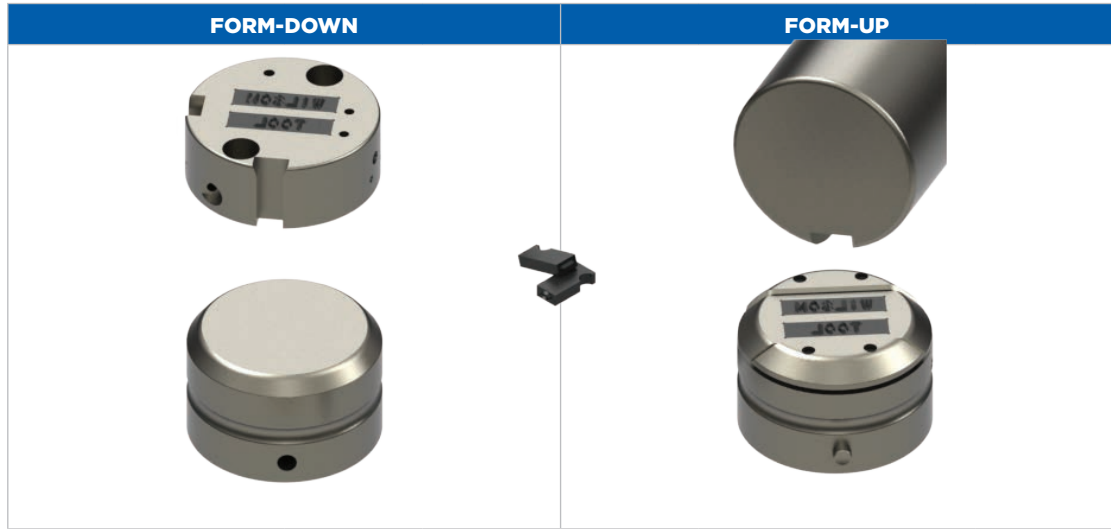
A	B	C	D	E
1/2"	1-1/4"	2"	3-1/2"	4-1/2"

APPLICATION	ADVANTAGES	INFORMATION NEEDED
<ul style="list-style-type: none"> An ID-Stamp tool is a perfect solution for permanently marking and displaying company names, serial numbers, or part numbers. When used in an Auto Index station you can stamp up to 40 different characters, including numbers, letters, and various symbols. Adjustable for .125" [3.18mm] material range. 	<ul style="list-style-type: none"> Eliminates secondary stamping operations and ensures consistent marking. Reduces the number of tools needed to mark parts. Designed to take the standard .125" [3.18mm] letter stamp character. The large station holder is ABS ready. Adapters can be used to move B Station tools to an Auto Index station. 	<ul style="list-style-type: none"> Machine Model Material thickness range and type Requires Auto Index

SPECIALS

LETTER STAMP

SPECIALS



SIZE	MAXIMUM NUMBER OF CHARACTERS PER ROW FOR 1- OR 2-ROW STAMP							
	B STATION 1-1/4"	C STATION 2"	D STATION 3-1/2"	E STATION 4-1/2"	B STATION 1-1/4"	C STATION 2"	D STATION 3-1/2"	E STATION 4-1/2"
1/16" [1.57mm]	22	24	48	64	20	31	53	64
3/32" [2.36mm]	14	16	32	43	14	21	35	43
1/8" [3.17mm]	10	12	24	32	10	15	26	32
3/16" [4.75mm]	7	8	16	21	7*	10	17	21
1/4" [6.35mm]	5	6	12	16	5*	8	13	16
3/8" [9.52mm]	3*	4*	8*	10*	3*	5*	8*	10*

*Available in 1-row configuration only



COMMON IN STATION SIZES

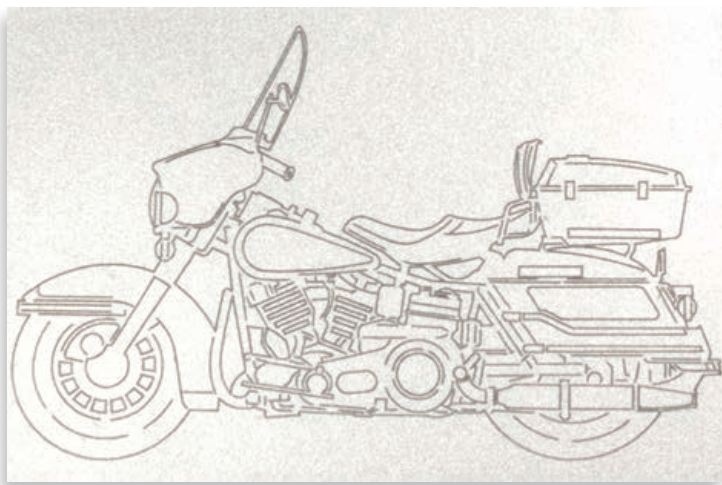
A
B
C
D
E

1/2" 1-1/4" 2" 3-1/2" 4-1/2"

APPLICATION	ADVANTAGES	INFORMATION NEEDED
<ul style="list-style-type: none"> A letter stamp is a perfect solution for permanently marking and displaying company names, serial numbers, or part numbers. Replaceable punch tip design allows for versatility as well as quick and easy change out. 	<ul style="list-style-type: none"> Stock sizes available in single and double row. Reduces the number of tools needed to mark parts. Eliminates secondary stamping operations. Adjustable for .125" [3.18mm] material range. Interchangeable punch tip design provides cost savings and flexibility to easily change character size by purchasing only a punch tip and characters. Form-up letter stamp tools are made self-stripping. 	<ul style="list-style-type: none"> Machine Model Material thickness and type Size character, number of rows, number of characters per row Form-up or form-down Style of large station guide assembly



WILSON MULTI-SCRIBE®

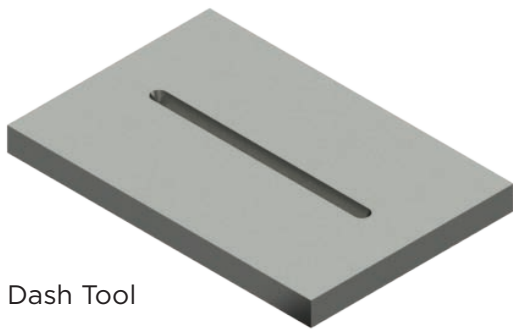


COMMON IN STATION SIZES

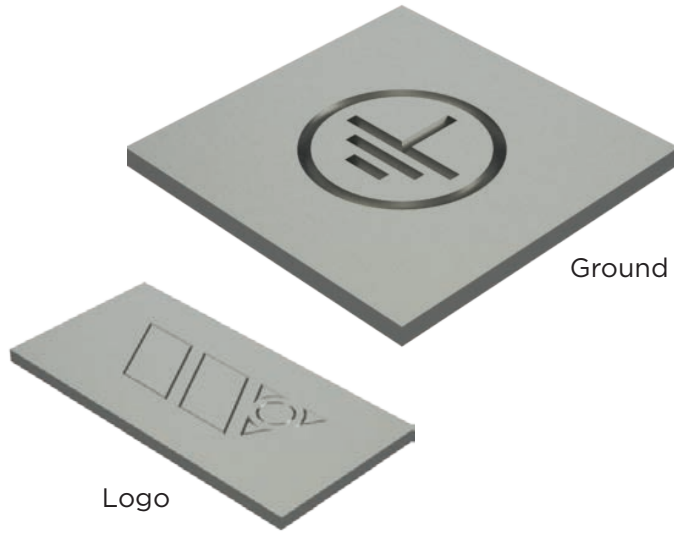
A	B	C	D	E
1/2"	1-1/4"	2"	3-1/2"	4-1/2"

APPLICATION	ADVANTAGES	INFORMATION NEEDED
<p>Wilson Multi-Scribe® is ideal for both sheet scribing and dot-matrix marking on a wide range of materials.</p> <ul style="list-style-type: none"> • Unique designs and logos can be achieved just by programming. • Hydraulic rams produce both “scribe” and “dot-matrix” sheet marking. • Mechanical rams produce “dot-matrix” sheet marking • Works on a wide range of materials. 	<ul style="list-style-type: none"> • Can achieve variable scribe depth • Design allows for consistent mark depth • Long lasting diamond tip • Won’t deform the material or mark the underside of the sheet. • Sold as a kit which includes: <ul style="list-style-type: none"> - Punch & die assembly - Red medium spring, yellow light spring, green heavy spring - 120° and 150° diamond insert - 90° carbide insert - 3mm hex wrench • Wilson Multi-Scribe tool comes assembled with 120° diamond and red medium spring. 	<ul style="list-style-type: none"> • Machine Model • Material thickness and type

STAMPING

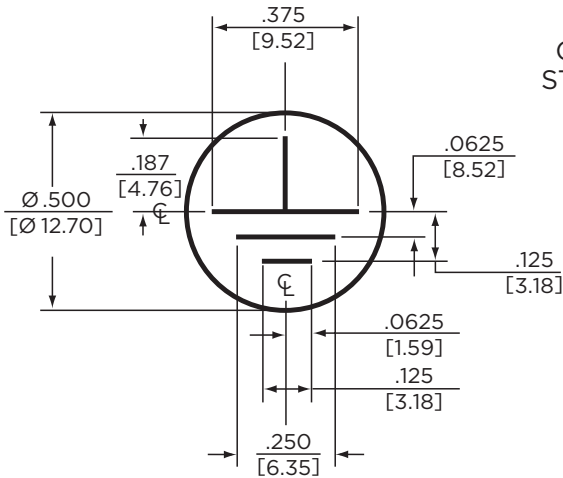


Dash Tool

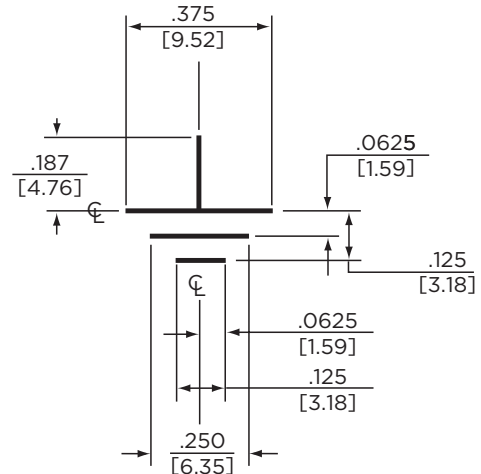


Ground Symbol

Logo



GROUND SYMBOL STOCK DIMENSIONS



COMMON IN STATION SIZES



APPLICATION	ADVANTAGES	INFORMATION NEEDED
<ul style="list-style-type: none"> Stamping the top or bottom of the sheet is the perfect solution for permanently displaying company names, serial numbers, symbols, and product or company logos. Ground symbols, widely used in the electrical industry are available in stock sizes, form-down or form-up. Dash tools can be used to "V" notch the sheet to aid in bending, create numbers and letters, and location marks on a sheet. Available in form-down or form-up, in various lengths and can be run progressively. 	<ul style="list-style-type: none"> All form-up tools are designed self-stripping to prevent sheet marking and tool wear. Logo stamps and other special stamps can be manufactured easily when an electronic file is provided. When used in the Auto Index station, dash tools can be used to create numbers or letters. Adjustable for .125" [3.18mm] material range. 	<ul style="list-style-type: none"> Machine Model Material thickness and type Length of dash Size of ground symbol (stock or non-stock) Electronic file for logos Form-up or form-down Style of large station guide assembly



PROGRESSIVE PIERCE, FORM & BLANK



Scan QR Code to See Tool in Action

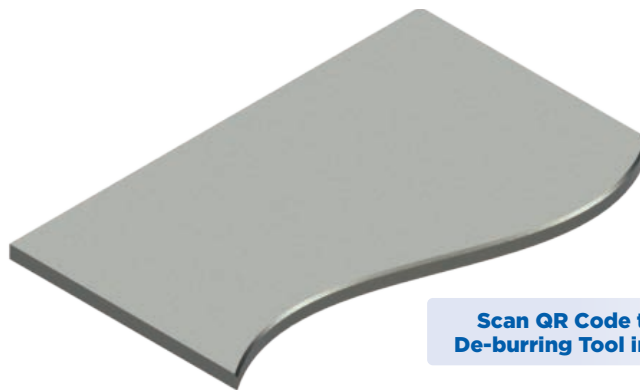


COMMON IN STATION SIZES



APPLICATION	ADVANTAGES	INFORMATION NEEDED
The progressive pierce, form and blank tool allows fabricators to economically produce very small runs of parts that traditionally would have a progressive die set.	<ul style="list-style-type: none"> • Creates the complete part • Lower tooling cost • Shorter tooling lead time • Dramatically reduced tooling set-up time. • Increased flexibility • Multiple coating options available to extend tool life 	<ul style="list-style-type: none"> • Machine Model • Material type and thickness • Style of large station guide assembly • Electronic file or dimensional drawing

ROLLING DE-BURR



COMMON IN STATION SIZES



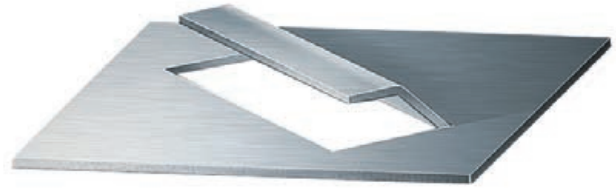
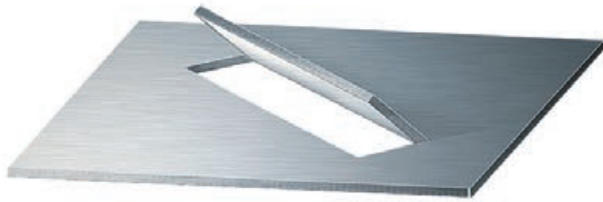
Scan QR Code to See De-burring Tool in Action



APPLICATION	ADVANTAGES	INFORMATION NEEDED
The rolling de-burring tool eliminates the secondary operation of removing burrs from your parts.	<ul style="list-style-type: none"> • Quickly and efficiently de-burrs your parts while on the turret machine. • Eliminates costly secondary operations. • Coins a small chamfer on the cut edge top and bottom of the sheet. • Can be used to de-burr nested parts. • Adjust ball pressure without disassembling the tool. 	<ul style="list-style-type: none"> • Machine Model • Material thickness and type

SPECIALS

HIGH FORMING TOOLS



SPECIALS

AVAILABLE FOR STATION SIZES
(DEPENDS ON MACHINE)

A

1/2"

B

1-1/4"

C

2"

D

3-1/2"

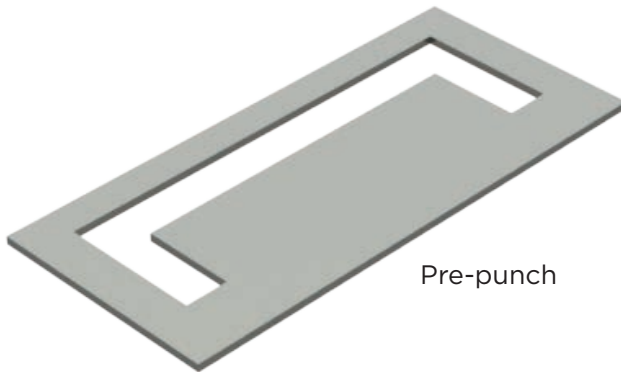
E

4-1/2"

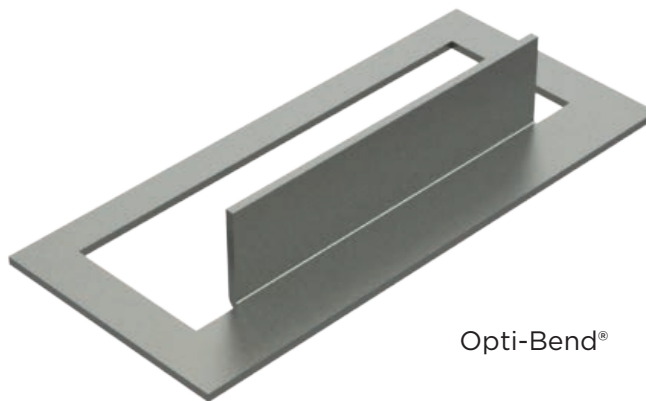
APPLICATION	ADVANTAGES	INFORMATION NEEDED
Machines with high form stations require special tooling that can achieve forms in the sheet up to .472" [12mm] high or higher.	<ul style="list-style-type: none"> • Able to form closer to the clamps with less distortion to the sheet. • Able to pierce holes in adjacent stations with less distortion. 	<ul style="list-style-type: none"> • Machine Model • Material thickness and type • Dimensional drawing or electronic file



OPTI-BEND®



Pre-punch

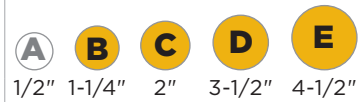


Opti-Bend®



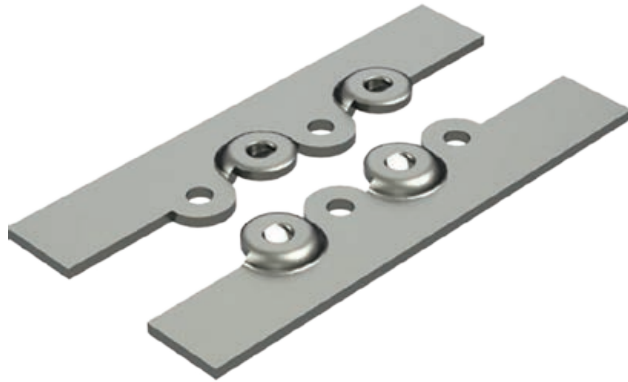
Scan QR Code to See Opti-Bend® in Action

COMMON IN STATION SIZES



APPLICATION	ADVANTAGES	INFORMATION NEEDED
<ul style="list-style-type: none"> Opti-Bend allows you to achieve exceptionally high bends (up to 90°) in your punch press, eliminating costly time-consuming secondary operations in a press brake. It is possible to achieve 3° over bend. 	<ul style="list-style-type: none"> Performs up to 90° bends on a punch press with neutral pull on the sheet (won't pull out of clamps). Special rotating cam design minimizes sheet marking on soft or high polished materials. Available in single hit or progressive styles. Can be run on a small range of material. Allows multiple bending in a turret machine. 	<ul style="list-style-type: none"> Machine Model Material thickness and type Dimensional drawing or electronic file

ZIP-TECH



SPECIALS

COMMON IN STATION SIZES

A	B	C	D	E
1/2"	1-1/4"	2"	3-1/2"	4-1/2"

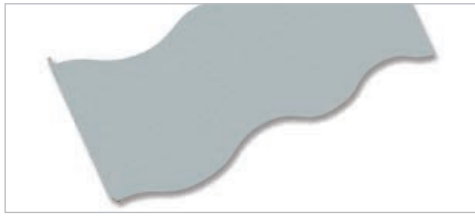
Scan QR Code to See
More Connective Forms



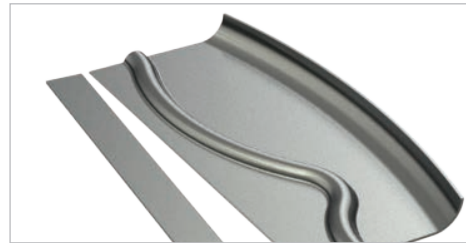
APPLICATION	ADVANTAGES	INFORMATION NEEDED
<p>Zip-Tech lance is achieved in three operations:</p> <ol style="list-style-type: none"> 1. Pre-punch: Round hole 2. Pre-punch: T-shape hole 3. Zip-Tech Lance and Form 	<ul style="list-style-type: none"> • Fabricates snaps to join metal parts together. • Different types of materials of the same thickness can be joined together. • Eliminate time consuming and labor intensive welding and grinding operations, spot welding or other fastening methods. 	<ul style="list-style-type: none"> • Machine Model • Material thickness and type • Auto Index stations available



WILSON WHEEL® FAMILY



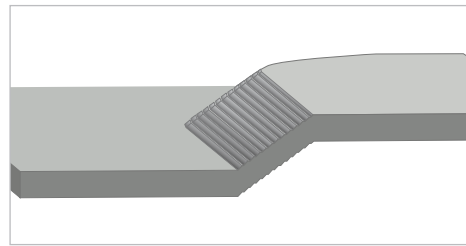
Rolling Shear



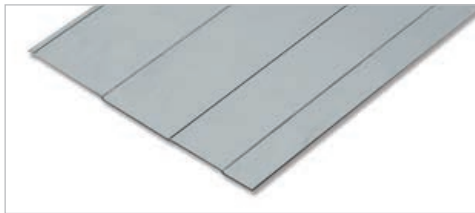
Rolling Flare



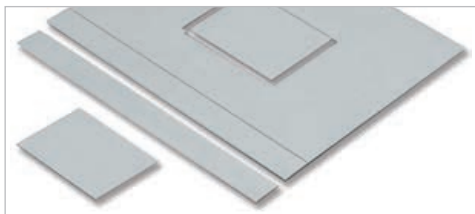
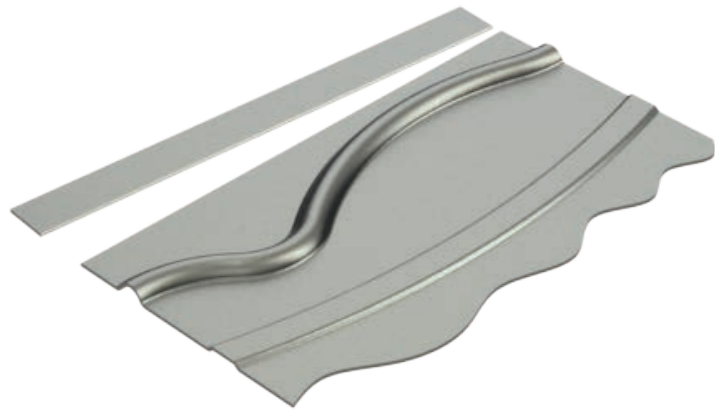
Rolling Rib



Rolling Forge



Rolling Offset



Rolling Pincher

Scan QR Code to See
the Wilson Wheel®
Family in Action



COMMON IN STATION SIZES

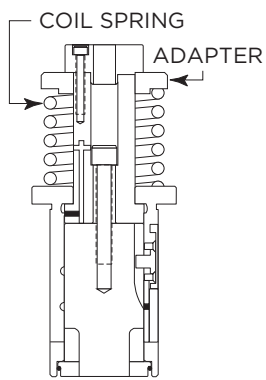
A	B	C	D	E
1/2"	1-1/4"	2"	3-1/2"	4-1/2"

APPLICATION	ADVANTAGES	INFORMATION NEEDED
<ul style="list-style-type: none"> The Wilson Wheel® family of products offers you flexible, high speed production of slits, ribs and offsets on a wide range of materials with virtually no burrs or nibble marks. Create curves, arcs and circles with your Auto Index station. 	<ul style="list-style-type: none"> High speed — equal to programmed table travel speed. Virtually no burrs or nibble marks on sheet. Eliminate scrap with rolling shear and pincher. Replacement forming wheels available. Available in form-up or form-down. Works on a wide range of material. Wheel tools can start or end anywhere on the sheet. Stock sizes available for fast delivery. 	<ul style="list-style-type: none"> Machine Model Material thickness and type Define fabrication needs

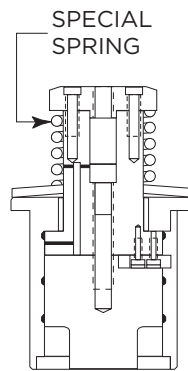
LIGHT SPRING UNIT



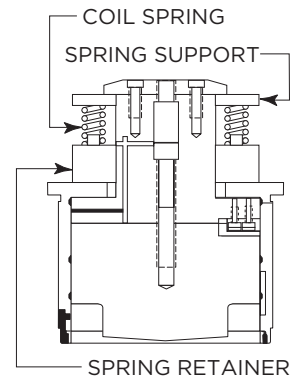
OTHER ASSEMBLY DESIGNS



A



C



D

COMMON IN STATION SIZES



A 1/2" **B** 1-1/4" **C** 2" **D** 3-1/2" **E** 4-1/2"

APPLICATION	ADVANTAGES	INFORMATION NEEDED
Light Spring Packs help reduce sheet and form distortion as well as sheet marking in forming and piercing operations.	<ul style="list-style-type: none"> • Fast and easy assembly and disassembly with Series 80, Series 80 Plus, Series 90 and High Performance (HP). • Simply spin off the existing spring unit and spin on the partial light spring unit. • Sold in partial or complete spring units. • Assembly instructions included. 	Type of holder



E-Z SET PUNCH HEAD

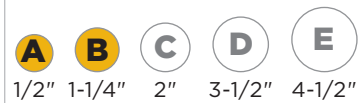


E-Z SET PUNCH HEAD	Cat. No.
A Station – Imperial	2481
B Station – Imperial	2369
B Station – Metric	2468

Scan QR Code to See
How to Install and
Adjust EZ Set Punch Head

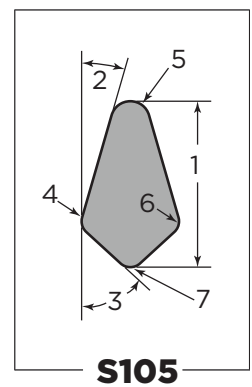
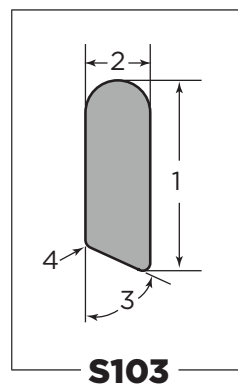
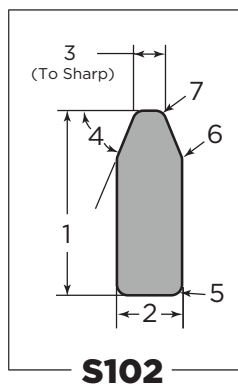
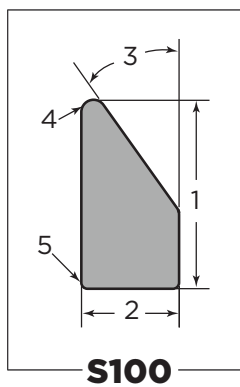
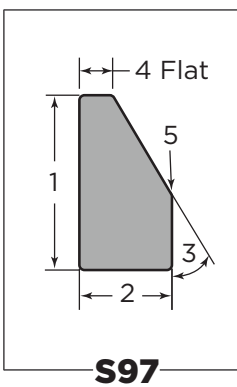
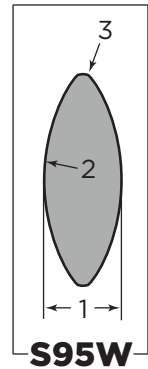
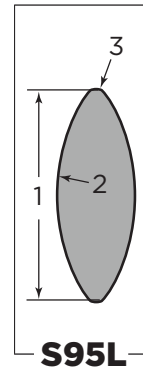
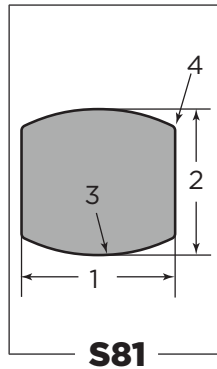
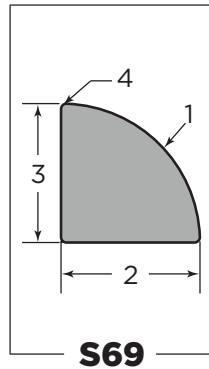
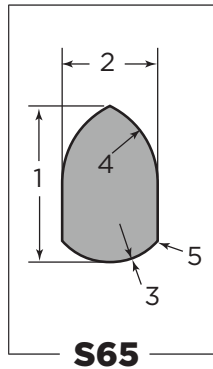
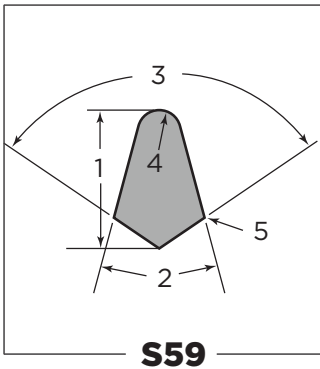
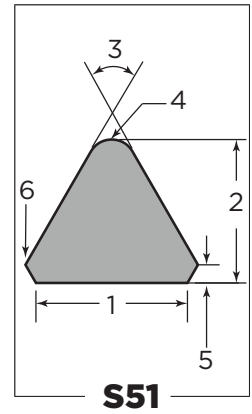
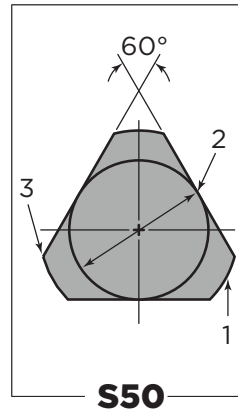
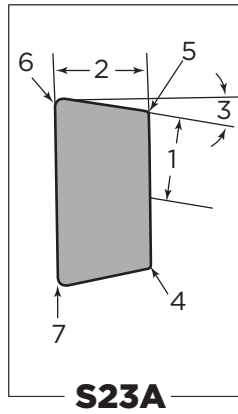
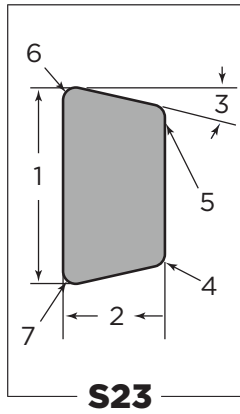
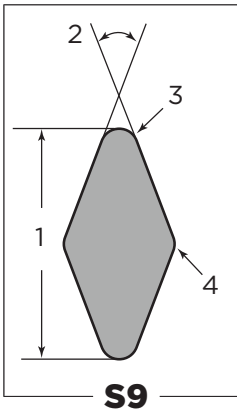
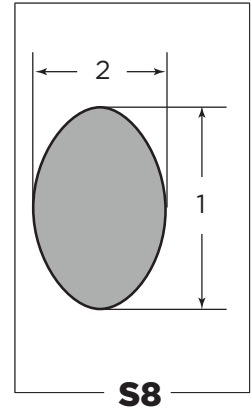
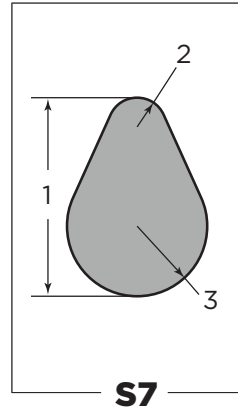
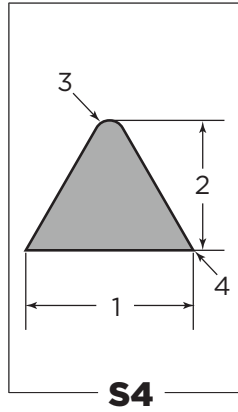
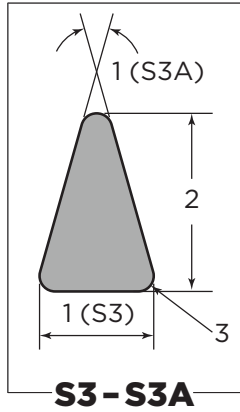
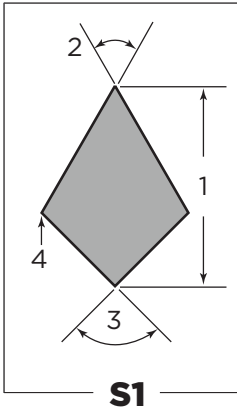


COMMON IN STATION SIZES



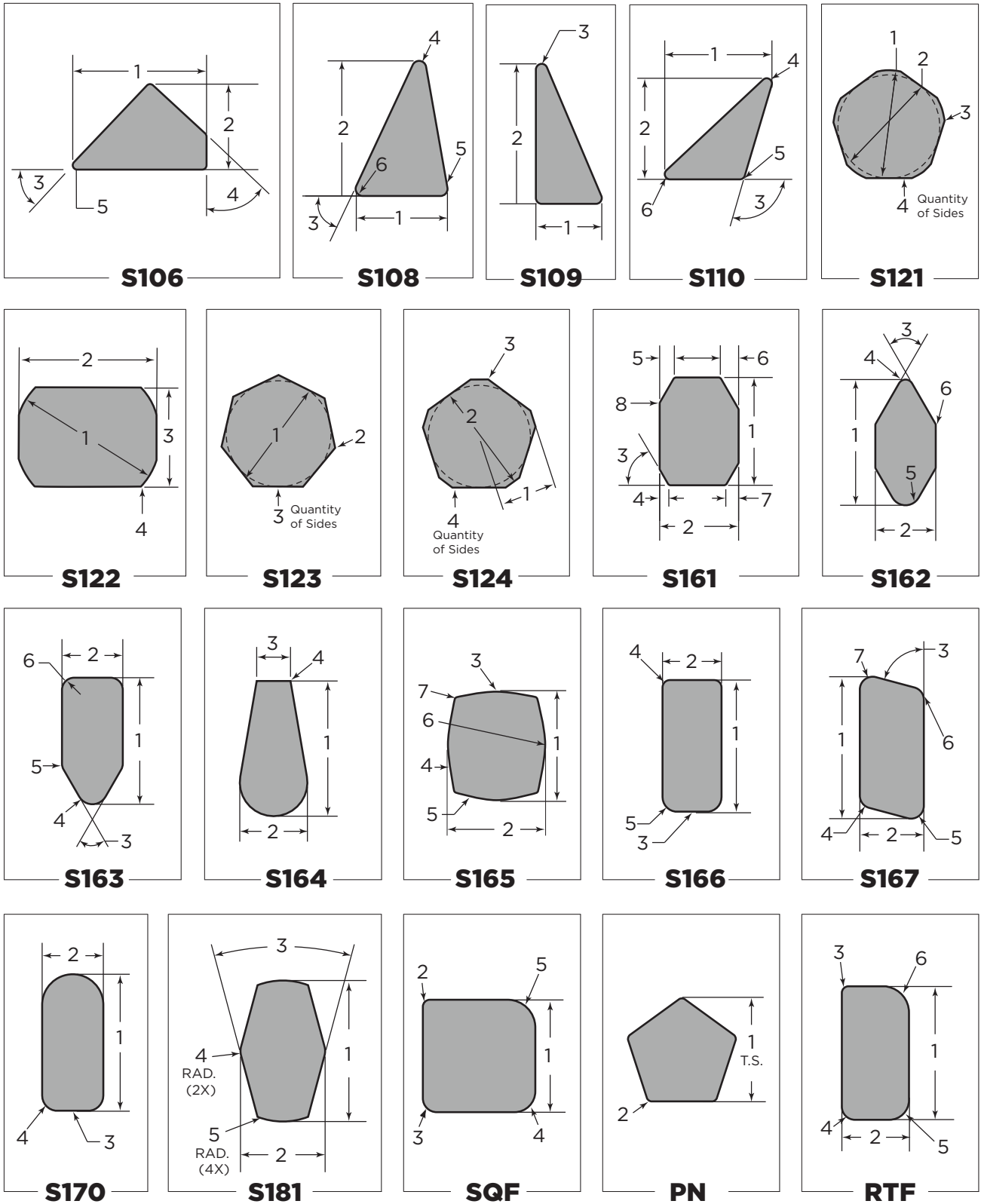
APPLICATION	ADVANTAGES	INFORMATION NEEDED
<ul style="list-style-type: none"> The E-Z Set punch head provides quick turn-of-the-wrist adjustment. A simple lift and turn of the adjustable head is all that is required. You can achieve just the right mark or form when using the E-Z Set punch head on A or B station stamping and forming tools. 	<ul style="list-style-type: none"> Precise adjustment: Each adjustment click provides a .0035" [0.09 mm] incremental change in the tool length. The maximum adjustment is approximately .125" [3.18 mm]. Fine length adjustments can now be made without removing the tool from the turret, thus reducing machine down time. You will see instant payback based on reduced machine down time. 	<ul style="list-style-type: none"> Type of holder – imperial or metric Style of guide assembly

SPECIAL SHAPES — GROUP A



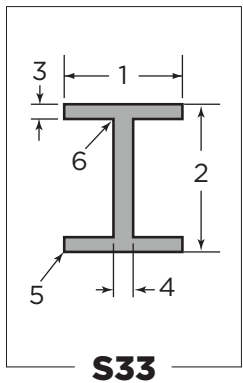
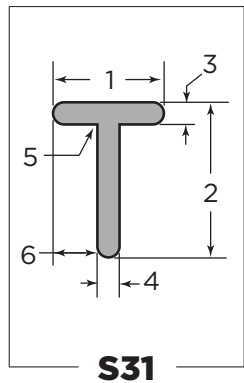
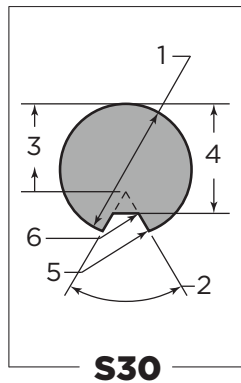
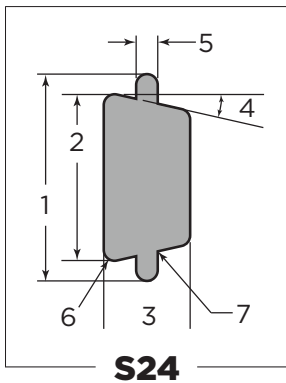
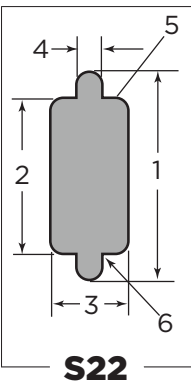
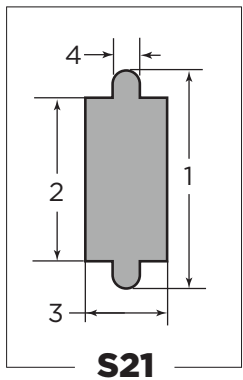
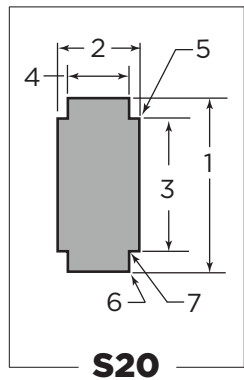
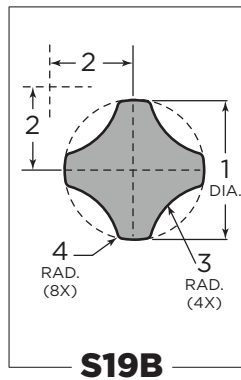
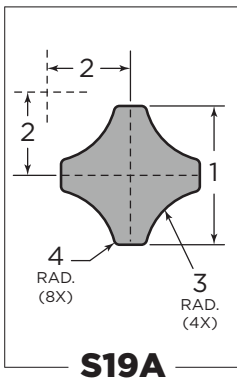
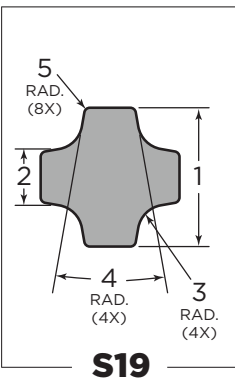
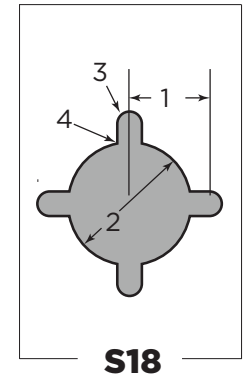
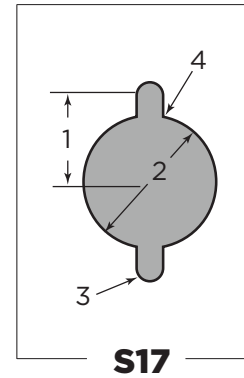
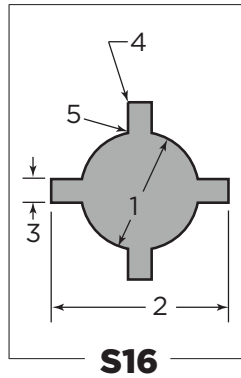
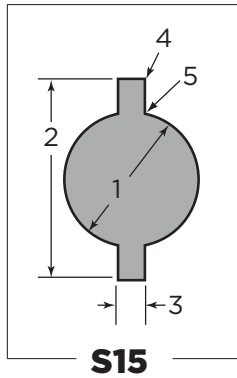
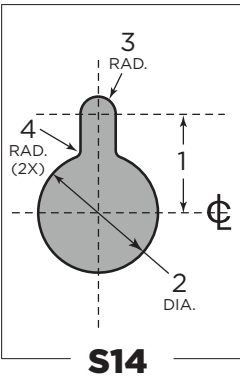
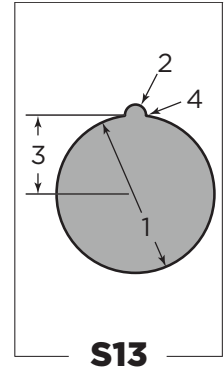
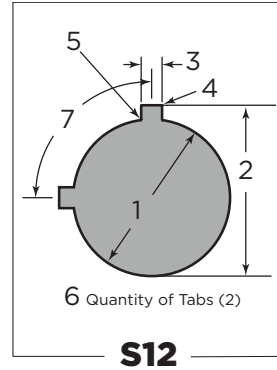
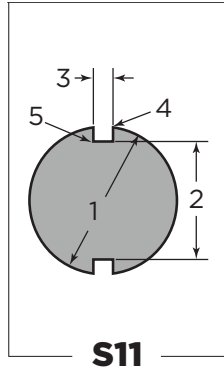
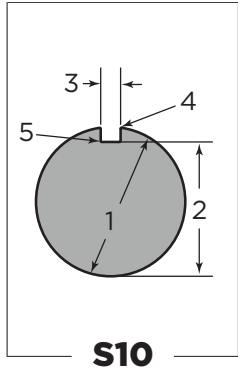
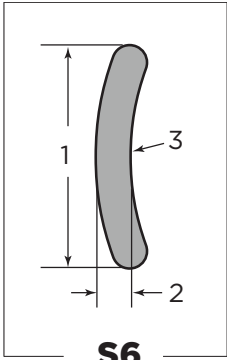
NOTE: Special considerations may alter price and lead time.

SPECIAL SHAPES — GROUP A



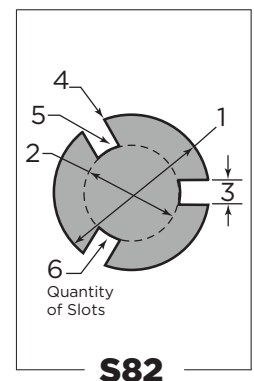
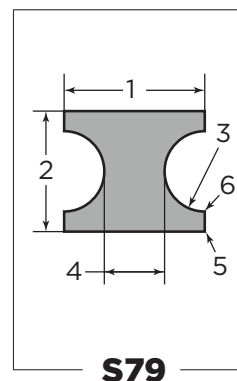
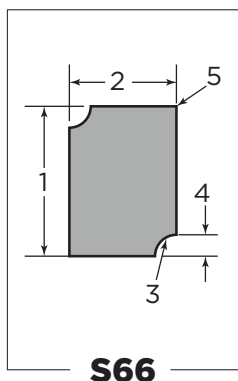
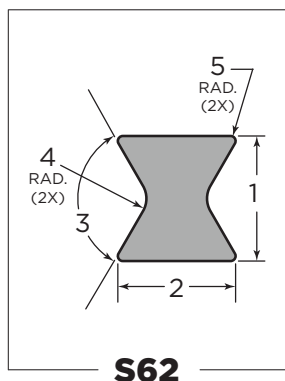
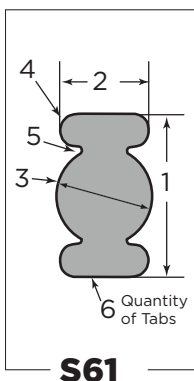
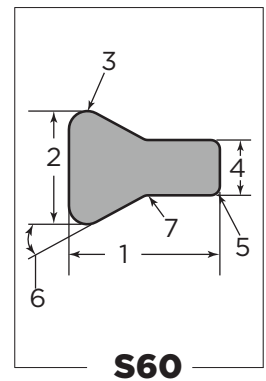
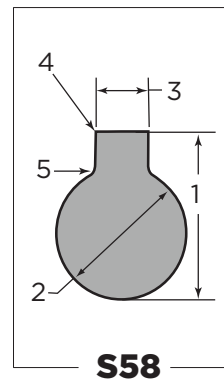
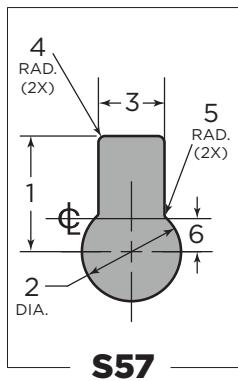
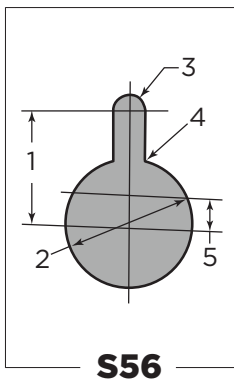
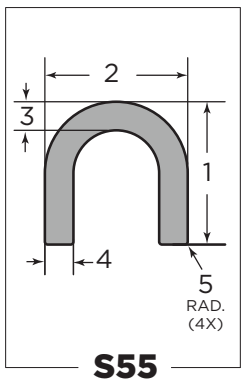
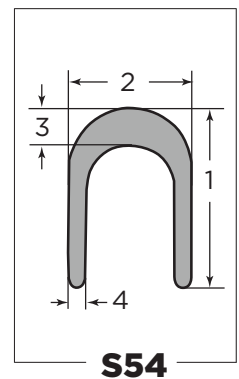
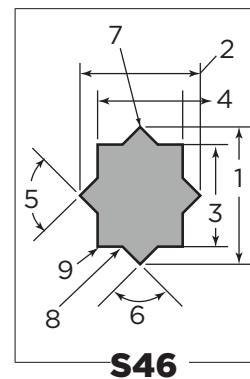
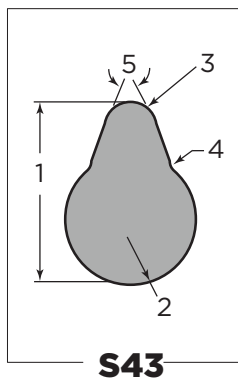
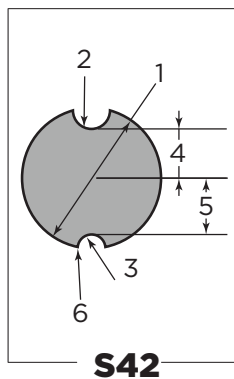
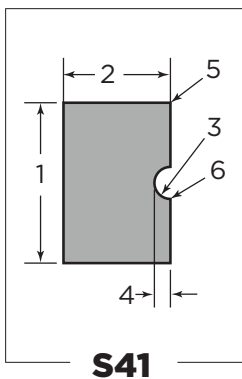
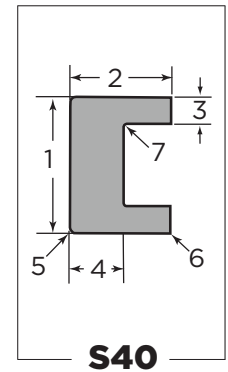
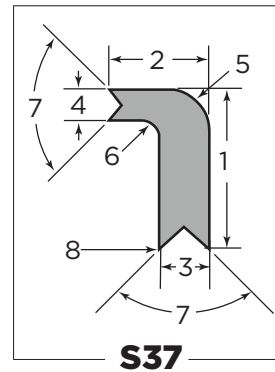
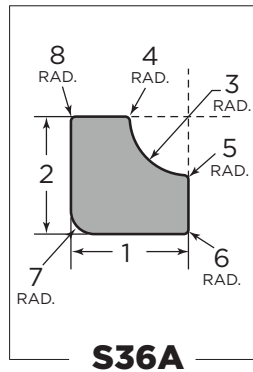
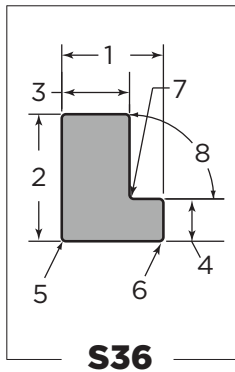
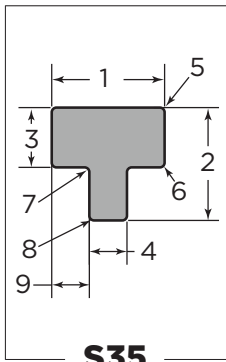
NOTE: Special considerations may alter price and lead time.

SPECIAL SHAPES — GROUP B



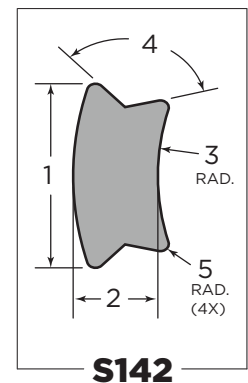
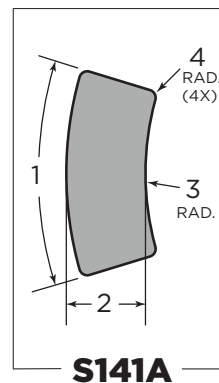
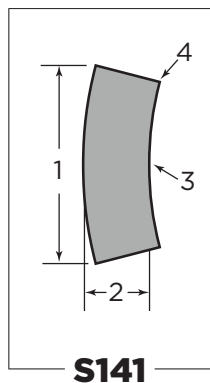
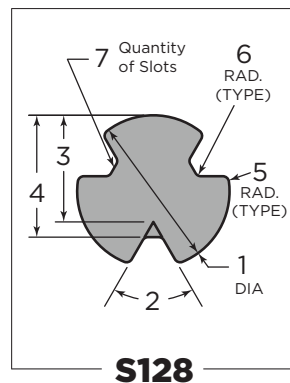
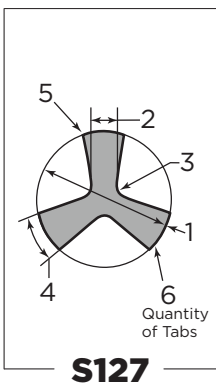
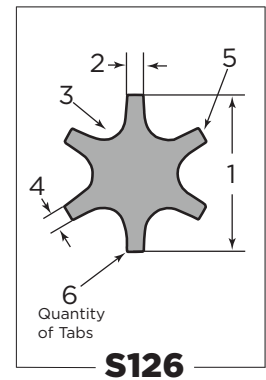
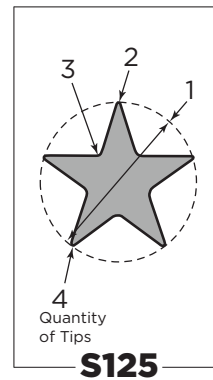
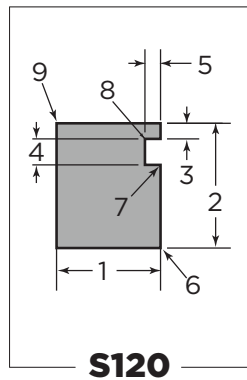
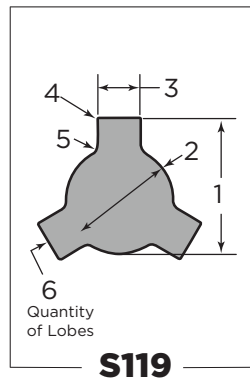
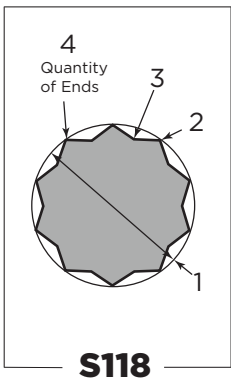
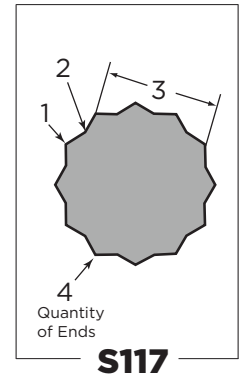
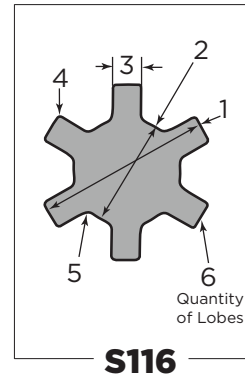
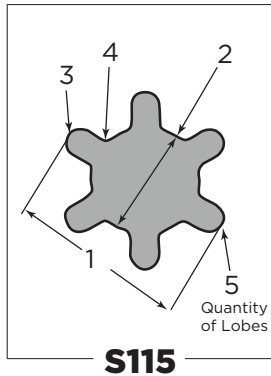
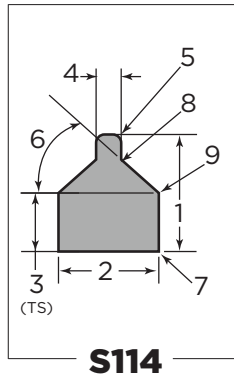
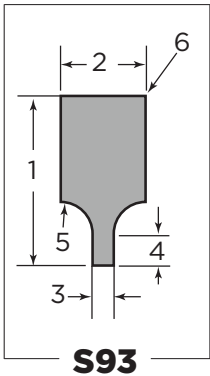
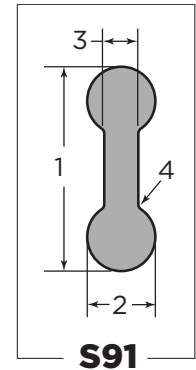
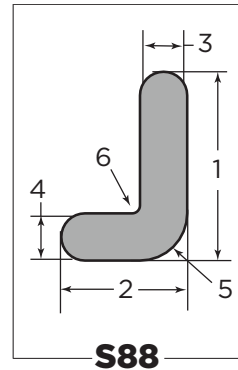
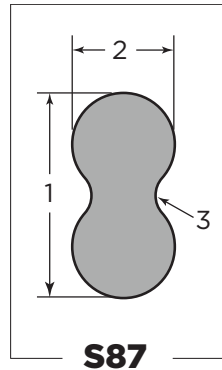
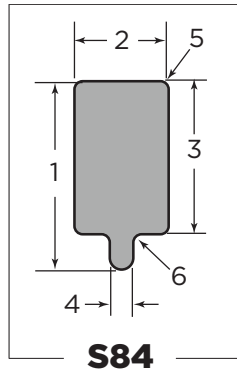
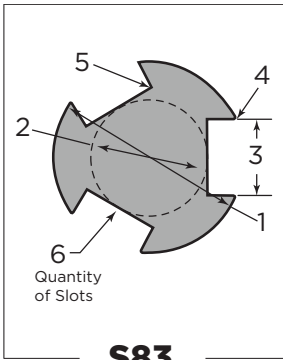
NOTE: Special considerations may alter price and lead time.

SPECIAL SHAPES — GROUP B



NOTE: Special considerations may alter price and lead time.

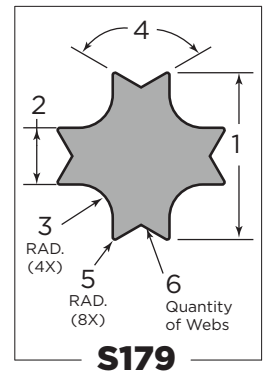
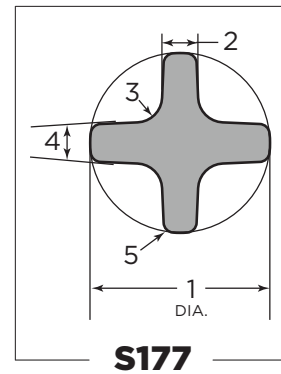
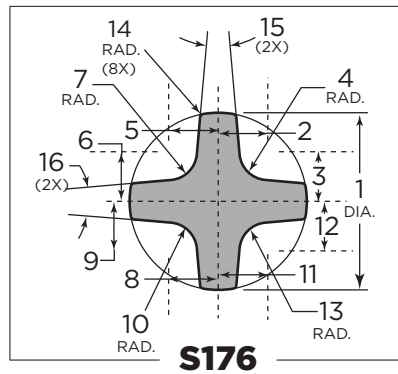
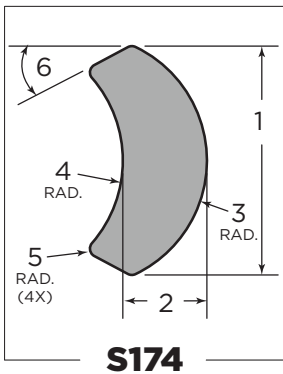
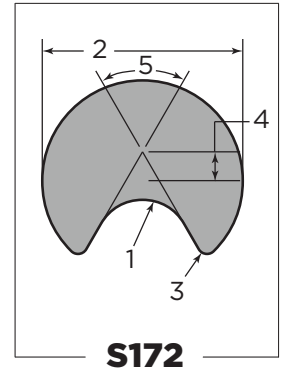
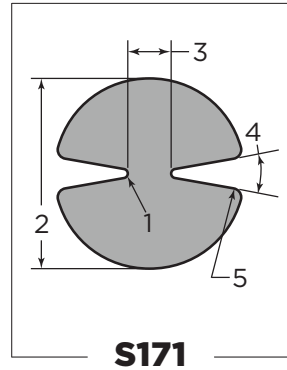
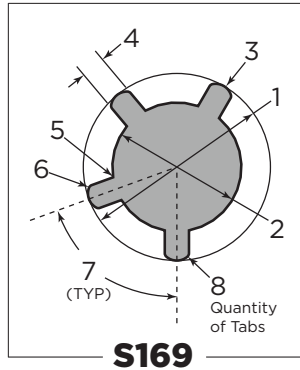
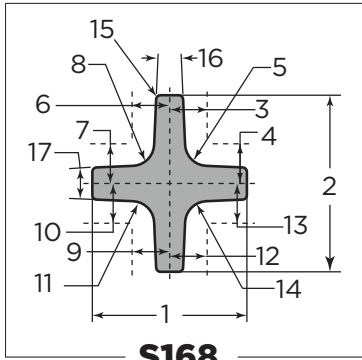
SPECIAL SHAPES — GROUP B



NOTE: Special considerations may alter price and lead time.

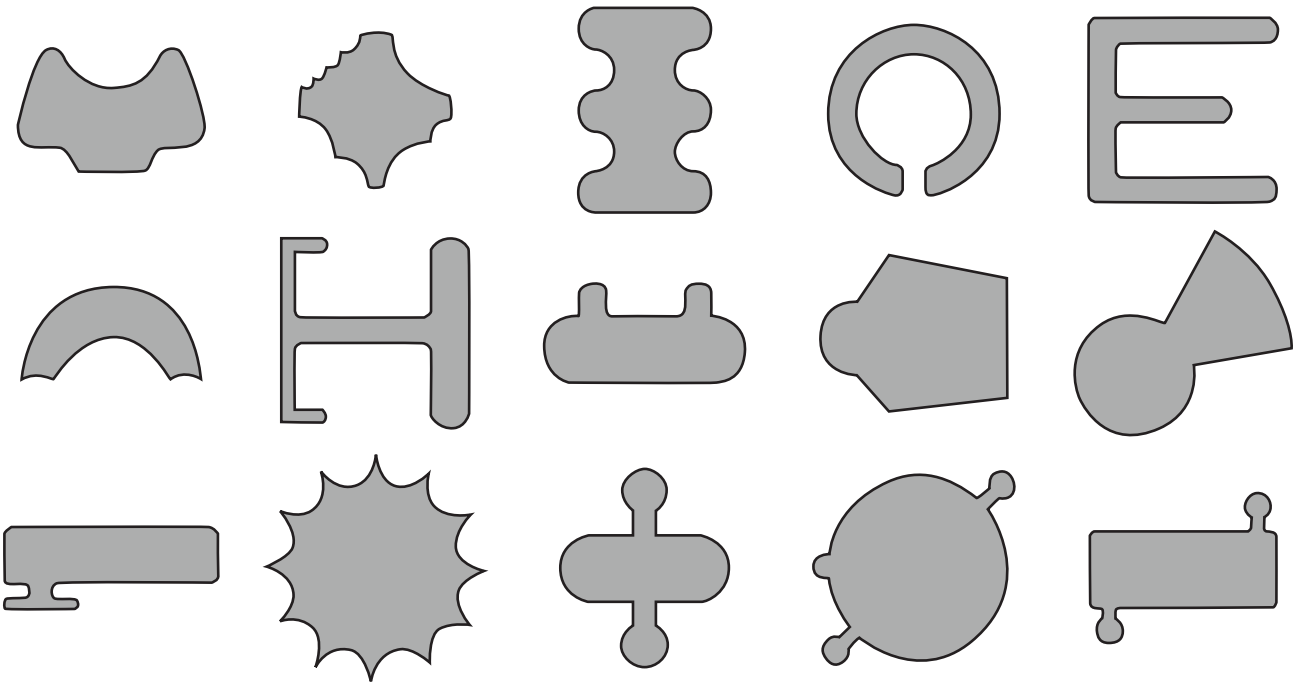


SPECIAL SHAPES — GROUP B



NOTE: Special considerations may alter price and lead time.

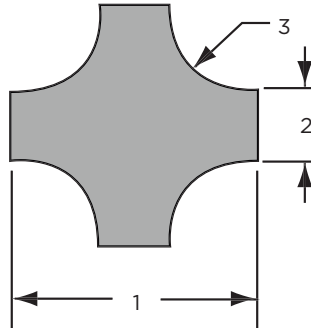
SPECIAL SHAPES — GROUP C



Any complex 2D shape ordered with a DXF file will be priced as a B Group.
Electronic file will be validated at the time of ordering.

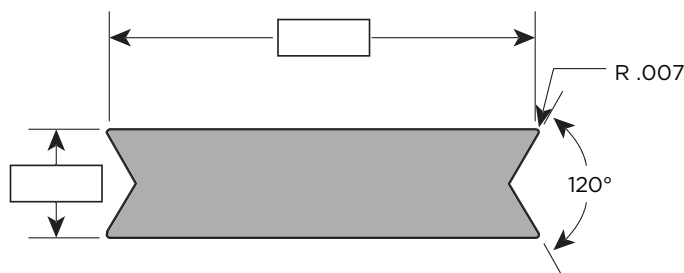
4-WAY RADIUS TOOLS

STANDARD SIZES



4-WAY RADIUS TOOLS – STANDARD SIZES			
RADIUS inch [mm]	DIM. 1 inch [mm]	DIM. 2 inch [mm]	DIM. 3 inch [mm]
.062 [1.58]	.500 [1.58]	.250 [6.35]	.062 [1.58]
.094 [2.39]	.625 [2.39]	.250 [6.35]	.094 [2.39]
.125 [3.18]	.625 [3.18]	.250 [6.35]	.125 [3.18]
.156 [3.96]	.750 [3.96]	.250 [6.35]	.156 [3.96]
.188 [4.78]	.750 [4.78]	.250 [6.35]	.188 [4.78]
.250 [6.35]	.875 [6.35]	.250 [6.35]	.250 [6.35]
.312 [7.93]	1.000 [7.93]	.250 [6.35]	.312 [7.93]
.375 [9.53]	1.125 [9.53]	.250 [6.35]	.375 [9.53]
.500 [12.7]	1.250 [12.7] Ø	.250 [6.35]	.500 [12.7]

INVERTED DIAMOND



HAND TOOLS

MAGNET SQUARE



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

Catalog No. 974150

SAE HEX KEY WRENCH SET



Imperial 13 piece set. Contains: .050", 1/16", 5/64", 3/32", 7/64", 1/8", 9/64", 5/32", 3/16", 7/32", 1/4", 5/16", 3/8"

Catalog No. 6057

OIL STONE



3 square aluminum oxide sharpening stone.

Catalog No. 6060

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, and 10 x 170mm.

Catalog No. 6105

DIAMOND FILE



Industrial file plated with finely selected diamond powder. Can be used on hardened tool steel

Catalog No. 6059

SOFT FACE HAMMER



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

Catalog No. 6106

T-HANDLE EXTRACTOR



Used for large station guide assemblies.

Catalog No. 6483

TRU-ARC PLIERS



Retaining ring pliers for changing Old Style B Station Thick Turret strippers and Old Style 5/8" Drop-In strippers.

Catalog No. 6056

SPANNER WRENCH



Adjustable C hook wrench for removing B Station Thick Turret and 1-1/4" Station Thin Turret punch heads.

Catalog No. 6058

HAND TOOLS

TOOL KIT



- 1 Tool Box
- 1 Oil Stone
- 1 Diamond File
- 1 Tru-Arc Pliers
- 1 Spanner Wrench
- 1 Punch Lubricant
- 1 Soft Face Hammer
- 1 Metric Hex Key Wrench Set
- 1 Hex Key Wrench Set (English)
- 1 Assortment of 4 sizes of square urethane ejectors

Catalog No. 6091

DIGITAL MEASURING EQUIPMENT

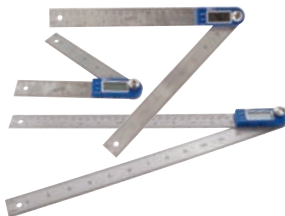
DIGITAL ANGLE CUBE



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.

Catalog No. 974119

DIGITAL PROTRACTOR RULER



Lightweight, easy-to-use, highly accurate protractors measure angles from 0° to 360° with an accuracy of ± 0.01 degrees. Set angles in .05° increments. Front locking lever to hold the arm position. A hold function and reverse reading capability.

Catalog No. 980065

ZIP-MAR ADHESIVE DISCS

ZIP-MAR ADHESIVE DISCS




Zip Mar reduces the costly marring of material by the stripper. The disk is applied to the bottom of a standard stripping guide or stripper plate. A hole is then cut with a sharp knife to reveal the existing hole in the stripper.

STATION	QUANTITY	CAT. NO.
A	Pack of 10	6083
B		6084
C		6085
D		6086
E		6087
Sheet	6" x 12" [15.2cm x 30.5cm]	6108

ALIGNMENT TOOLS | BALL RIDING | BRUSH DIE


SINGLE TRACK MACHINE ALIGNMENT TOOLS



One tool is required to align each station.

STATION	UPPER	LOWER
	CAT. NO.	CAT. NO.
A-1/2"	2597	2598
B-1-1/4"	2599	495


MULTIPLE TRACK MACHINE ALIGNMENT TOOLS



Two tools are required to align each station — one in front of the station and one in back.

STATION	CAT. NO.
A 1/2"	2601
B 1-1/4"	2602


ALIGNMENT TOOLS



Two tools are required to align each station — one in front of the station and one in back.

STATION	UPPER	LOWER
	CAT. NO.	CAT. NO.
C 2"	1840	1841
D 3-1/2"	1947	1948
E 4-1/2"	1949	1950
F 6"	2290	2291

BALL RIDING DIE




A spring loaded ball designed to help eliminate:

- Sheet hang-up from material running into a higher die
- Sheet deformation from punching next to dies of different heights
- Damage to die inserts when the die cap receives uneven loading.

OAH = 1.328" [33.73mm]

STATION	CAT. NO.
A 1/2"	2375
B 1-1/4"	10685
C 2"	14591
D 3-1/2"	14582
E 4-1/2"	14583

BRUSH DIE



Primarily used in applications where any marking that might be caused by ball riding dies is not acceptable.

OAH = 1.248" [31.7mm].

STATION	CAT. NO.
A 1/2"	2760
B 1-1/4"	2761
C 2"	2762
D 3-1/2"	2763
E 4-1/2"	2764

TOOL STORAGE | SHEAR GRINDING FIXTURE

TOOL STORAGE CABINET — 8 DRAWERS



989824



989825

3 Drawers for A Station Tooling - 3" [76.2mm]

- 16 punch & guide assemblies or 32 dies & 16 punches (per drawer)

3 Drawers for B Station Tooling - 4" [101.6mm]

- 12 punch & guide assemblies or 24 dies & 12 punches (per drawer)

1 Drawer for C & D Station Tooling - 5" [127.0mm]

- 12 punches, stripper plates & dies

1 Drawer for E or F Station Tooling - 10" [254.0mm]

- 9 compartments for guide assemblies

THICK TURRET TOOLING STORAGE CABINETS

W x D x H	Cat. No.
30" x 27" x 42" [76.2 x 68.5 x 106.6cm]	989824
30" x 27" x 47.5" [76.2 x 68.5 x 120.6 cm]	989825

Scan QR Code for More Storage Details



ACCESSORIES

Description	Cat. No.
Steel Top w/Rubber Mat	989833
Laminated Wood Top	989832



SHEAR GRINDING FIXTURE



- Easy to adjust angle setting for shear grinding
- Can be used with your existing surface grinder
- Easy to use instruction sheet with grinding tips

STD & HP FIXTURE & COMPONENTS

DESCRIPTION	CAT. NO.
Shear Grinding Fixture	6034
EXP Sharpening Adapter	6990
1/2" Tooling Sleeve Adapter	6043
1-1/4" Tooling Punch and Die Holder	6042
1-1/4" to 1/2" Die Adapter	6088
Old Style — 2", 3-1/2" & 4-1/2" Tooling Punch Holder for Standard Thick	6039
HP Thick — 2", 3-1/2" & 4-1/2" Tooling Punch Holder	6040
Dura-Blade Grinding Fixture	6932
Pointer (Replacement)	6035
Degree Scale (Replacement)	6036

STD & HP MULTI-TOOL PUNCH & DIE HOLDERS

DESCRIPTION	CAT. NO.
8 Station Punch & Die Holder	6812
8mm Punch & Die Holder	6156
16mm Punch & Die Holder	6157
24mm Punch & Die Holder	6158

XSHARP™ GRINDER

Scan QR Code to See XSharp™ in Action



ACCESSORIES



Benefits of Accurate Regrinding

- Burr-free, quality parts straight off the punch press
- Longer tool life for reduced tooling costs
- No scrapped or wasted sheets due to tooling malfunction
- Reduced wear on your punch press

Fully Automated Grinding Process

- Simple to operate; no previous grinding experience required
- Touchscreen controller with user-friendly multi-language interface for easy operation (language can be selected during machine setup)
- Automated height detection feature locates the top of any tool mounted in the chuck before the grinding cycle begins
- Automatic compensation makes up for any grinding wheel wear

Suitable for Most Tooling Styles: Flexible range of chucks and adapters allows for sharpening most punch press tooling styles

Precision: AC-servo motor drives a precision gear and ball screw with dual linear guides and four carriers to provide highly stable bearing properties

Shear Grinding Chuck: For sharpening punches with shears (included)

Closed Coolant System: Ensures the tool is constantly flooded with coolant during the grinding process

Interlocking Safety Guard: Automatically opens and closes

Frame: Heavy-duty cast-iron frame for durability, stability and long life

Small Footprint: Machine can easily be placed next to the punch press

XSHARP™ ACCESSORIES	
DESCRIPTION	CAT. NO.
Grinding Wheel	55109
Coolant	55367
Dressing Stone	55117

TECHNICAL ACCESSORIES			
Machine Height	77.2" [1962mm]	Max. Tool Diameter	6.3" [160mm]
Machine Width	31.5" [800mm]	Max. Tool Height	9" [230mm]
Machine Depth	30.7" [779mm]	Air Pressure Supply	6 bar
Machine Weight	992 lbs./450kg	Grinding Motor Power	3HP/2.2 kW
Power Supply	230/460V, 60Hz	Wheel Rotation Speed	2800 rpm
Table Motor Power	.24HP/.18 kW	Coolant Pump Power	.21HP/0.16 kW
Table Rotation Speed	40 RPM	Coolant Pump Water Flow	Max. 11.5GPM/40 l/min.

*Note: Adapters may be required for some ranges of TRUMPF-style tooling.
Wilson Tool International reserves the right to change machine specifications without prior notice.

5 EASY STEPS TO A SHARPER EDGE



Step 1. Load tool into chuck



Step 2. Set tool style



Step 3. Set tool size



Step 4. Set grind amount (in increments of 0.001" or 0.01mm)



Step 5. Touch start to sharpen the tool



TOOL MAINTENANCE

NYLON VICE JAWS



Used to aid in the assembly and maintenance of A & B Station Thick Turret style punch assemblies.

Catalog No. 24001

HP SPRING COMPRESSION KIT



Includes spring base, external circlip pliers, spacer sleeve, washer and M-12 bolt.

Catalog No. 6940

For old style: Cat. No. 8104

ASSEMBLY FIXTURE



Ideal bench mounted aid for assembling and retaining a variety of assemblies. For C & D Stations.

Catalog No. 24162

RUBBERIZED ABRASIVE WHEEL



- For removing galling
- Measuring range 0 - 6"
- Accuracy to 0.001"

Catalog No. 8050

LUBRICANTS

PUNCH LUBRICANT



An extreme-pressure, solid lubricant that is used for metalworking and protecting against corrosion. Multi-purpose, low friction and heavy duty.

Catalog No. 6055

SHEET LUBRICANT



- Xcel 1 Liter Spray Bottle
Catalog No. 24315

- Xcel 5 Liter Concentrate
Catalog No. 24316

CUT-MAX 570



Cutting oil allows for faster cutting of difficult alloys while providing an excellent finish and extends tool life. Sample size bottle.

Catalog No. 6941

SURE SHOT SPRAYER



1 Quart [.95 Liter] capacity enamel steel sprayer with adjustable plastic nozzle.

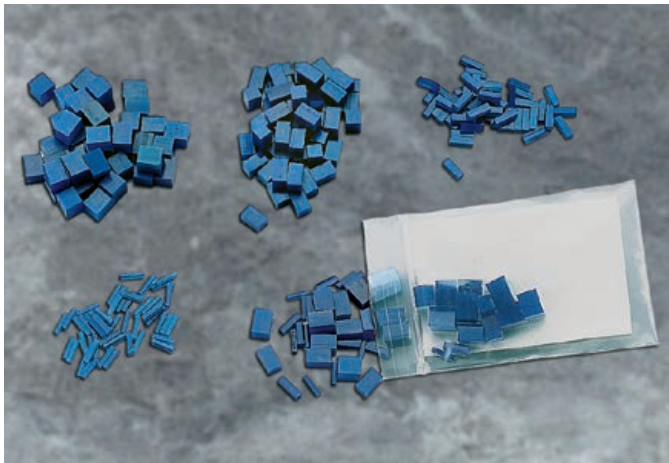
Catalog No. 6120

DIE SHIMS

ACCESSORIES

DIE SHIMS FOR MULTI-TOOLS				
MACHINE TYPE	STATION	SHAPE	THICKNESS	PACKAGE OF 15
				CAT. NO.
PrimaPower®	3-1/2-8i / Ri	—	.010" [0.25mm]	6815
	3-1/2-8i / Ri	—	.030" [0.76mm]	6816
	MT 12 & 20-8	Round	.010" [0.25mm]	6817
	MT 12 & 20-8	Round	.030" [0.76mm]	6818
	MT 12 & 20-8	Shape	.010" [0.25mm]	6819
	MT 12 & 20-8	Shape	.030" [0.76mm]	6820
	MT 6 & 10-16	—	.010" [0.25mm]	6821
	MT 6 & 10-6	—	.030" [0.76mm]	6822
	MT 6 & 8-24	—	.010" [0.25mm]	6823
	MT 6 & 8-24	—	.030" [0.76mm]	6824
Thick Turret	1-1/4-5	—	.010" [0.25mm]	6825
	1-1/4-5	—	.030" [0.76mm]	6826

SLUG EJECTORS



SLUG EJECTORS SQUARE URETHANE		
HOLE DIAMETER IN PUNCH	QUANTITY	CAT. NO.
1/8" [3.2mm]	50	6116
3/16" [4.8mm]	50	6117
3/8" [9.5mm]	50	6118
1/2" [12.7mm]	50	6119
Assortment	48 (12 ea.)	6410



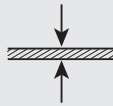
ADAPTERS

1/2" A STATION TO 1-1/4" B STATION ADAPTER	
DESCRIPTION	CAT. NO.
Punch & Guide Assembly Adapter (Keyed at 0° & 180°)	2284
Die Adapter	2220
Screw	2119

1-1/4" B STATION TO 2" C STATION ADAPTER	
DESCRIPTION	CAT. NO.
Punch & Guide Assembly Adapter	2476
Die Adapter	2475
Screw	6206

1-1/4" B STATION TO 3-1/2" D STATION ADAPTER	
DESCRIPTION	CAT. NO.
Punch & Guide Assembly Adapter (not shown)	2492
Die Adapter	35058

1-1/4" B STATION TO 4-1/2" E STATION ADAPTER	
DESCRIPTION	CAT. NO.
Punch & Guide Assembly Adapter (not shown)	2680
Die Adapter	2681

MAX. MATERIAL THICKNESS FOR ABOVE ADAPTERS
.135" [3.4mm] mild steel and aluminum .090" [2.3mm] stainless steel

Other style adapters are available, please consult our sales desk.



A to B Station



B to C Station

SHEAR OPTIONS

REFERENCE

ROOFTOP	CONCAVE OR DOUBLE CONCAVE	INVERTED ROOFTOP	DOUBLE VALLEY	JK SHEAR
+	+	+	+	+
Best shear for punching at maximum tonnages.	Best shear for nibbling because it inverts stresses.	Good shear for nibbling because it inverts stresses.	Best shear for nibbling when shape is long and narrow.	A special shear that allows you to punch high strength materials with a reduced risk of breakage.
-	-	-	-	-
When nibbling, bite must be 75% of punch dimension or excessive side loading will result.	Less resistant to breakage when punching at high tonnages because of inverted stresses.	More susceptible to breakage because of a sharp focal point for stresses — use great care.	Less resistant to breakage when punching at high tonnages because of inverted stresses.	Can only be used on punches up to 1.000" [25.4mm] diameter or A Dimension.

SPECIAL SHEARS					
STATION	A DIMENSION	INVERTED ROOFTOP SINGLE CONCAVE		DOUBLE VALLEY DOUBLE CONCAVE	
		1/16" [1.6MM]	1/8" [3.2MM]	1/16" [1.6MM]	1/8" [3.2MM]
B 1-1/4"	Within 1.250" [31.75mm]		—		—
C 2"	Within 2.000" [50.8mm]				
D 3-1/2"	Within 3.500" [88.9mm]				
E 4-1/2"	Within 4.500" [114.3mm]				

JK SHEAR ADD ON	
SHAPE	PRICE
Round	
Rectangle, Square, Hexagon, Single D, Double D	
Obround	

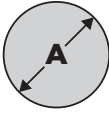

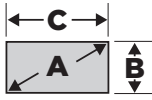
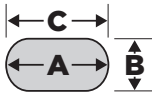
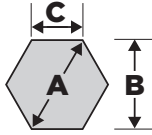
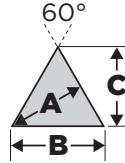
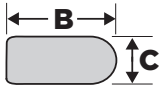
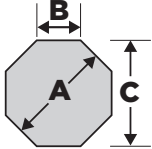
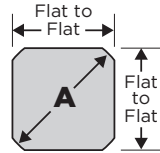
Scan QR Code for Punching Force Chart



SHEAR DETAILS	A DIMENSION	EXCEPTION	SPECIAL SHEAR DETAILS
<ul style="list-style-type: none"> 1/16" [1.6mm] rooftop shear is given to all punches with A Dim (see page 141) greater than 2.000" [50.8mm] and width greater than .250" [6.35mm] at no extra charge. All punches .250" [6.35mm] and under in width will be shipped with no shear unless specified. 		<p>In some instances, inverted rooftop is substituted for single and double concave shears.</p>	<ul style="list-style-type: none"> If specified: 1/8" [3.2mm] maximum rooftop shear can be given at N/C for any round or shape in 2" C Station, 3-1/2" D Station, 4-1/2" E Station or 6" F Stations. Rooftop shear available on any round or shape in 1/2" A Station or 1-1/4" B Stations.



CALCULATING YOUR A DIMENSION

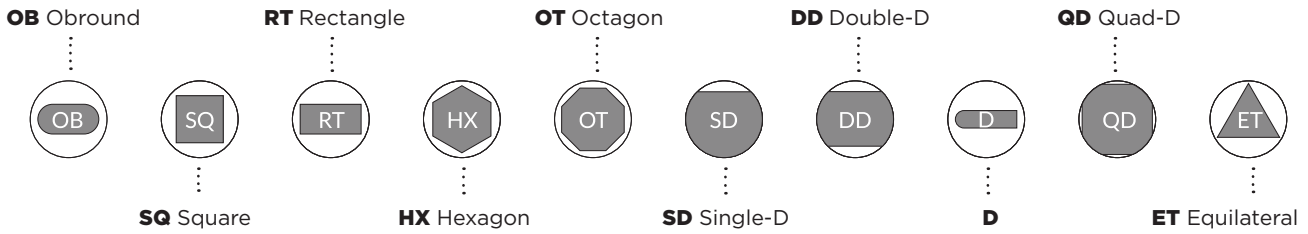
ROUND		A = Diameter
SQUARE		A = B x 1.414
RECTANGLE		A = $\sqrt{B^2 + C^2}$
OBROUND		A = C
HEXAGON		A = 1.155 x B or A = 2 x C
EQUILATERAL		A = 1.155 x B or A = C
LONG "D"		A = $\sqrt{B^2 + C^2}$
OCTAGON		A = 1.082 x C or A = 2.613 x B
QUAD D		A = Diameter

Scan QR Code for
Wilson Tool's
Standard Shape
Dimensions Flyer



STANDARD SHAPES & KEYING LOCATIONS

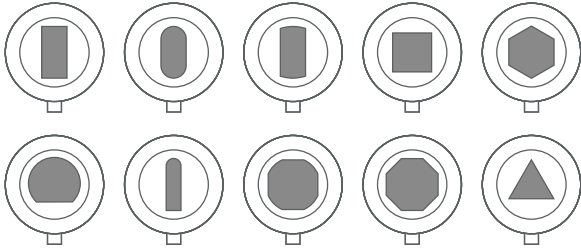
STANDARD SHAPES



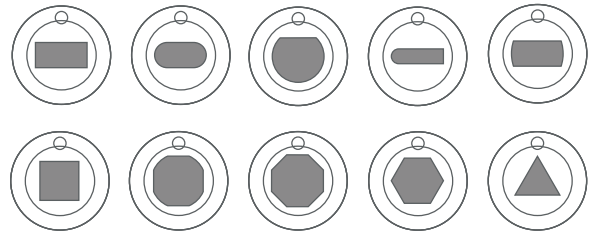
STANDARD KEYING LOCATIONS

PUNCH VIEW

1/2" A STATION & 1-1/4" B STATION

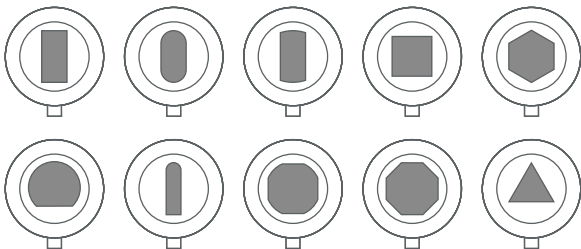


2" C STATION, 3-1/2" D STATION & 4-1/2" E STATION

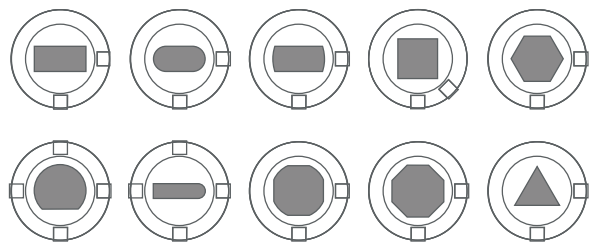


DIE VIEW

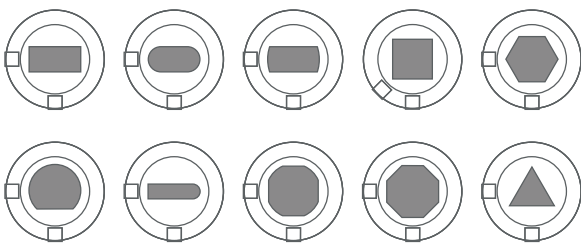
1/2" A STATION & 1-1/4" B STATION



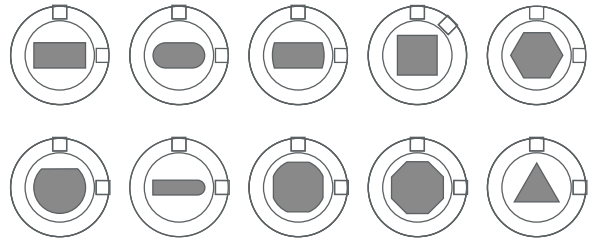
2" C STATION



3-1/2" D STATION



4-1/2" E STATION



NON-STANDARD KEYING | DIE CLEARANCE

WILSON TOOL KEYING DIAGRAM

Refer to non-standard key locations by the following method:

- **Example 1:** Shape at 60°
- **Example 2:** Shape at 30°

EXAMPLES OF ANGLE SETTINGS

Example 1 **Example 2**

WORK HOLDERS

FRONT OF PRESS

SHAPE AT SINGLE ANGLES OTHER THAN STANDARD			
STATION	PUNCH	DIE	GUIDE OR STRIPPER
A	N/C		N/C
B			—
C			—
D			—
E			—

No additional charge on A & B Stations for shape at 45° increments)

STANDARD KEYING, PLUS EXTRA PINS OR KEYS FOR SHAPES AT OTHER THAN 45° INCREMENTS			
STATION	PUNCH	DIE	GUIDE OR STRIPPER
A	—	—	
B	—	—	
C			—
D			—
E			—

STANDARD KEYING, PLUS EXTRA PINS OR KEYS FOR SHAPES AT 45° INCREMENTS					
STATION	PUNCH		DIE		GUIDE OR STRIPPER
	AVAILABLE OPTIONS	ADD ON PRICE	AVAILABLE OPTIONS	ADD ON PRICE	
A	—	—	0° & 45° 0° & 180°		
B	0° & 45° 0° & 180°		0° & 45° 0° & 180°		
C	45° increments		45° increments		—
D	45° increments		45° increments		—
E	45° increments		45° increments		—

DIE VIEW

Front of Press

This key location matches Amada's turret punch press programming method.

DIE CLEARANCE SELECTION INFORMATION			
TOTAL CLEARANCE			
MATERIAL	MINIMUM	BEST	MAXIMUM
Copper, 1/2 Hard	8%	12%	16%
Brass, 1/2 Hard	6%	11%	16%
Mild Steel	10%	15%	20%
Steel 0.50C	12%	18%	24%
Aluminum, Soft	5%	10%	15%
Stainless Steel	15%	20%	25%

% x Material Thickness = Total Clearance

REFERENCE

NON-STANDARD FEATURES ADD ON CHARGES

A STATION			
ADD ON FOR ROUNDS			
SMALL DIAMETER	PUNCH	DIE	STRIPPER
.031-.061" [0.79-1.56mm]			N/C
.062-.092" [1.57-2.34mm]		N/C	N/C
Clearance \leq .004" [0.10mm]			N/C
ADD ON FOR SHAPES			
SMALL WIDTH	PUNCH	DIE	STRIPPER
.031-.039" [0.79-1.0mm]			
.040-.092" [1.01-2.34mm]		N/C	
Clearance \leq .004" [0.10mm]			N/C

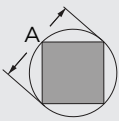
B STATION			
ADD ON FOR ROUNDS			
SMALL DIAMETER	PUNCH	DIE	STRIPPER
.031-.061" [0.79-1.56mm]			N/C
.062-.092" [1.57-2.34mm]		N/C	N/C
.093-.249" [2.35-6.32mm]		N/C	N/C
Clearance \leq .004" [0.10mm]			N/C
ADD ON FOR SHAPES			
SMALL WIDTH	PUNCH	DIE	STRIPPER
.031-.039" [0.79-1.0mm]			
.040-.092" [1.01-2.34mm]		N/C	
A Dim. < .437" [11.10mm]		N/C	N/C
Clearance \leq .004" [0.10mm]			N/C

C STATION			
ADD ON FOR ROUNDS			
SMALL DIAMETER	PUNCH	DIE	STRIPPER
<1.000" [25.4mm]		N/C	N/C
Clearance \leq .004" [0.10mm]			N/C
ADD ON FOR SHAPES			
SMALL WIDTH	PUNCH	DIE	STRIPPER
.031-.039" [0.79-1.0mm]			
.040-.092" [1.01-2.34mm]			
A Dim. < 1.150" [29.21mm]		N/C	N/C
Clearance \leq .004" [0.10mm]			N/C

D STATION			
ADD ON FOR ROUNDS			
SMALL DIAMETER	PUNCH	DIE	STRIPPER
<1.900" [48.26mm]		N/C	N/C
Clearance \leq .004" [0.10mm]			N/C
ADD ON FOR SHAPES			
SMALL WIDTH	PUNCH	DIE	STRIPPER
.031-.039" [0.79-1.0mm]			
.040-.092" [1.01-2.34mm]			
A Dim. < 1.900" [48.26mm]		N/C	N/C
Clearance \leq .004" [0.10mm]			N/C

E STATION			
ADD ON FOR ROUNDS			
SMALL DIAMETER	PUNCH	DIE	STRIPPER
<3.400" [86.36mm]		N/C	N/C
Clearance \leq .004" [0.10mm]			N/C
ADD ON FOR SHAPES			
SMALL WIDTH	PUNCH	DIE	STRIPPER
.031-.039" [0.79-1.0mm]			
.040-.092" [1.01-2.34mm]			
A Dim. < 3.400" [86.36mm]		N/C	N/C
Clearance \leq .004" [0.10mm]			N/C

RADIUS OR 45° CHAMFER 4 CORNERS		
RADIUS OR CHAMBER SIZE	PRICE	
Punch	.001 - .062" [0.02 - 1.57mm]	
	.063 - .250" [1.58 - 6.35mm]	
	> .25" [0.10mm]	
Die	Any Size	

MAXIMUM A DIMENSION	NOTES
	Additional cost to round or shape punch for: <ul style="list-style-type: none"> • Extra straight before radius • Extra back taper • No back taper

See page 153 for help calculating your A Dimension.



HPX® TECHNOLOGY



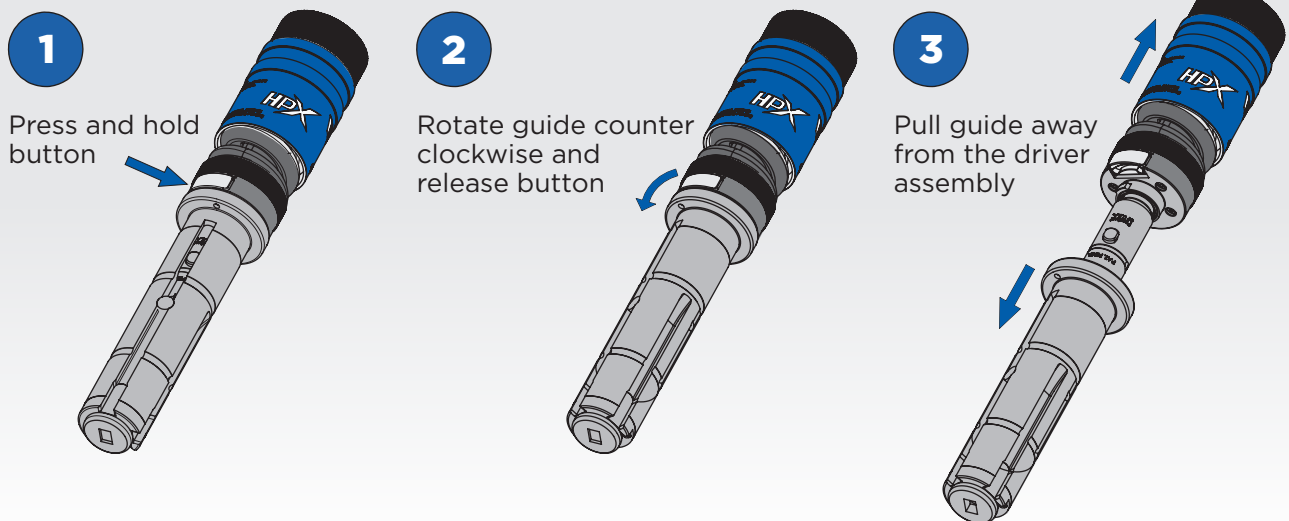
Best-in-Class Thick Turret Tooling

HPX® punch and guide assemblies from Wilson Tool International are specifically engineered to meet the needs of sheet metal manufacturers. They provide the easiest set-up and use for thick turret tooling to keep production running and downtime to a minimum.

- **EXP® Punch Technology:** All EXP punches come standard with Wilson Tool's exclusive Ultima® premium tool steel — resulting in twice the life of most standard punches. Smaller punches mean you can stock more shapes in less space. Save on tooling replacement costs and inventory space.
- **Fast Tool Changes:** EXP punch tips are easily removed for sharpening and change overs with the push of a button.
- **Push-Button Guide Release:** With the push of a button, guides are released to reduce to the effort needed when changing and adjusting tooling.
- **Ultima® Premium Tool Steel:** Advanced tool steel increases wear resistance on punches and provides twice the tool life, substantially reducing downtime and tool replacement costs.
- **Quick Adjustment:** Each click adjusts the punch length by 0.005".
- **Versatility:** Guide assemblies are universal and can be used for round or shaped EXP punches. Guides support ABS and non-ABS functionality.



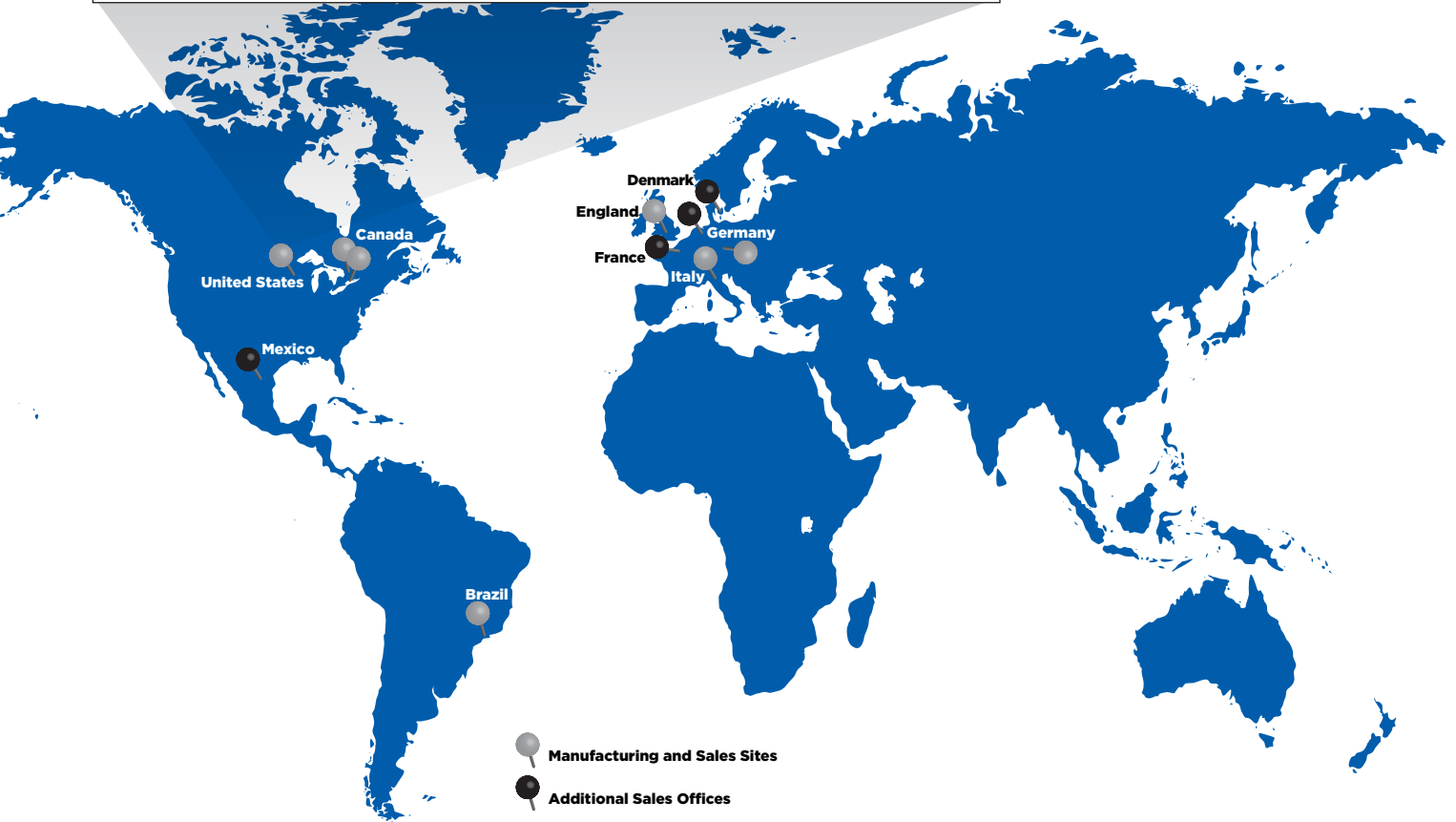
PUSH-BUTTON GUIDE RELEASE



WILSON TOOL INTERNATIONAL HEADQUARTERS

12912 Farnham Avenue N, White Bear Lake, MN 55110, USA
800.328.9646 | **punching@wilsontool.com**

Canada 800.268.5573 punching@wilsontoolcanada.com
Mexico 001.800.741.2510 punzonado@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.



P601C (1.2025)