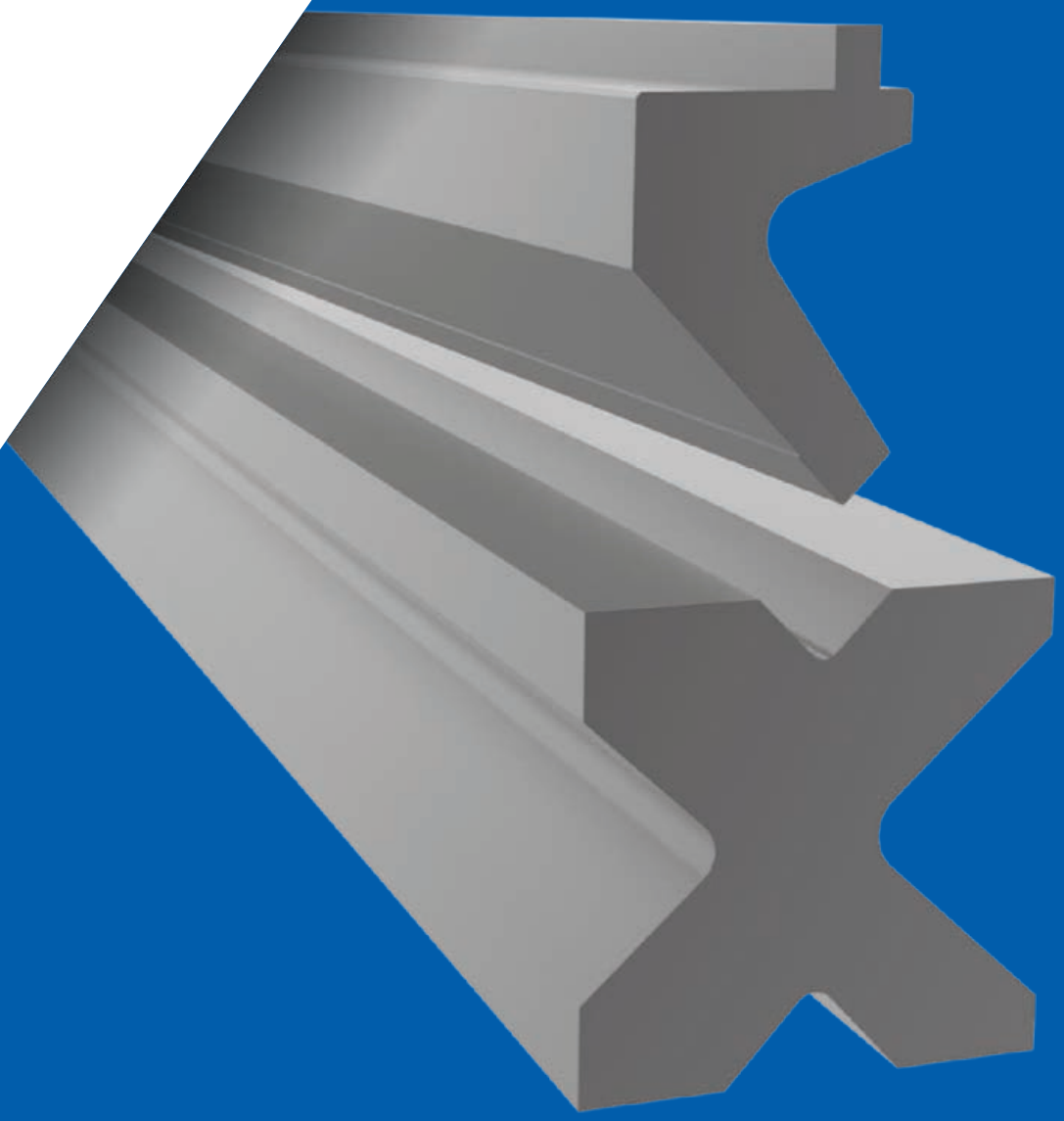
WILSON TOOL

CANADA



# AMERICAN PLANED

## PRESS BRAKE TOOLING SOLUTIONS

**2026**

# 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.

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*Prices and product availability are subject to change without notice.*



## CONNECT WITH WILSON TOOL

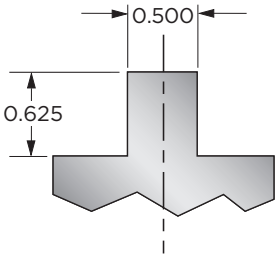
Keep up with everything that's new at Wilson Tool International! Visit our website or find us on social media for the latest information, news, videos and product releases.

**TERMS AND CONDITIONS**

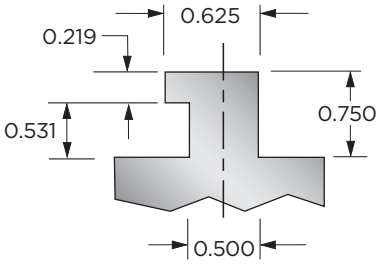
Please note, all orders are subject to Wilson Tool International's Terms and Conditions which include pricing, payment, delivery, warranties, and our return policy. To view our full Terms and Conditions, visit wilsontool.com/en-us/terms-conditions.

Information in this catalog, including pricing and product availability, is subject to change. Wilson Tool International reserves the right to modify data, specifications, and illustrations without notice and are not liable for errors or printing mistakes.

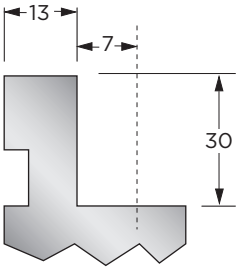
# STANDARD PUNCH TANGS AVAILABLE



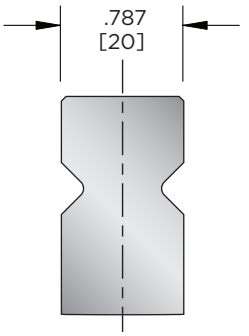

**American – Standard**
(no safety hook)




**American – Safety Hook**




**European**




**WT**

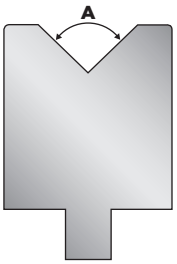
American punches come standard with **NO SAFETY HOOK**. Specify when ordering if a safety hook is required.

# MODIFICATIONS

**Punch Modifications**

Tip modifications are available in all styles and sizes. No charge for:

- Tip Radius changes up to .250″
- Angle changes to 75°–90°




**Die Modifications**

Angles can be modified to 80° at no charge.

**Lengths Available**

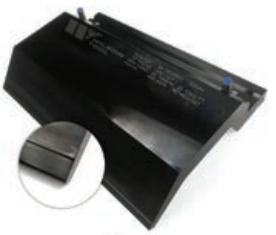
Tell us your needs and we can make the lengths you need, from smaller sectionalized pieces to lengths up to 13 feet — and everywhere in between.

Ends can be milled for a better end-of-tool surface finish.

# UPGRADES

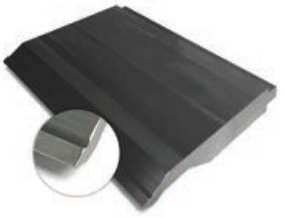
**Ground Surface Finish**

Upgrade to a ground finish for a better finish on parts. The improved surface will reduce sheet marking and match to sectionalized pieces better.



**Induction Hardened for Thicker Material**

Induction harden punch or die radii to draw hardness up to 58-60 for longer tool life. Recommended when bending thicker materials.



# PRESS BRAKE TOOLING

Wilson Tool Planed (or "conventional") press brake tooling is produced from tool steel that is through hardened to 28-32 HRC. American punches come standard with NO SAFETY HOOK. Specify when ordering if a safety hook is required.

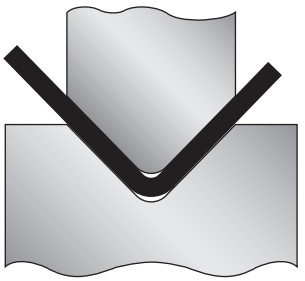
**Air Bending Dies**

Air bending dies are made at a more acute angle than the angle to be formed. The only contact is between the dies and material, occurring at the tip of the upper punch and the inside edges of the lower die. The material is formed rather than coined or bottomed.

Most Wilson Tool American Planed press brake air bending dies are made with an included angle of 85°. When forming 90° flanges in mild steel, the material's natural spring-back achieves the 90° angle. To form angles greater than the die's included angle, the ram is adjusted for less die penetration.

**Bottoming/Coining**

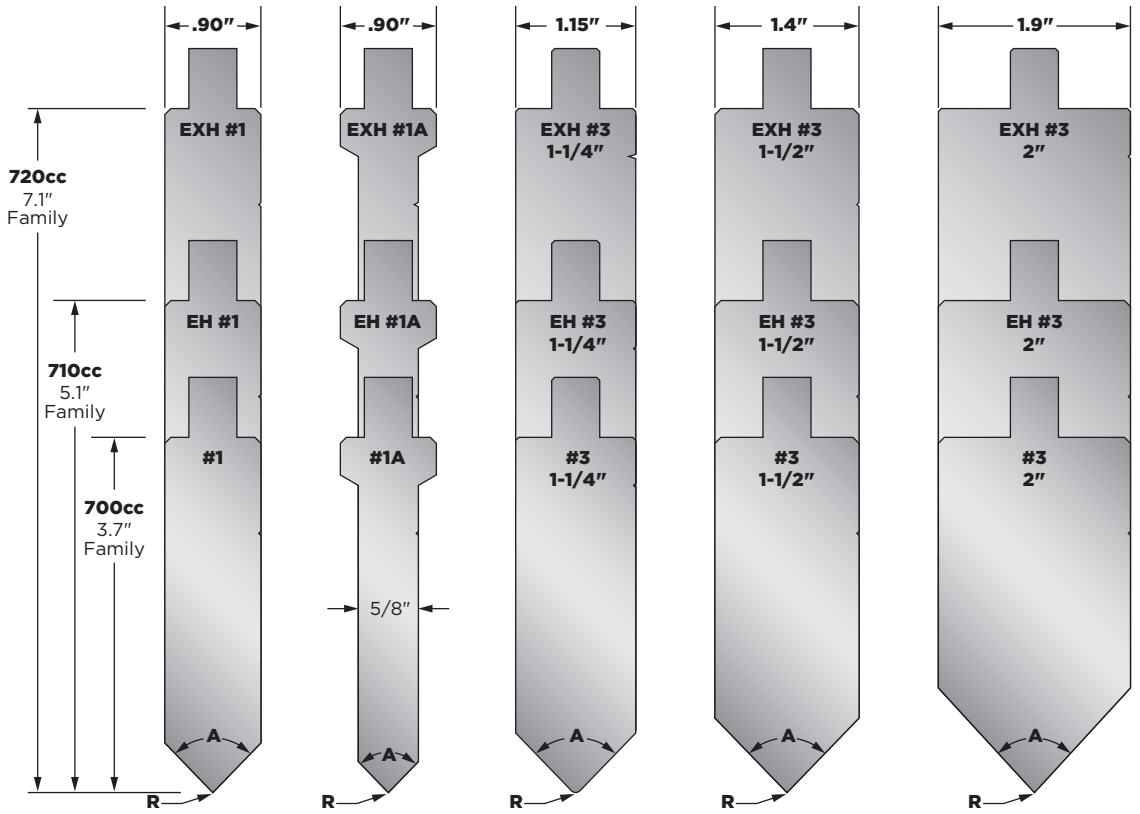
Bottoming is used when high accuracy and sharp corners are needed. This process requires three to five times the pressure used in air bending. Since more tonnage is needed, bottoming dies are seldom used on steel heavier than 12 gauge.



Wilson Tool American Planed press brake bottoming dies have an included angle of 90°, and lower die capacities are based on eight times the material thickness. For tighter radii and less spring-back, the die opening is five times the material thickness.

# BLOCK PUNCHES

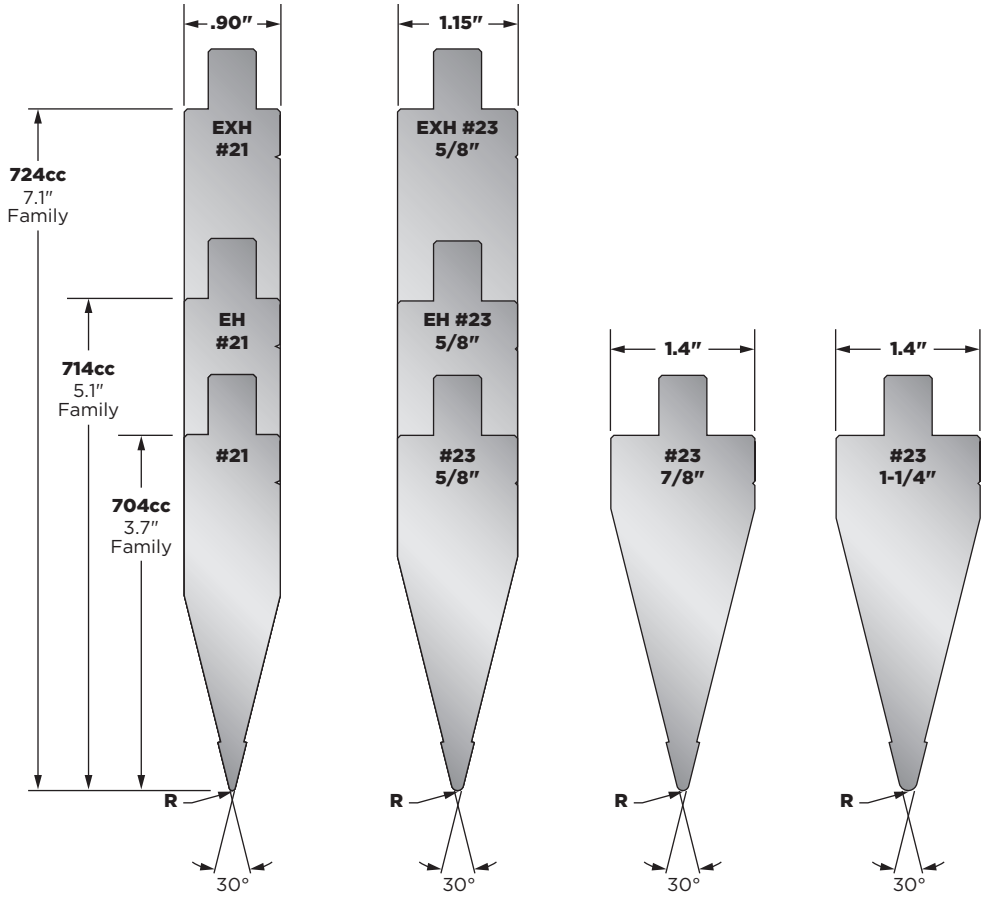





| Part No. | A Angle | R Tip Radius inch [mm] Min. | R Tip Radius inch [mm] Max. | Weight per foot lbs. | Bend Limit Graph |
|---|---|---|---|---|---|
| **SERIES 700cc — 3.7" FAMILY** | | | | | |
| **#1** | 75° - 90° | 1/64 [0.4] | 1/8 [3.18] | 14 | pg. 11 |
| **#1A** | | | | 11 | pg. 12 |
| **#3 1-1/4"** | | | | 17 | pg. 13 |
| **#3 1-1/2"** | | 1/8 [3.18] | 1/2 [12.7] | 20 | pg. 14 |
| **#3 2"** | | | | 22 | pg. 15 |
| **SERIES 710cc — 5.1" FAMILY** | | | | | |
| **EH #1** | 75° - 90° | 1/64 [0.4] | 1/8 [3.18] | 19 | pg. 11 |
| **EH #1A** | | | | 14 | pg. 12 |
| **EH #3 1-1/4"** | | | | 22 | pg. 13 |
| **EH #3 1-1/2"** | | 1/8 [3.18] | 1/2 [12.7] | 27 | pg. 14 |
| **EH #3 2"** | | | | 31 | pg. 15 |
| **SERIES 720cc — 7.1" FAMILY** | | | | | |
| **EXH #1** | 75° - 90° | 1/64 [0.4] | 1/8 [3.18] | 26 | pg. 11 |
| **EXH #1A** | | | | 18 | pg. 12 |
| **EXH #3 1-1/4"** | | | | 30 | pg. 13 |
| **EXH #3 1-1/2"** | | 1/8 [3.18] | 1/2 [12.7] | 37 | pg. 14 |
| **EXH #3 2"** | | | | 45 | pg. 15 |

Outside widths shown are bar sizes prior to cleanup.

# ACUTE PUNCHES

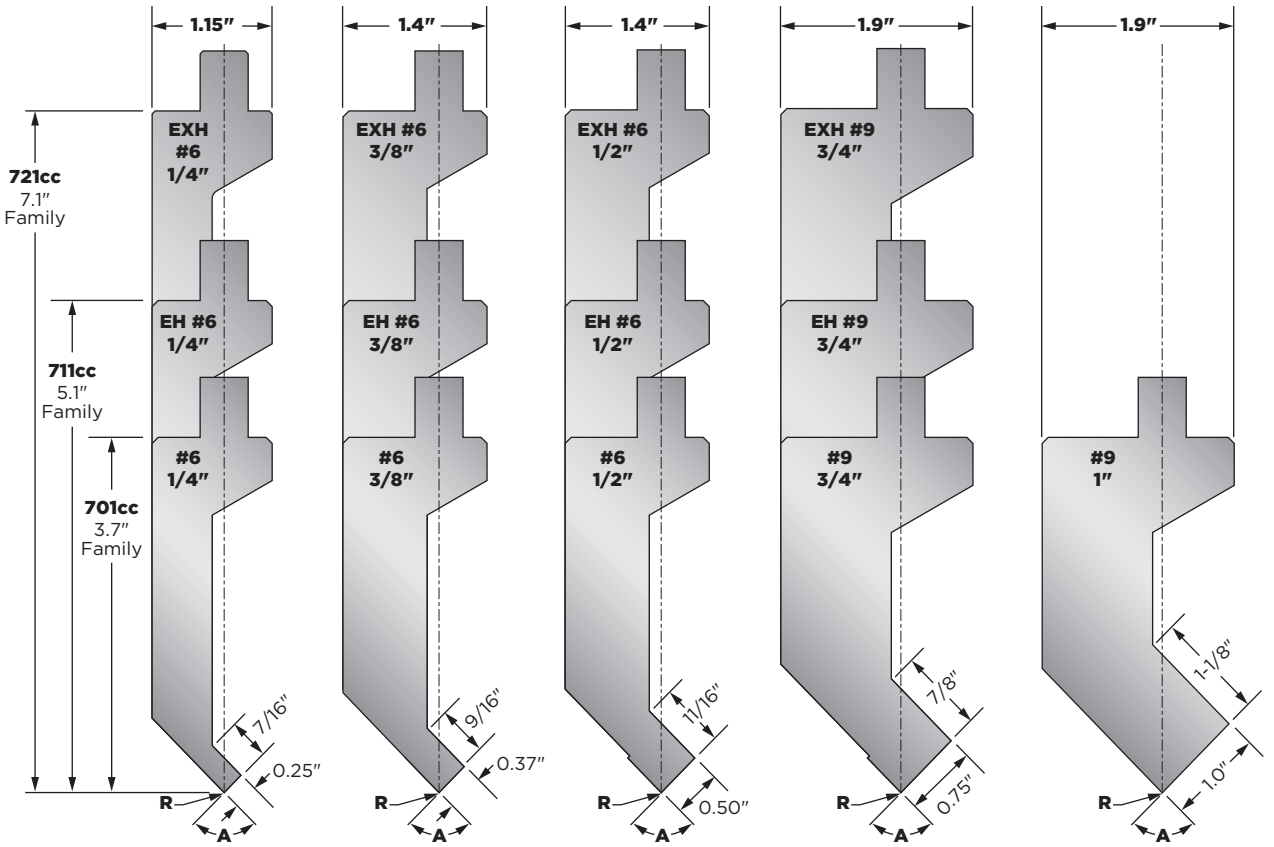



| Part No. | Angle | R Tip Radius inch [mm] | | Weight per foot lbs. | Bend Limit Graph |
|---|---|---|---|---|---|
| | | Min. | Max. | | |
| **SERIES 704cc — 3.7" FAMILY** | | | | | |
| **#21** | 30° | 1/64 [0.4] | 1/8 [3.18] | 13 | pg. 16 |
| **#23 5/8"** | | | | 15 | pg. 17 |
| **#23 7/8"** | | | | 15 | pg. 18 |
| **#23 1-1/4"** | | | | 15 | pg. 19 |
| **SERIES 714cc — 5.1" FAMILY** | | | | | |
| **EH #21** | 30° | 1/64 [0.4] | 1/8 [3.18] | 18 | pg. 16 |
| **EH #23 5/8"** | | | | 20 | pg. 17 |
| **SERIES 724cc — 7.1" FAMILY** | | | | | |
| **EXH #21** | 30° | 1/64 [0.4] | 1/8 [3.18] | 25 | pg. 16 |
| **EXH #23 5/8"** | | | | 28 | pg. 17 |

Outside widths shown are bar sizes prior to cleanup.

# SASH PUNCHES

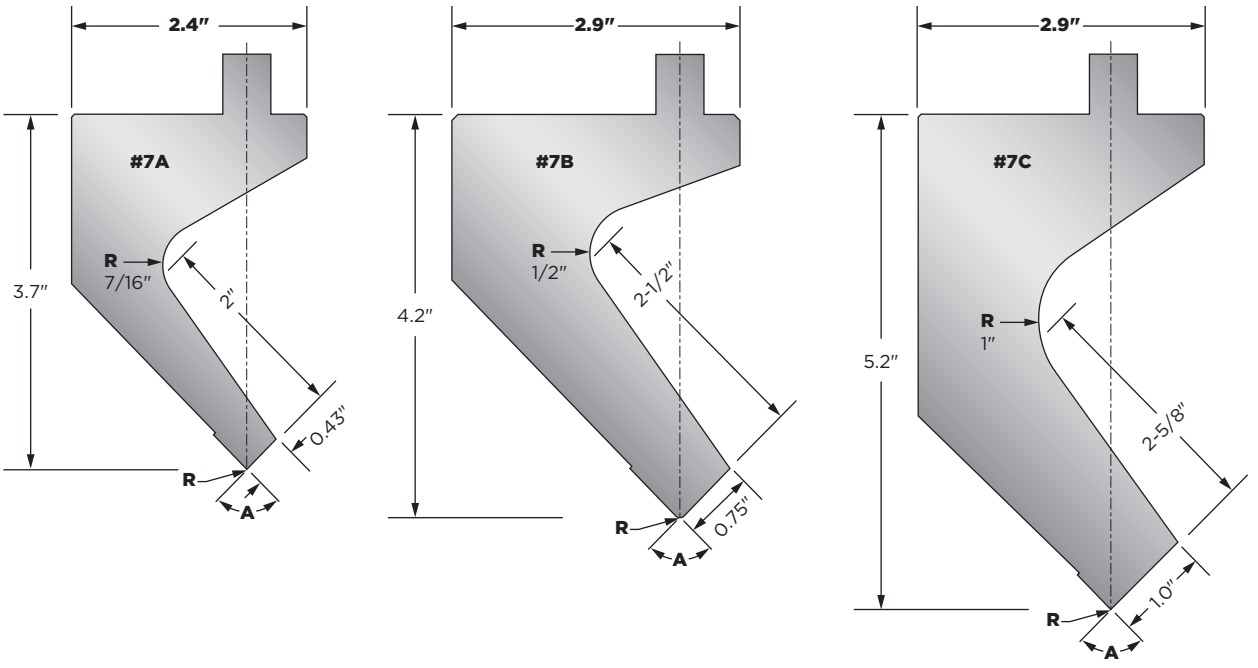





| Part No. | A Angle | R Tip Radius inch [mm] Min. | R Tip Radius inch [mm] Max. | Weight per foot lbs. | Bend Limit Graph |
|---|---|---|---|---|---|
| **SERIES 701cc — 3.7″ FAMILY** | | | | | |
| **#6 1/4″** | 75° - 90° | 1/64 [0.4] | 1/16 [1.59] | 14 | pg. 20 |
| **#6 3/8″** | | | | 16 | pg. 21 |
| **#6 1/2″** | | 1/32 [0.794] | | 16 | pg. 22 |
| **#9 3/4″** | | 1/8 [3.18] | 1/2 [12.7] | 22 | pg. 23 |
| **#9 1″** | | | | 22 | pg. 24 |
| **SERIES 711cc — 5.1″ FAMILY** | | | | | |
| **EH #6 1/4″** | 75° - 90° | 1/64 [0.4] | 1/16 [1.59] | 18 | pg. 20 |
| **EH #6 3/8″** | | | | 20 | pg. 21 |
| **EH #6 1/2″** | | 1/32 [0.794] | | 20 | pg. 22 |
| **EH #9 3/4″** | | 1/8 [3.18] | 1/2 [12.7] | 27 | pg. 23 |
| **SERIES 721cc — 7.1″ FAMILY** | | | | | |
| **EXH #6 1/4″** | 75° - 90° | 1/64 [0.4] | 1/16 [1.59] | 22 | pg. 20 |
| **EXH #6 3/8″** | | | | 24 | pg. 21 |
| **EXH #6 1/2″** | | 1/32 [0.794] | | 24 | pg. 22 |
| **EXH #9 3/4″** | | 1/8 [3.18] | 1/2 [12.7] | 34 | pg. 23 |

Outside widths shown are bar sizes prior to cleanup.

# GOOSENECK PUNCHES




| Part No. | A Angle | R Tip Radius inch [mm] Min. | R Tip Radius inch [mm] Max. | Weight per foot lbs. | Bend Limit Graph |
|---|---|---|---|---|---|
| **SERIES 702cc** | | | | | |
| **#7A** | 75° – 90° | 1/32 [0.794] | 1/16 [1.59] | 16 | pg. 25 |
| **#7B** | | 1/8 [3.18] | 1/2 [12.7] | 24 | pg. 26 |
| **#7C** | | | | 32 | pg. 27 |

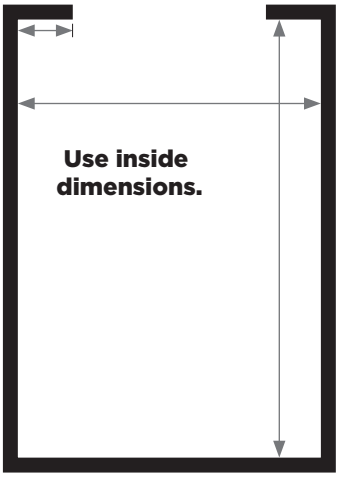
Outside widths shown are bar sizes prior to cleanup.

# HOW TO USE A BEND LIMIT GRAPH

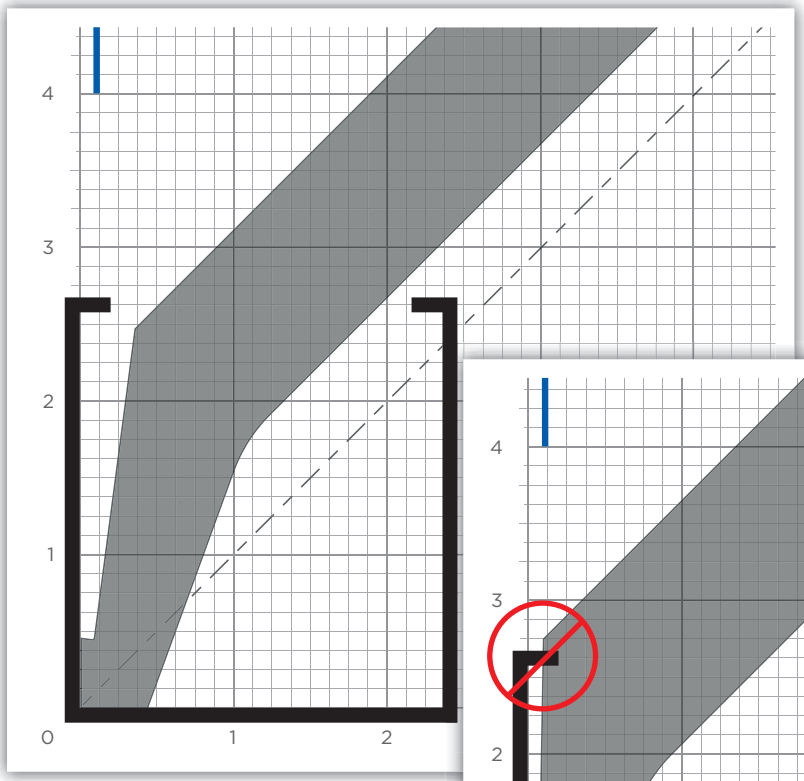
Although a bend limit graph won't help with bend sequencing, it will help determine what punch profile is best for you. Visit our YouTube channel for a step-by-step video on using these graphs.

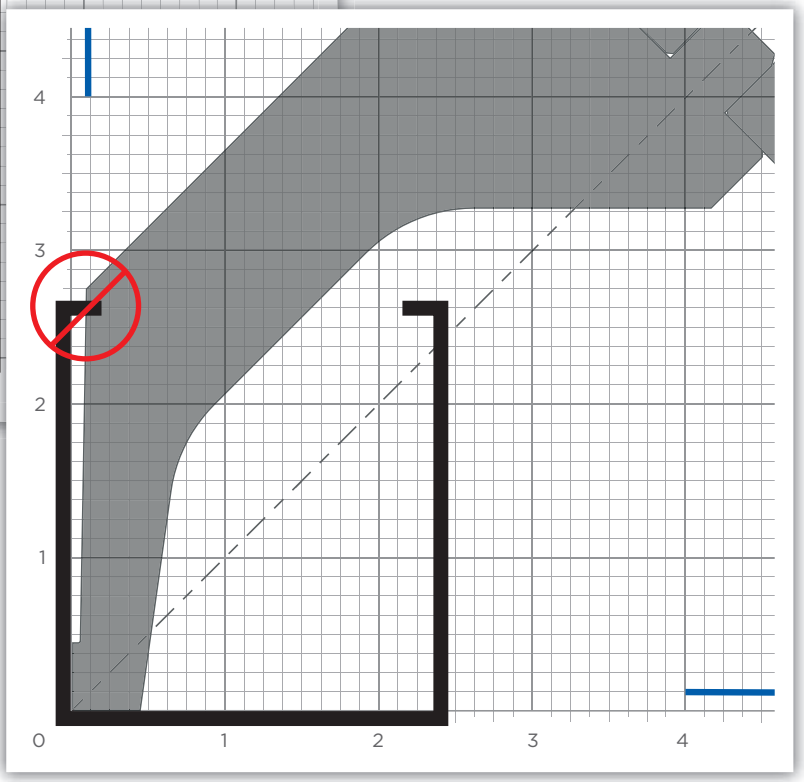
- The graphs are 1:1
- Your part can be laid on top of the catalog page
- Use inside dimensions — always account for material thickness






**This application works.**

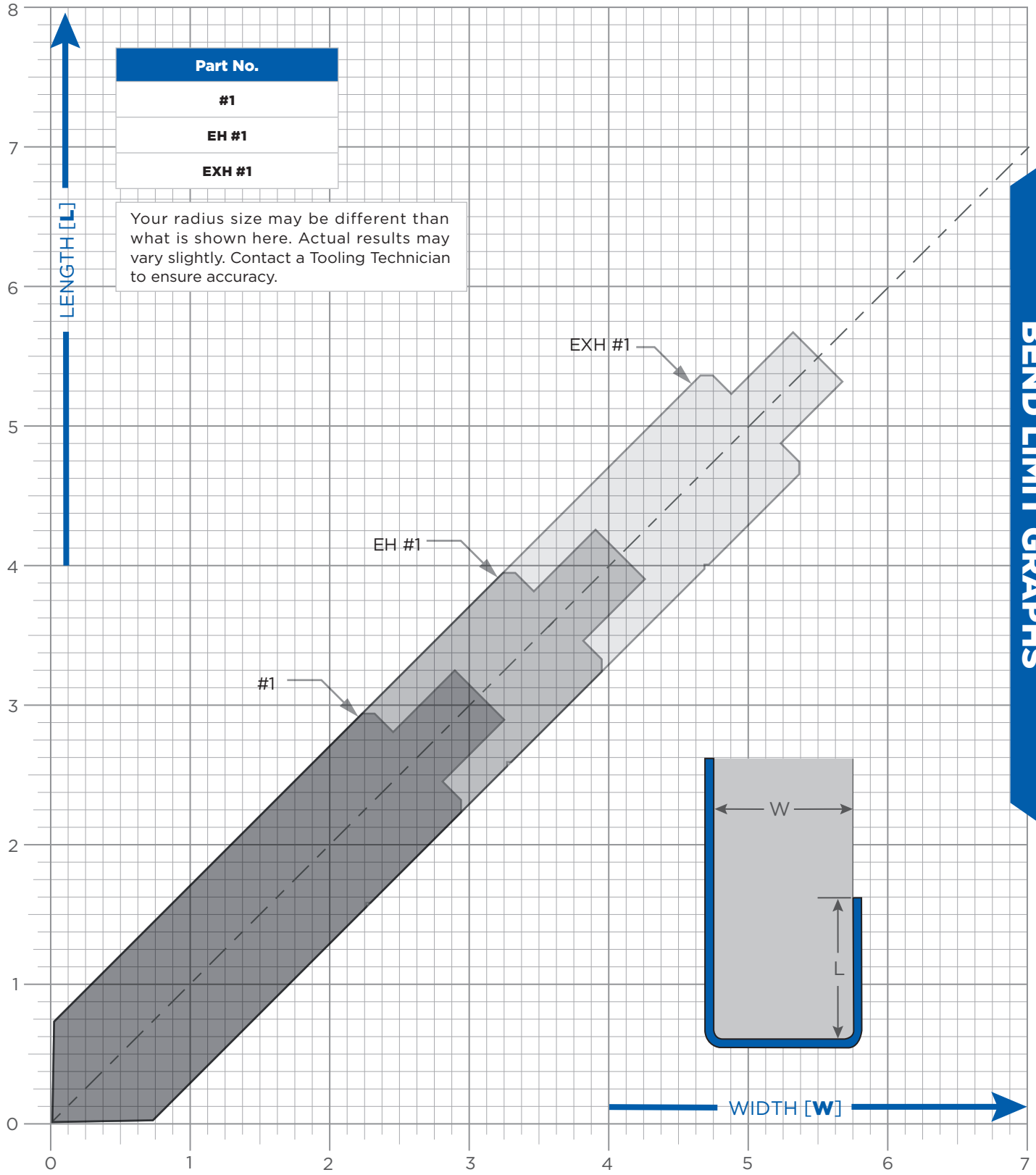



**This application doesn't work.**

**Scan QR Code to Watch the Video**

# BLOCK PUNCHES #1



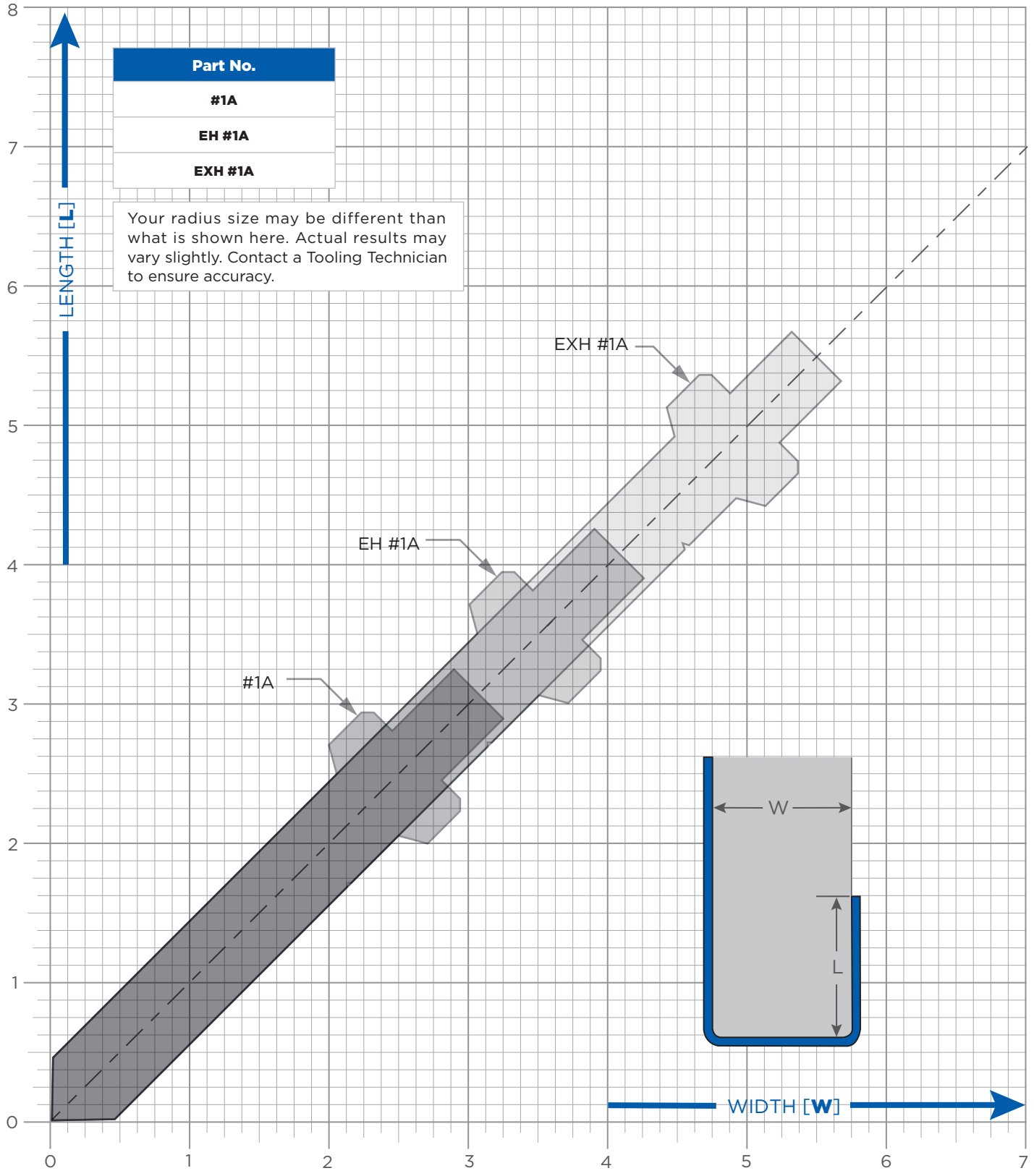

BEND LIMIT GRAPHS

# BLOCK PUNCHES
# #1A

BEND LIMIT GRAPHS

| Part No. |
| --- |
| #1A |
| EH #1A |
| EXH #1A |

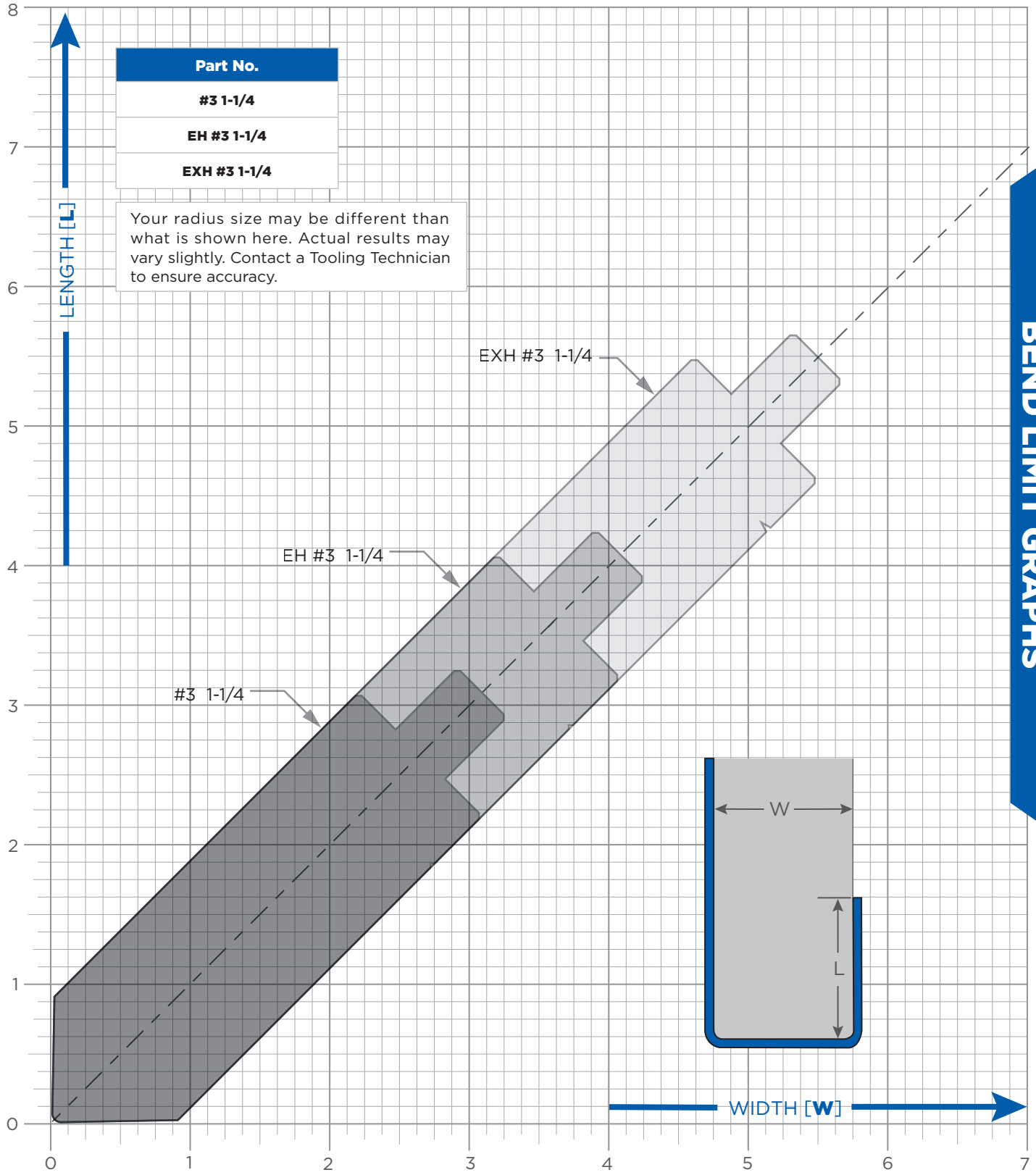
Your radius size may be different than what is shown here. Actual results may vary slightly. Contact a Tooling Technician to ensure accuracy.



# BLOCK PUNCHES
# #3 1-1/4"

| Part No. |
| --- |
| #3 1-1/4 |
| EH #3 1-1/4 |
| EXH #3 1-1/4 |

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



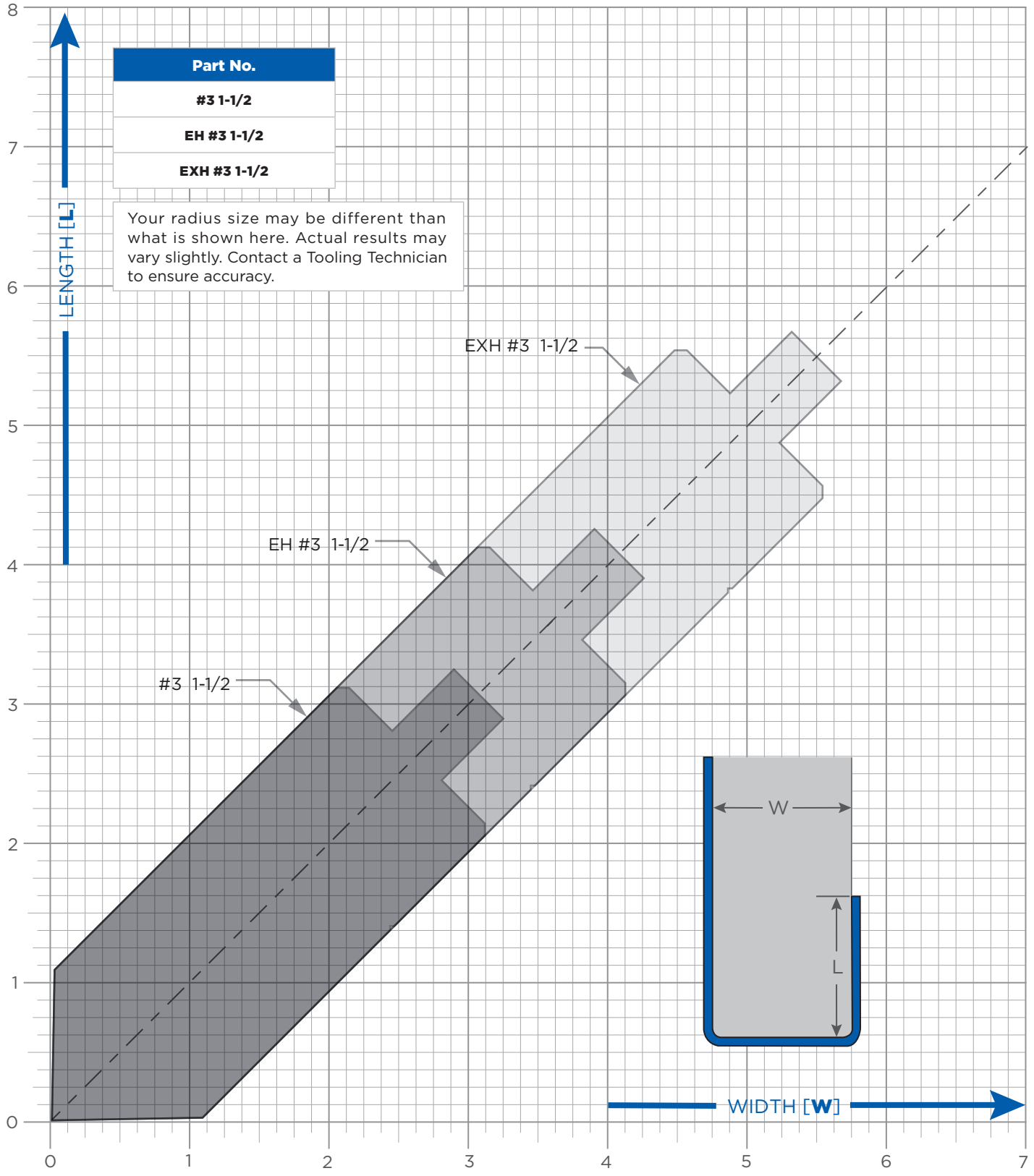

BEND LIMIT GRAPHS

# BLOCK PUNCHES
# #3 1-1/2"

BEND LIMIT GRAPHS

| Part No. |
| --- |
| #3 1-1/2 |
| EH #3 1-1/2 |
| EXH #3 1-1/2 |

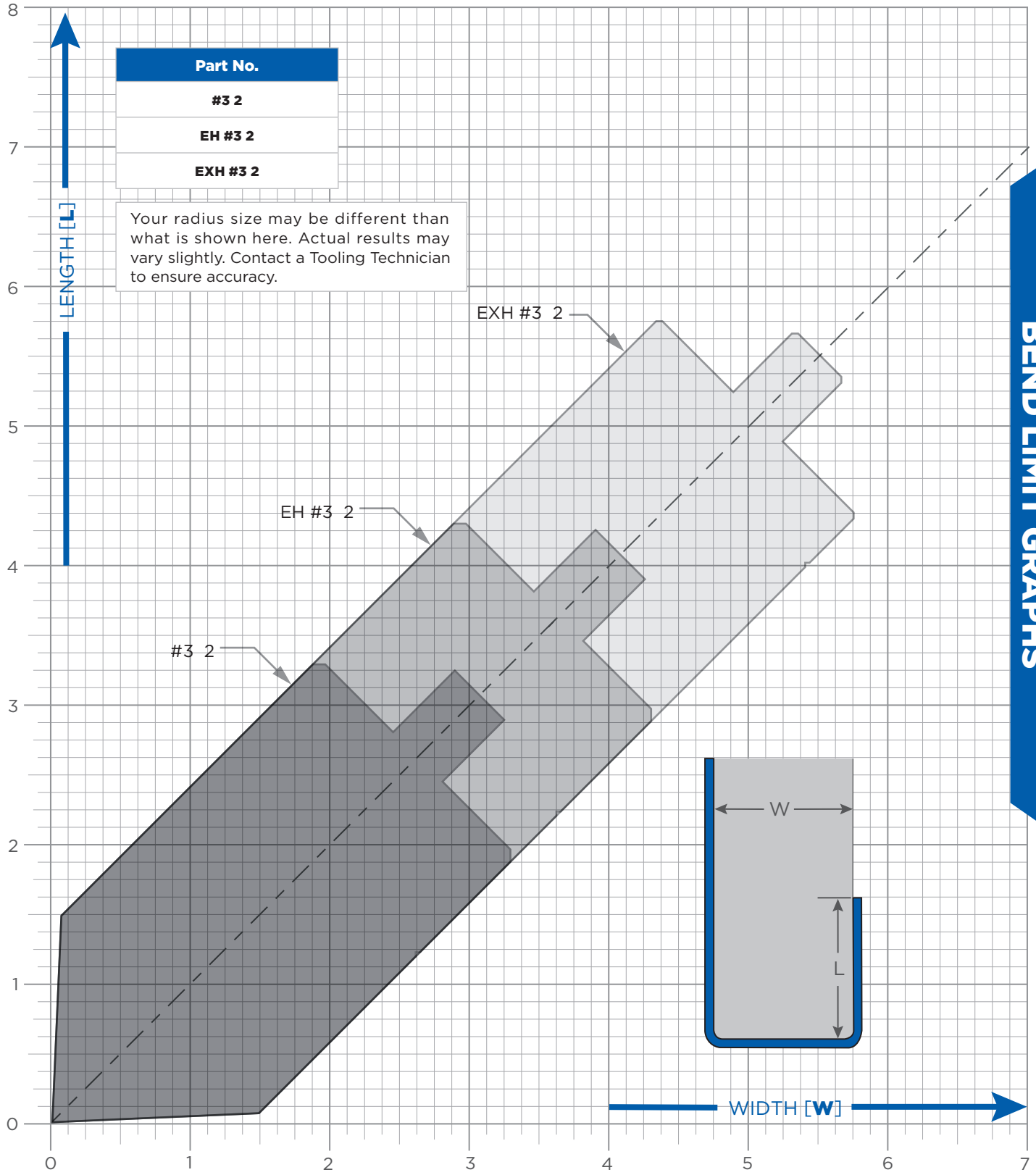
Your radius size may be different than what is shown here. Actual results may vary slightly. Contact a Tooling Technician to ensure accuracy.



# BLOCK PUNCHES
# #3 2"

| Part No. |
| --- |
| #3 2 |
| EH #3 2 |
| EXH #3 2 |

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



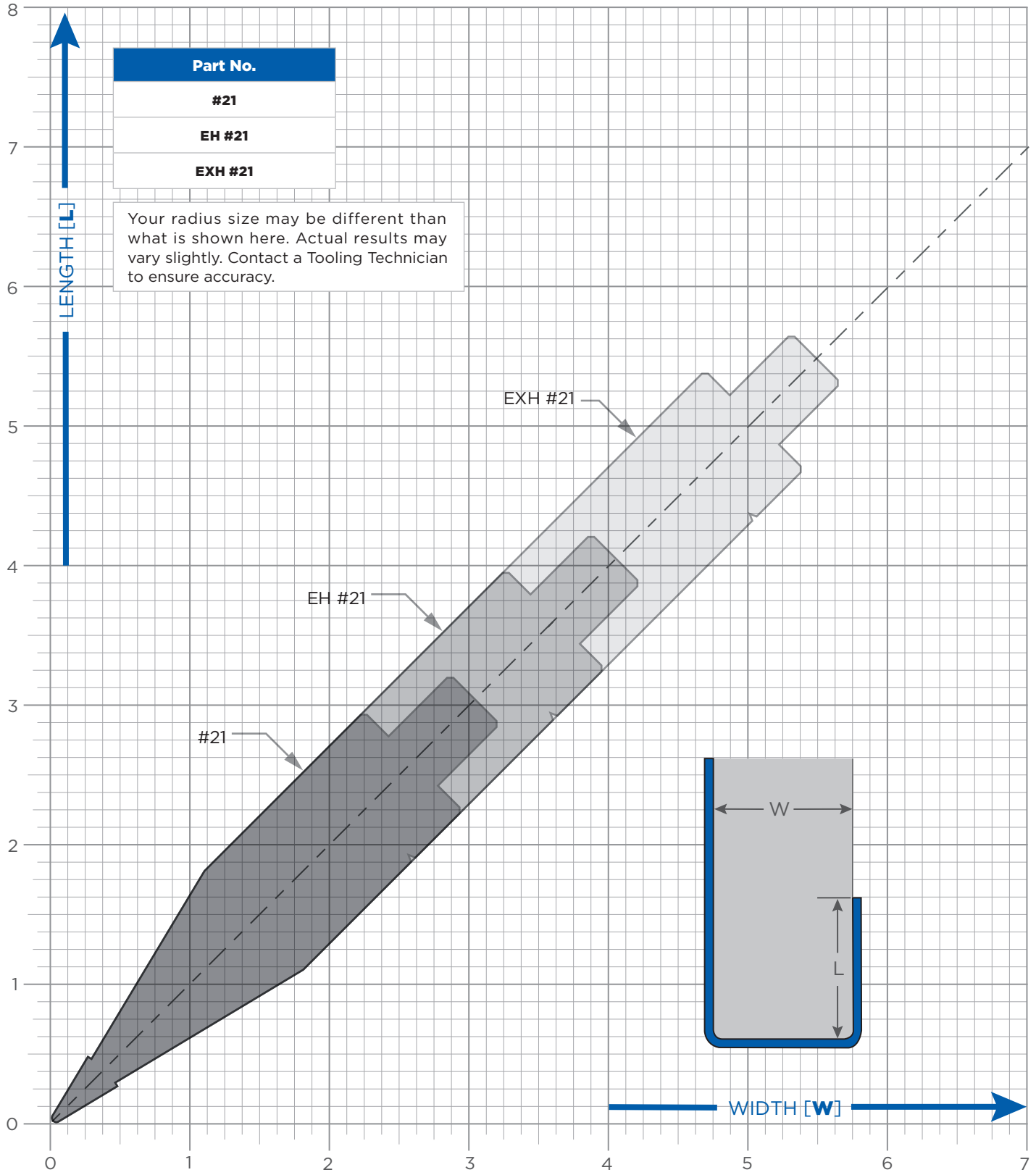

BEND LIMIT GRAPHS

# ACUTE PUNCHES #21



| Part No. |
| --- |
| #21 |
| EH #21 |
| EXH #21 |

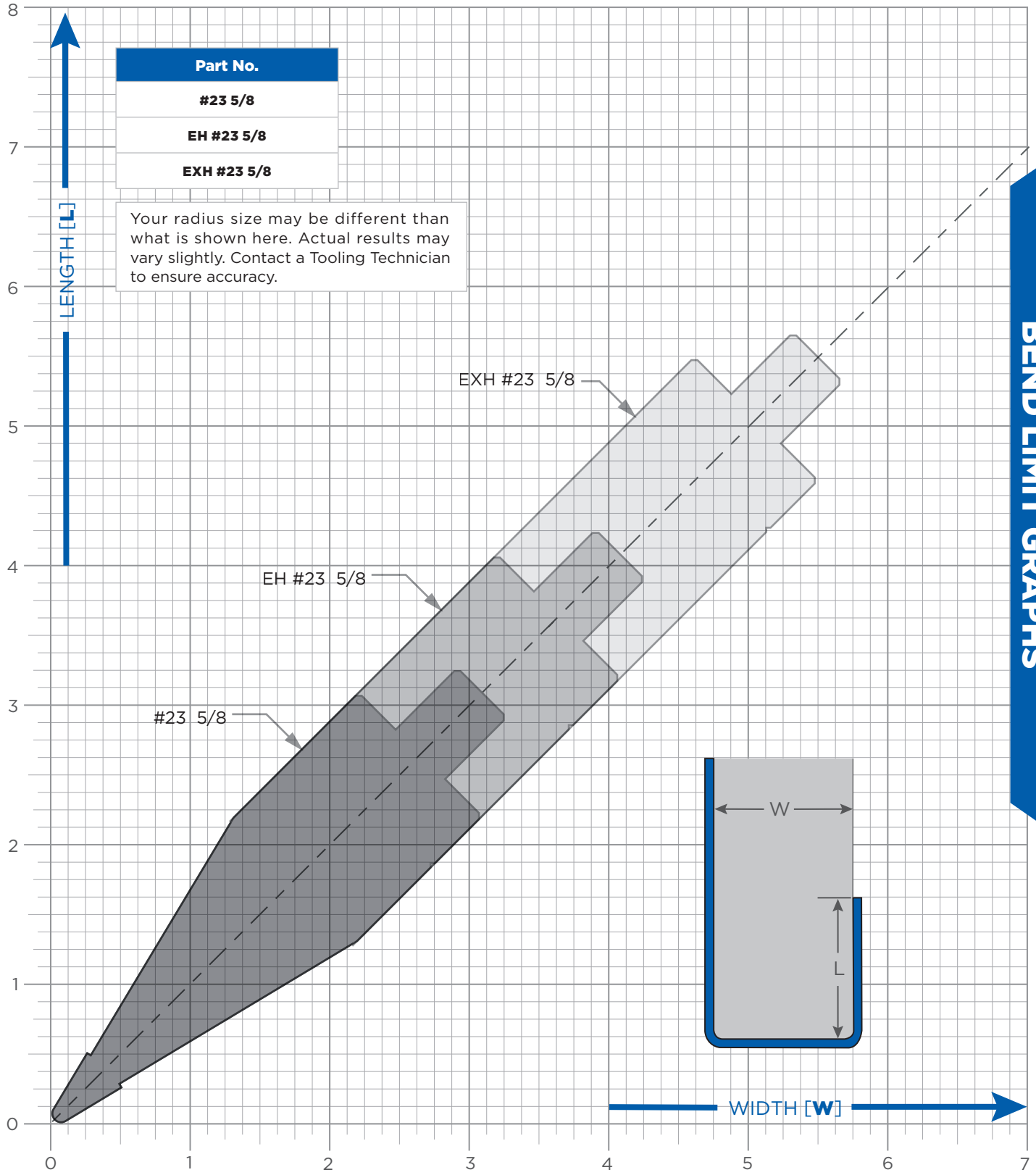
Your radius size may be different than what is shown here. Actual results may vary slightly. Contact a Tooling Technician to ensure accuracy.



# ACUTE PUNCHES
# #23 5/8"

| Part No. |
| --- |
| #23 5/8 |
| EH #23 5/8 |
| EXH #23 5/8 |

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



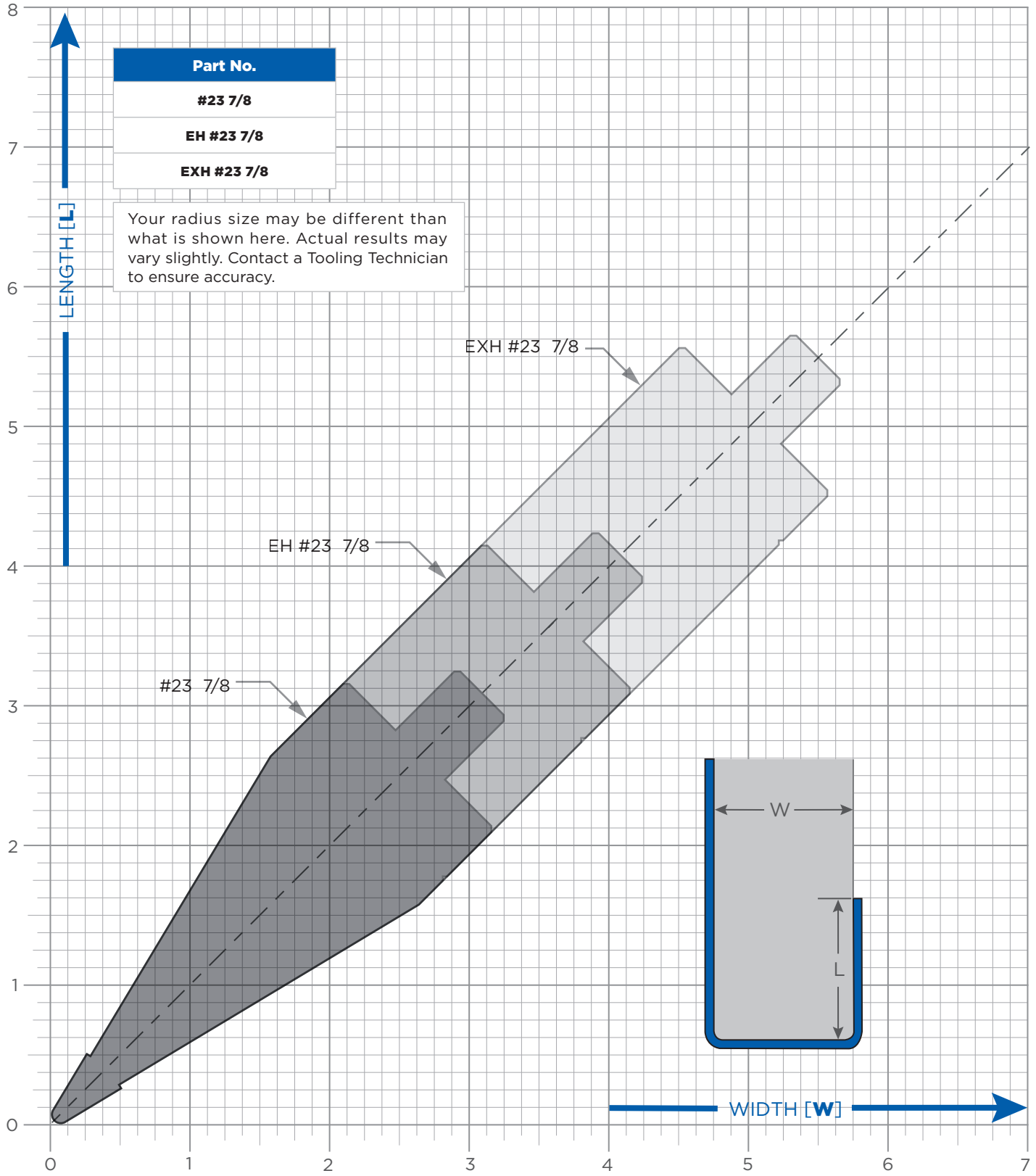

BEND LIMIT GRAPHS

# ACUTE PUNCHES
# #23 7/8"

BEND LIMIT GRAPHS

| Part No. |
| --- |
| #23 7/8 |
| EH #23 7/8 |
| EXH #23 7/8 |

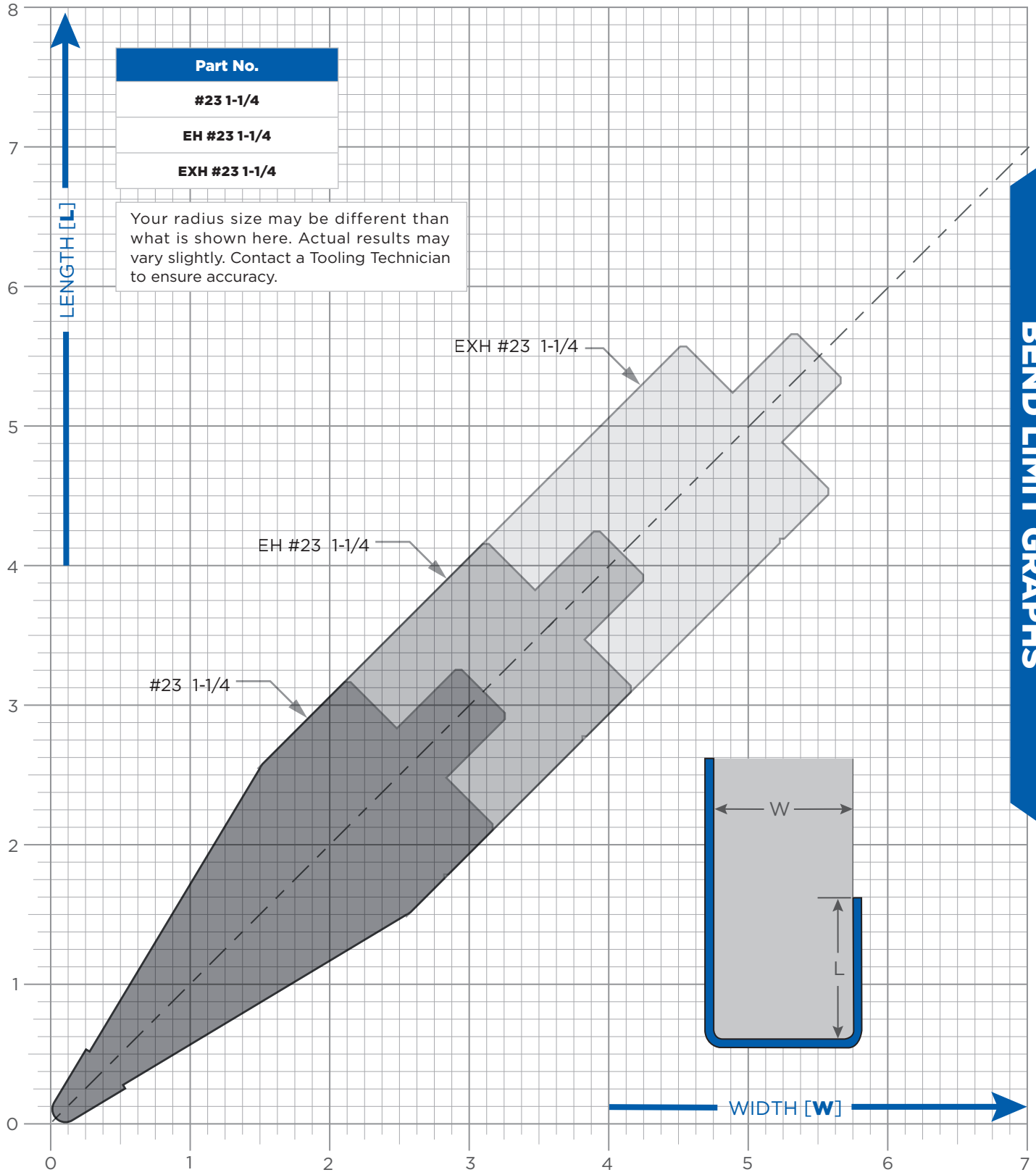
Your radius size may be different than what is shown here. Actual results may vary slightly. Contact a Tooling Technician to ensure accuracy.



# ACUTE PUNCHES
# #23 1-1/4"

| Part No. |
|---|
| #23 1-1/4 |
| EH #23 1-1/4 |
| EXH #23 1-1/4 |

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



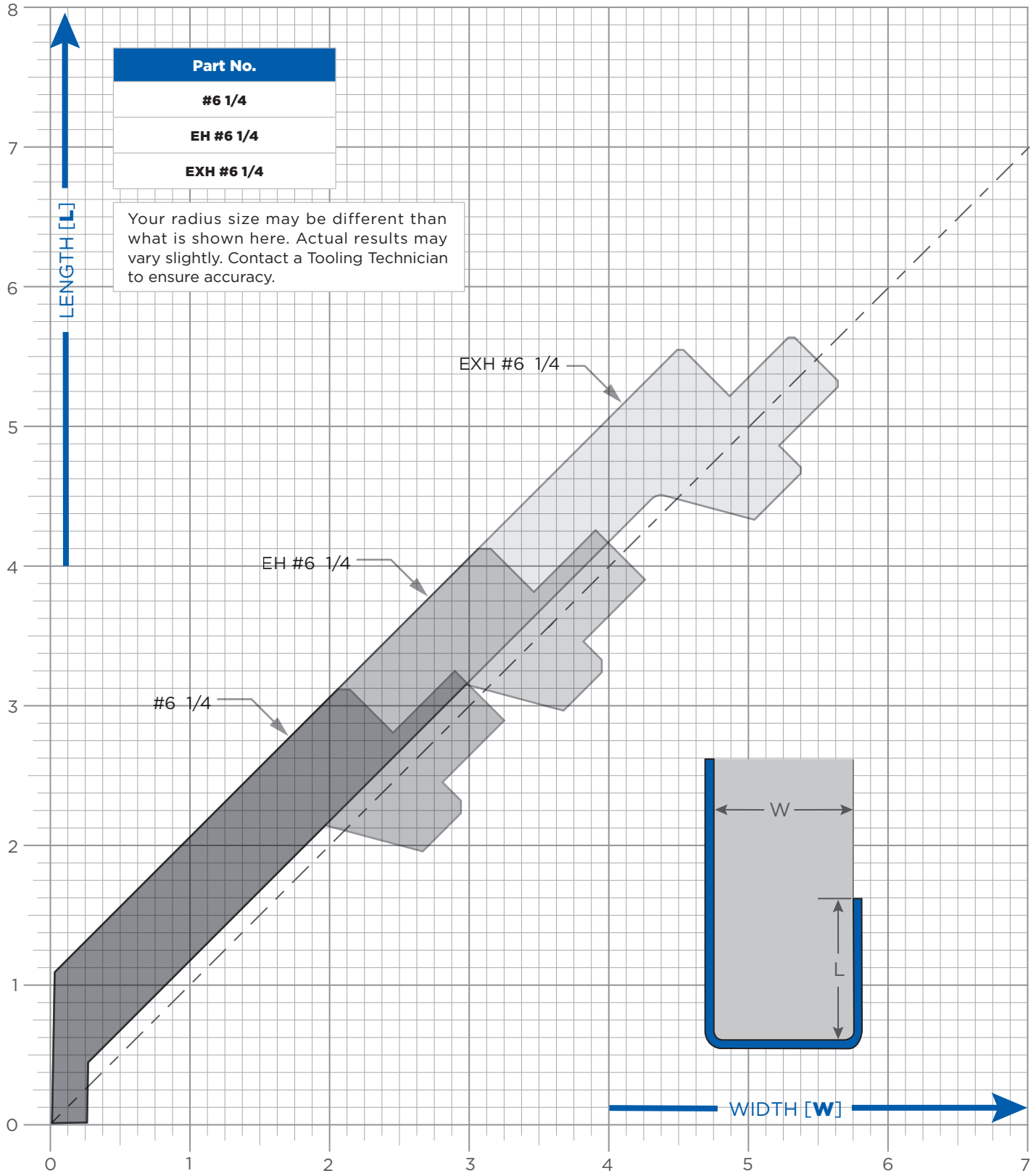

BEND LIMIT GRAPHS

# SASH PUNCHES
# #6 1/4"



| Part No. |
|---|
| #6 1/4 |
| EH #6 1/4 |
| EXH #6 1/4 |

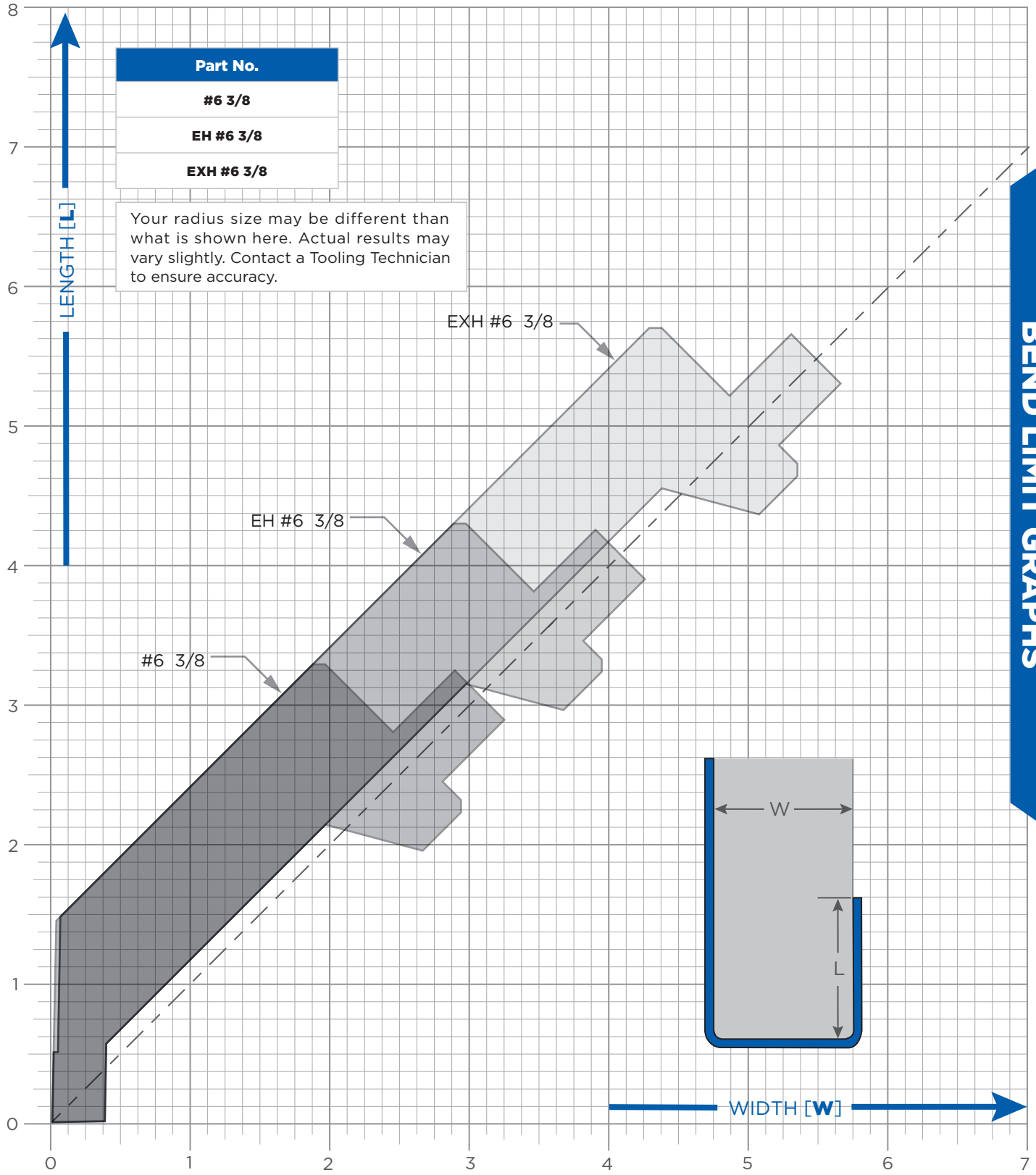
Your radius size may be different than what is shown here. Actual results may vary slightly. Contact a Tooling Technician to ensure accuracy.



# SASH PUNCHES
# #6 3/8"

| Part No. |
| --- |
| #6 3/8 |
| EH #6 3/8 |
| EXH #6 3/8 |

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



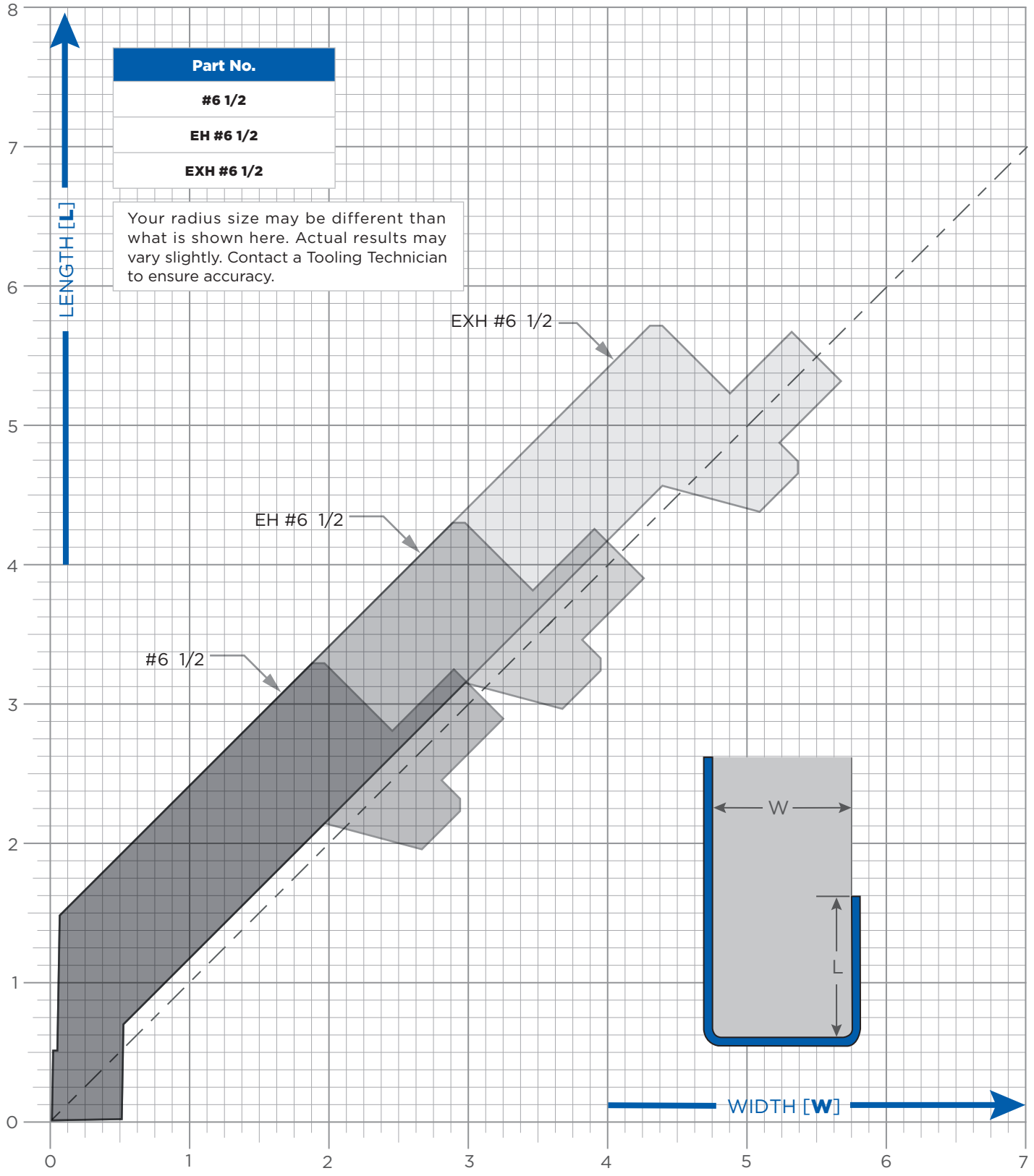

BEND LIMIT GRAPHS

# SASH PUNCHES
# #6 1/2"

BEND LIMIT GRAPHS

| Part No. |
| --- |
| #6 1/2 |
| EH #6 1/2 |
| EXH #6 1/2 |

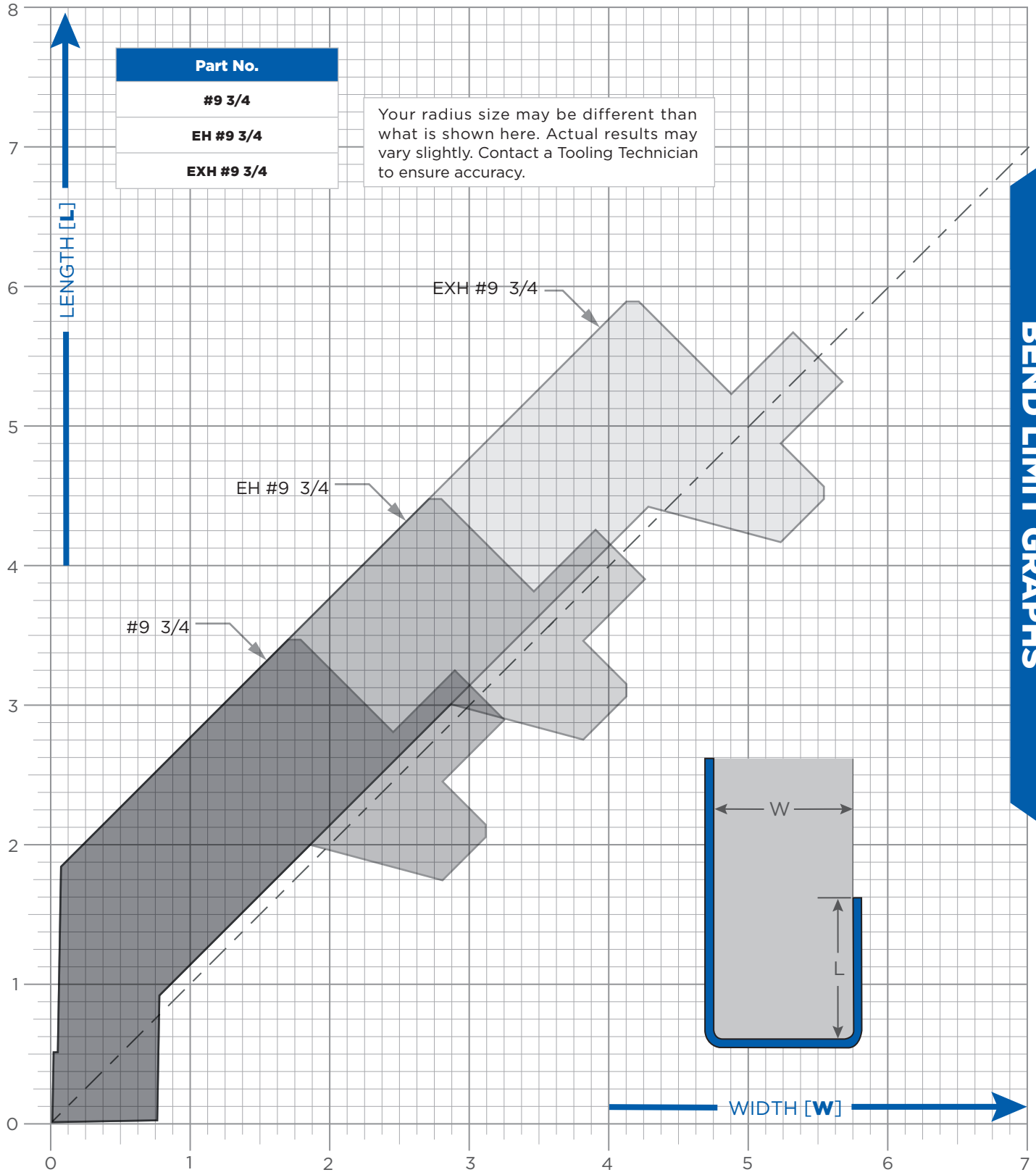
Your radius size may be different than what is shown here. Actual results may vary slightly. Contact a Tooling Technician to ensure accuracy.



# SASH PUNCHES
# #9 3/4"

| Part No. |
| --- |
| #9 3/4 |
| EH #9 3/4 |
| EXH #9 3/4 |

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



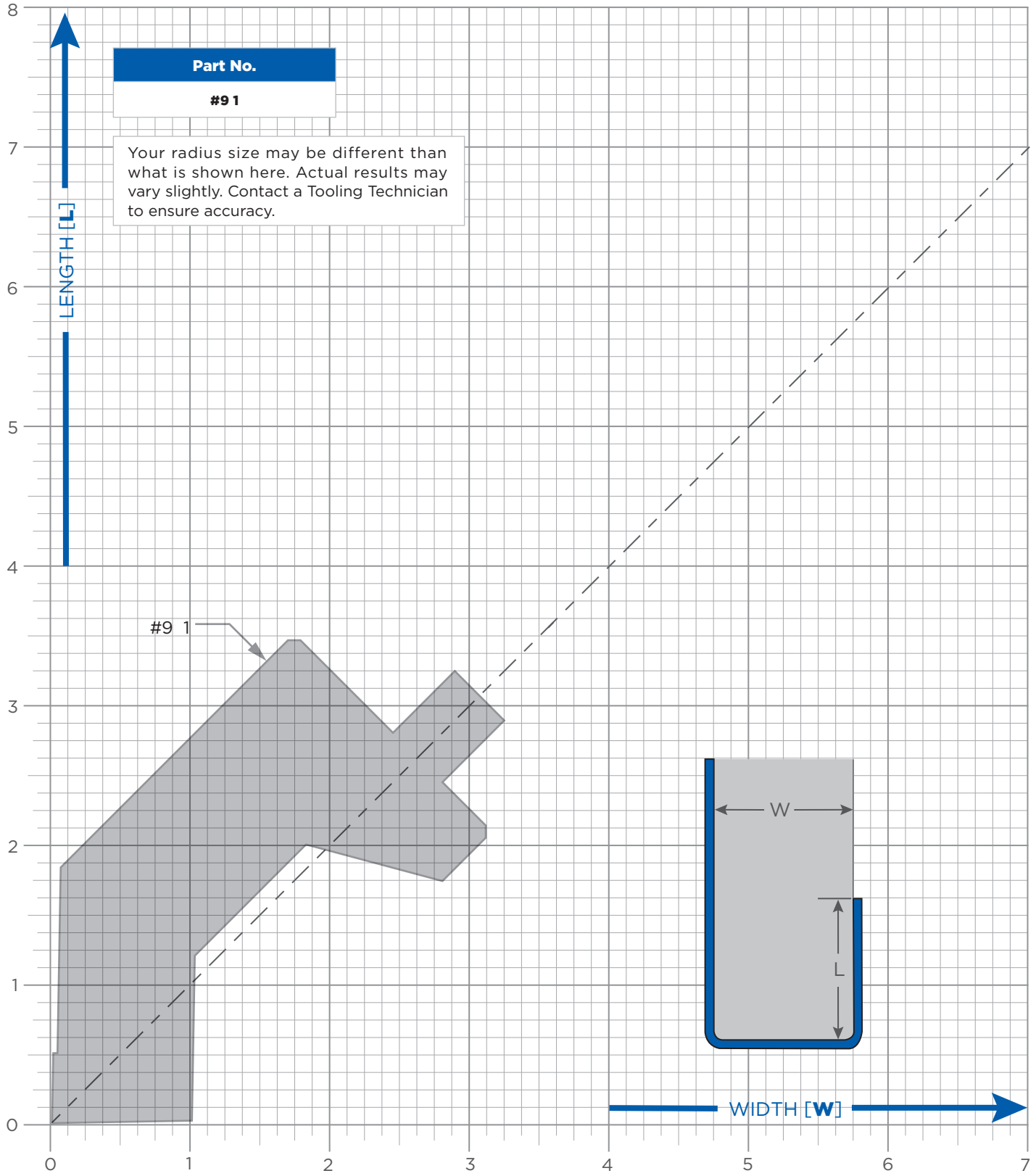

BEND LIMIT GRAPHS

# SASH PUNCHES
# #9 1"

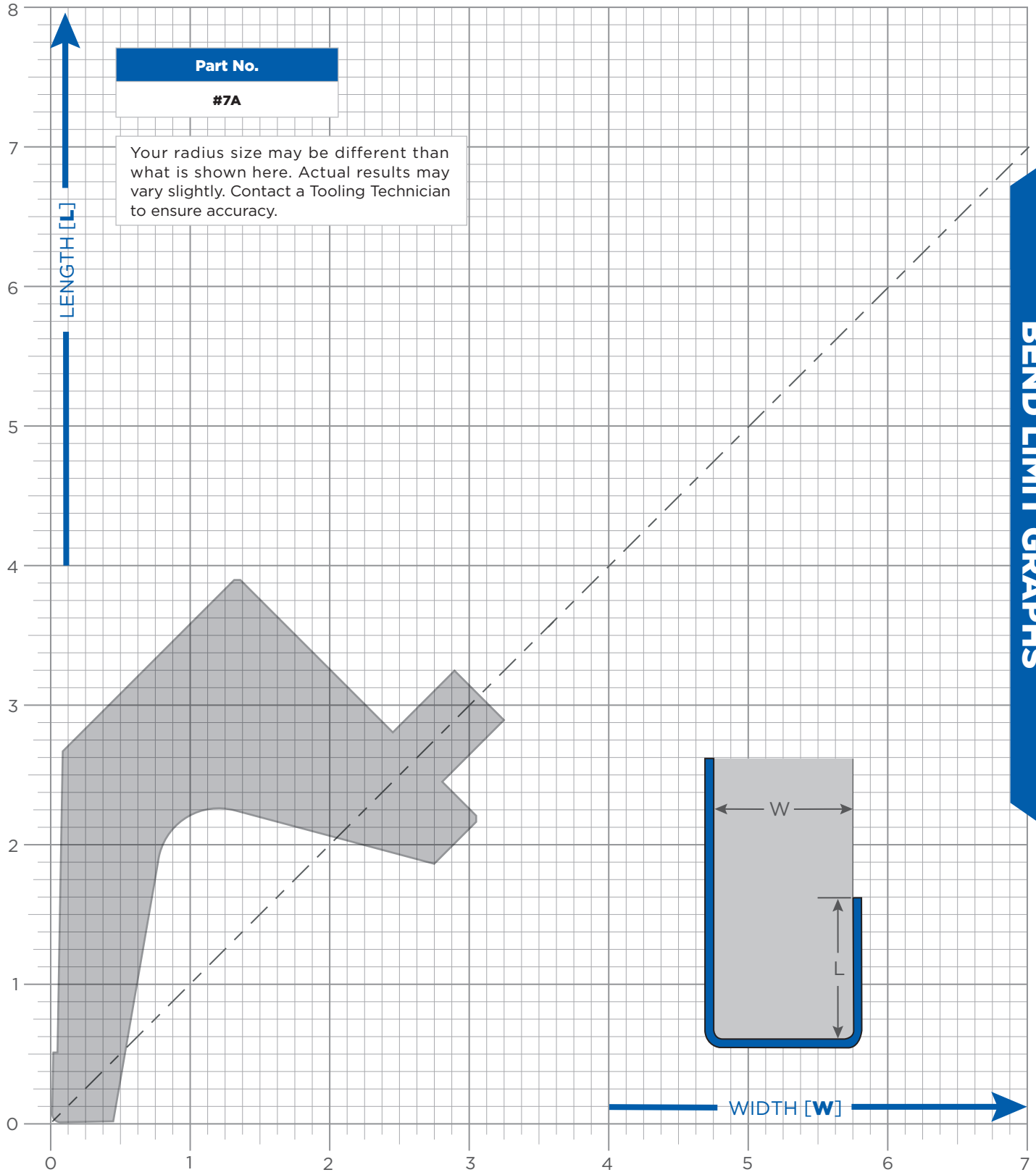
BEND LIMIT GRAPHS

| Part No. |
| --- |
| #9 1 |

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



# GOOSENECK PUNCH #7A



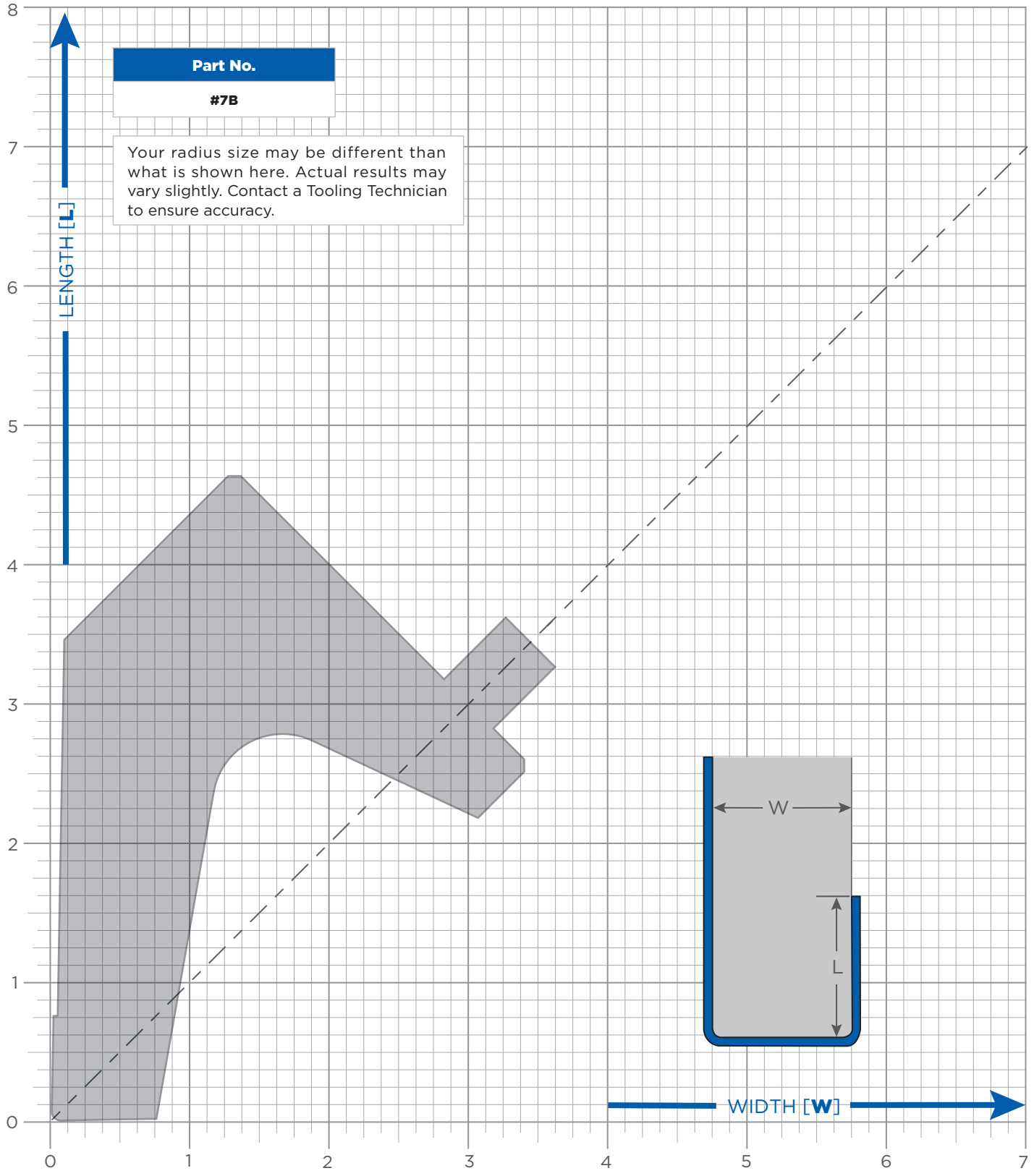

BEND LIMIT GRAPHS

# GOOSENECK PUNCH #7B

BEND LIMIT GRAPHS

| Part No. |
| --- |
| #7B |

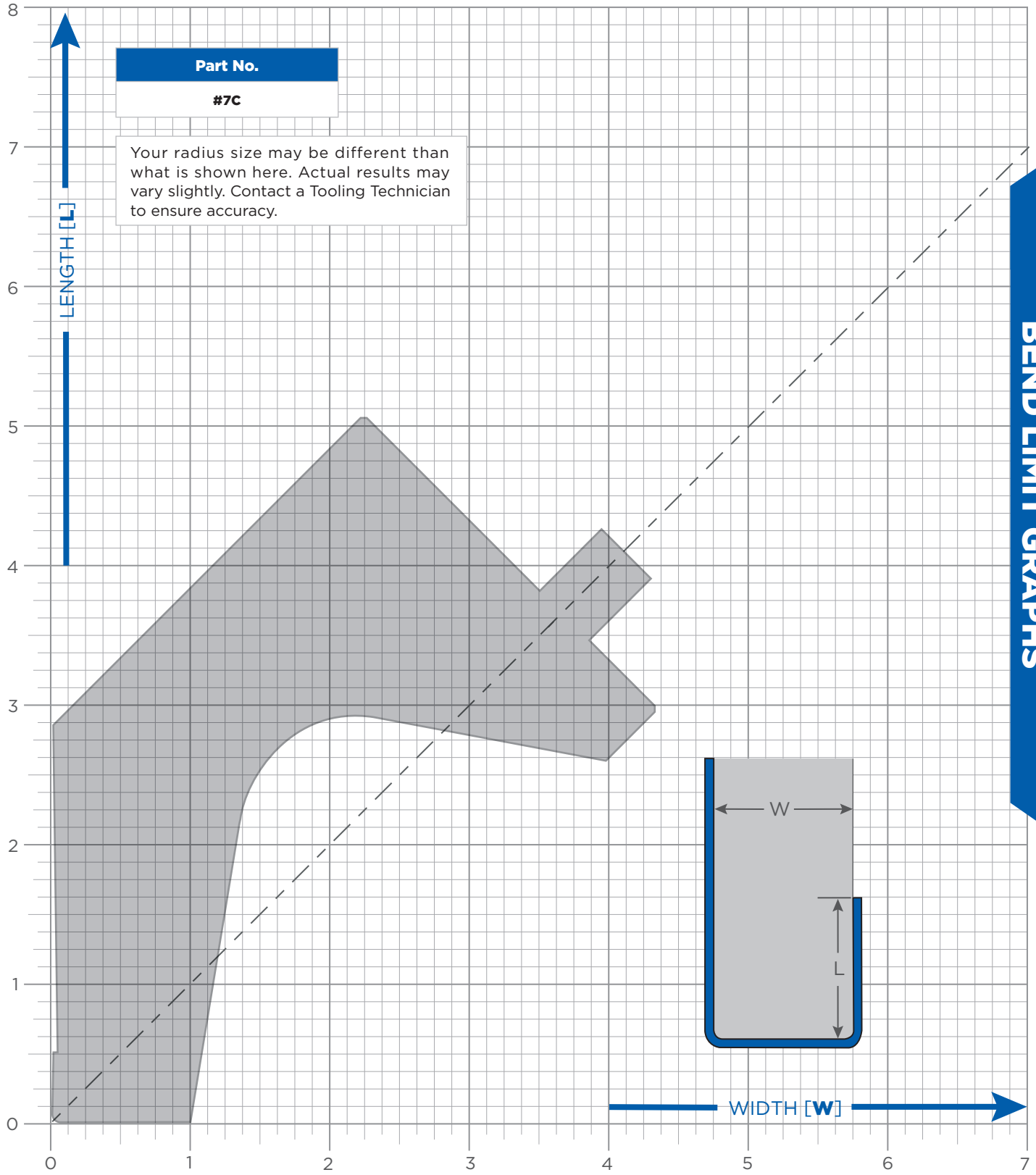
Your radius size may be different than what is shown here. Actual results may vary slightly. Contact a Tooling Technician to ensure accuracy.



# GOOSENECK PUNCH #7C

| Part No. |
| --- |
| #7C |

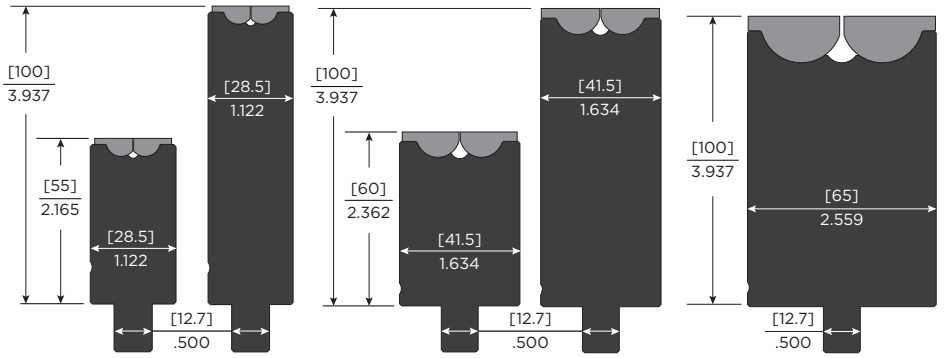
Your radius size may be different than what is shown here. Actual results may vary slightly. Contact a Tooling Technician to ensure accuracy.




BEND LIMIT GRAPHS

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






**51055 51100**
**MODEL 1**

**52060 52100**
**MODEL 2**

**525100**
**MODEL 2.5**

**Scan QR Code to Watch the Video**

| MODEL 1 | SOLID | | | | SECTIONAL | | X1 | | X2 | |
|---|---|---|---|---|---|---|---|---|---|---|
| Length | 9.84" [250mm] | | 19.68" [500mm] | | 21.65" [550mm] | | 10.83" [275mm] | | 10.83" [275mm] | |
| Height | 55mm | 100mm | 55mm | 100mm | 55mm | 100mm | 55mm | 100mm | 55mm | 100mm |
| Assembly Part No. | 51055-250 | 51100-250 | 51055-500 | 51100-500 | 51055-550 | 51100-550 | 51055x1 | 51100x1 | 51055x2 | 51100x2 |
| Spring | (20 qty.) 980682 | (20 qty.) 981031 | (40 qty.) 980682 | (40 qty.) 981031 | (44 qty.) 980682 | (44 qty.) 981031 | (22 qty.) 980682 | (22 qty.) 981031 | (22 qty.) 980682 | (22 qty.) 981031 |
| Weight | 6 lbs. | 10 lbs. | 11 lbs. | 20 lbs. | 13 lbs. | 22 lbs. | 6 lbs. | 11 lbs. | 6 lbs. | 11 lbs. |
| Insert Part No. | (2) 980872A | | (4) 980872A | | (2) 980873A & (2) 980874A | | (2) 987158A | | (2) 987159A | |

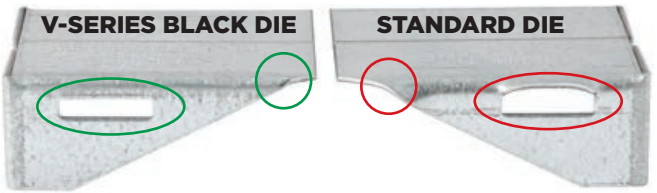
| MODEL 2 | SOLID | | | | SECTIONAL | | X1 | | X2 | |
|---|---|---|---|---|---|---|---|---|---|---|
| Length | 9.84" [250mm] | | 19.68" [500mm] | | 21.65" [550mm] | | 10.83" [275mm] | | 10.83" [275mm] | |
| Height | 60mm | 100mm | 60mm | 100mm | 60mm | 100mm | 60mm | 100mm | 60mm | 100mm |
| Assembly Part No. | 52060-250 | 52100-250 | 52060-500 | 52100-500 | 52060-550 | 52100-550 | 52060x1 | 52100x1 | 52060x2 | 52100x2 |
| Spring | (20 qty.) 980683 | (20 qty.) 981032 | (40 qty.) 980683 | (40 qty.) 981032 | (44 qty.) 980683 | (44 qty.) 981032 | (22 qty.) 980683 | (22 qty.) 981032 | (22 qty.) 980683 | (22 qty.) 981032 |
| Weight | 9 lbs. | 14 lbs. | 15 lbs. | 25 lbs. | 17 lbs. | 29 lbs. | 8 lbs. | 14 lbs. | 8 lbs. | 14 lbs. |
| Insert Part No. | (2) 980948 | | (4) 980948 | | (2) 980949 & (2) 980950 | | (2) 987160 | | (2) 987161 | |

| MODEL 2.5 | SOLID | | X1 | X2 |
|---|---|---|---|---|
| Length | 9.84" [250mm] | 19.68" [500mm] | 10.83" [275mm] | 10.83" [275mm] |
| Height | 100mm | 100mm | 100mm | 100mm |
| Assembly Part No. | 525100-250 | 525100-500 | 525100x1 | 525100x2 |
| Spring | (20 qty.) 981032 | (40 qty.) 981032 | (22 qty.) 981032 | (22 qty.) 981032 |
| Weight | 24 lbs. | 49 lbs. | 27 lbs. | 27 lbs. |
| Insert Part No. | (2) 990646 | (4) 990646 | (2) 990644 | (2) 990645 |

**NOT INTENDED FOR MECHANICAL PRESS BRAKES**
**Control in the press brake stroke is required for consistant results.**

| Model | Material Thickness inch [mm] | Min. Outside Flange inch [mm] | Ton/ Ft. | Min. Angle | Punch Radius Required @ Min. Angle | Min. Outside Radius @ Min. Angle inch [mm] | Max. Outside Radius @ 90° inch [mm] | US Short Ton/Ft. | Metric Tons/M | kN/M |
|---|---|---|---|---|---|---|---|---|---|---|
| | V-SERIES BLACK (VSB) SPECIFICATIONS | | | | | | | | | |
| 1 | .018 [.45] | .118 [3.0] | 1.8 | 34° | .054 | .125 [3.17] | .175 [4.45] | 38 | 112 | 1100 |
| | .020 [.50] | | 1.8 | | .052 | | | | | |
| | .024 [.60] | | 2 | | .047 | | | | | |
| | .032 [.80] | | 2.5 | | .036 | | | | | |
| | .035 [.90] | | 3.3 | | .031 | | | | | |
| | .040 [1.0] | .153 [3.9] | 4 | | | | | | | |
| | .048 [1.2] | | 5.8 | | | | | | | |
| | .059 [1.5] | .165 [4.2] | 9 | | | | | | | |
| 2 | .075 [1.9] | .335 [8.5] | 7 | 42° | .122 | .216 [5.5] | .354 [9.0] | 57 | 168 | 1650 |
| | .105 [2.7] | .347 [8.8] | 13 | | .112 | | | | | |
| | .118 [3.0] | .366 [9.3] | 19 | | .099 | | | | | |
| | .126 [3.2] | | 22 | | .091 | | | | | |
| | .134 [3.4] | | 25 | 55° | .082 | .276 [7.9] | | | | |
| 2.5 | .079 [2.0] | .732 [18.6] | 4 | 46° | .368 | .447 [11.35] | .500 [12.7] | 84 | 250 | 2450 |
| | .157 [4.0] | | 16 | | .221 | .378 [9.6] | | | | |
| | .197 [5.0] | | 28 | 55° | .146 | .343 [8.71] | | | | |

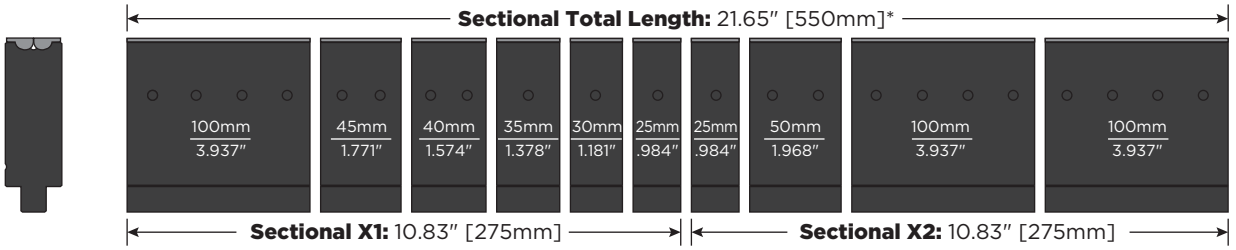
| Model | Shoulder Radius inch [mm] | Desired Angle | Theoretical V inch [mm] | Center Line of Inserts inch [mm] |
|---|---|---|---|---|
| | V-OPENING AND SHOULDER RADIUS DIMENSIONS | | | |
| 1 | .043 [1.1] | 90° | .283 [7.2] | .315 [8] |
| | | 34° | .256 [6.5] | |
| 2 | .050 [1.3] | 90° | .547 [13.9]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




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

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

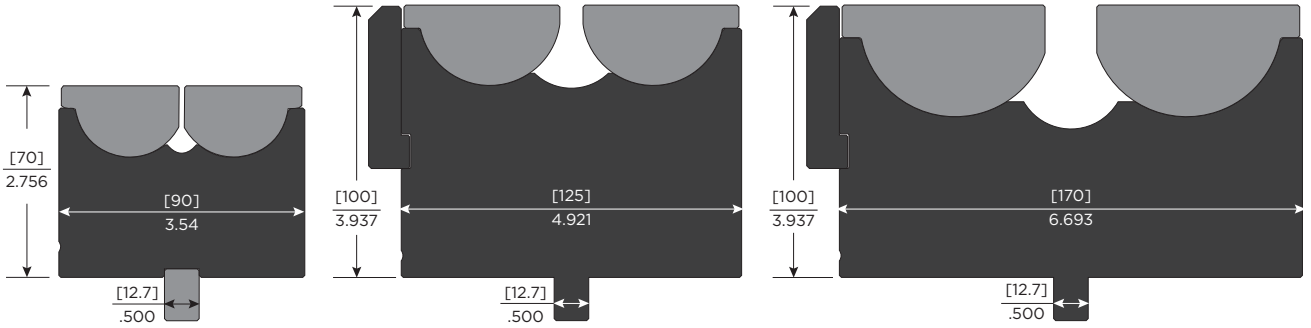
**Solid Length Available:** 19.68" [500mm] and 9.84" [250mm]




*550mm sectional length not available in Model 2.5

DIES

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




**53070.2**
**MODEL 3**

**535100**
**MODEL 3.5**

**540100**
**MODEL 4**

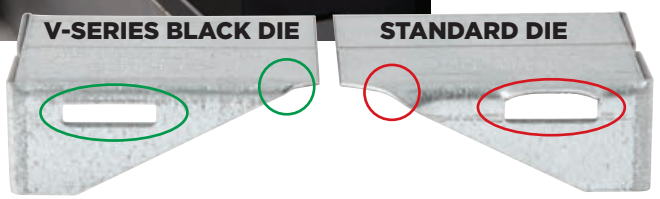
| MODEL 3 | SOLID | | SECTIONALIZED | |
|---|---|---|---|---|
| Length | 3.94" [100mm] | 9.84" [250mm] | 17.91" [455mm] | 10.04" [255mm] |
| Height | 70mm | 70mm | 70mm | 70mm |
| Assembly Part No. | 53070.2-100 | 53070.2-250 | 53070.2-455 | 53070.2x1 |
| Spring | (4 qty.) 980881 | (8 qty.) 980881 | (18 qty.) 980881 | (10 qty.) 987315 |
| Weight | 11 lbs. | 27 lbs. | 47 lbs. | 19 lbs. |
| Insert Part No. | (2) 987163 | (2) 980959 | (2) 987162 & (4) 987163 | (2) 987162 |

| MODEL 3.5 | SOLID | | X1 |
|---|---|---|---|
| Length | 3.94" [100mm] | 9.84" [250mm] | 10.04" [255mm] |
| Height | 100mm | 100mm | 100mm |
| Assembly Part No. | 535100-100 | 535100-250 | 535100x1 |
| Spring | (4 qty.) 990656 | (10 qty.) 990656 | (10 qty.) 990656 |
| Weight | 20 lbs. | 51 lbs. | 52 lbs. |
| Insert Part No. | (2) 990650 | (2) 990651 | (2) 990648 |

| MODEL 4 | SOLID | | X1 |
|---|---|---|---|
| Length | 3.94" [100mm] | 9.84" [250mm] | 10.04" [255mm] |
| Height | 100mm | 100mm | 100mm |
| Assembly Part No. | 540100-100 | 540100-250 | 540100x1 |
| Spring | (4 qty.) 990657 | (10 qty.) 990657 | (10 qty.) 990657 |
| Weight | 25 lbs. | 62 lbs. | 64 lbs. |
| Insert Part No. | (2) 990653 | (2) 990654 | (2) 990652 |

**NOT INTENDED FOR MECHANICAL PRESS BRAKES**
**Control in the press brake stroke is required for consistant results.**

| Model | Material Thickness inch [mm] | Min. Outside Flange inch [mm] | Ton/ Ft. | Min. Angle | Punch Radius Required @ Min. Angle | Min. Outside Radius @ Min. Angle inch [mm] | Max. Outside Radius @ 90° inch [mm] | US Short Ton/Ft. | Metric Tons/M | kN/M |
|---|---|---|---|---|---|---|---|---|---|---|
| V-SERIES BLACK (VSB) SPECIFICATIONS | | | | | | | | | | |
| 3 | .157 [4.0] | .886 [22.5] | 12 | 65° | .078 | .453 [11.5] | .625 [15.9] | 84 | 250 | 2450 |
| | .187 [4.75] | | 26 | | .094 | | | | | |
| | .250 [6.35] | | 30 | | .125 | | | | | |
| 3.5 | .236 [6.0] | 1.476 [37.5] | 15 | 75° | .031 | .267 [6.78] | .945 [24] | 84 | 250 | 2450 |
| | .315 [8.0] | | 29 | | | .346 [8.79] | | | | |
| | .394 [10.0] | | 49 | | | .425 [10.8] | | | | |
| 4 | .236 [6.0] | 2.126 [54] | 9 | 78° | .031 | .267 [6.78] | 1.433 [36.4] | 101 | 300 | 2942 |
| | .315 [8.0] | | 17 | 76° | | .346 [8.79] | | | | |
| | .472 [12.0] | | 44 | 73° | | .503 [12.78] | | | | |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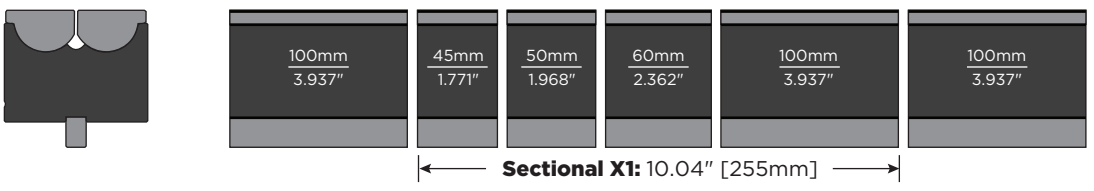
| Model | Shoulder Radius inch [mm] | Desired Angle | Theoretical V inch [mm] | Center Line of Inserts inch [mm] |
|---|---|---|---|---|
| V-OPENING AND SHOULDER RADIUS DIMENSIONS | | | | |
| 3 | .236 [6.0] | 90° | 1.299 [33.0] | 1.496 [38] |
| | | 65° | 1.236 [31.4] | |
| 3.5 | .138 [3.5] | 90° | 2.248 [57.1] | 2.362 [60] |
| | | 75° | 2.226 [56.6] | |
| 4 | .236 [6.0] | 90° | 3.151 [80.0] | 3.346 [85] |
| | | 73° | 3.108 [79.0] | |

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

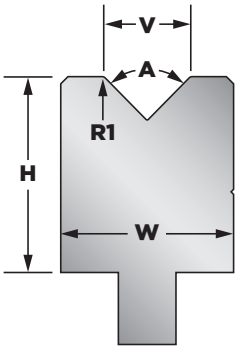
## V-Series Black (VSB) Standard Lengths — Models 3, 3.5 & 4

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

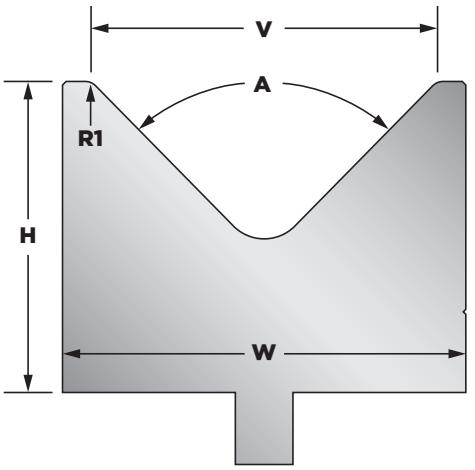


# BLOCK DIES






7589cc



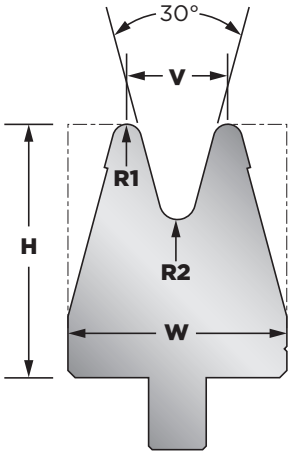

7585cc

| Part No. | A Angle | V V-Opening inch [mm] | H Height inch [mm] | W Width inch [mm] | R1 Sh. Rad. inch [mm] | Weight per foot lbs. |
|---|---|---|---|---|---|---|
| **SERIES 7589cc** | | | | | | |
| **#2 1/4″** | 85° 88° 89° 90° | .250 [6.4] | 1.7 [43.2] | 1.0 [25.4] | .031 [0.8] | 7 |
| **#2 3/8″** | | .375 [9.5] | 1.7 [43.2] | 1.0 [25.4] | | 7 |
| **#2 1/2″** | | .500 [12.7] | 1.7 [43.2] | 1.0 [25.4] | .062 [1.6] | 7 |
| **#2 5/8″** | | .625 [15.9] | 1.7 [43.2] | 1.25 [31.8] | | 9 |
| **#2 3/4″** | | .750 [19.1] | 1.7 [43.2] | 1.5 [38.1] | | 10 |
| **#2 7/8″** | | .875 [22.2] | 1.7 [43.2] | 1.5 [38.1] | | 10 |
| **#4 1″** | | 1.00 [25.4] | 1.7 [43.2] | 1.5 [38.1] | | 10 |
| **#4 1-1/8″** | | 1.125 [28.6] | 1.7 [43.2] | 1.5 [38.1] | | 10 |
| **#4 1-1/4″** | | 1.25 [31.8] | 2.2 [55.9] | 2.0 [50.8] | .094 [2.4] | 15 |
| **SERIES 7585cc** | | | | | | |
| **#4 1-1/2″** | 85° 88° 89° 90° | 1.5 [38.1] | 2.2 [55.9] | 2.0 [50.8] | .125 [3.2] | 15 |
| **#4 2″** | | 2.0 [50.8] | 2.2 [55.9] | 2.5 [63.5] | .188 [4.8] | 17 |
| **#4 2-1/2″** | | 2.5 [63.5] | 2.2 [55.9] | 3.0 [76.2] | .250 [6.4] | 18 |
| **#4 3″** | | 3.0 [76.2] | 2.7 [68.9] | 3.5 [88.9] | | 24 |
| **#4 4″** | | 4.0 [101.6] | 4.25 [108] | 5.0 [127.0] | | 54 |

V openings larger than 4″ are available.

Outside widths shown are bar sizes prior to cleanup.

# ACUTE DIES




**7530cc**

| Part No. | A Angle | V V-Opening inch [mm] | H Height inch [mm] | W Width inch [mm] | R1 Sh. Rad. inch [mm] | R2 V Rad. inch [mm] | Weight per foot lbs. |
|---|---|---|---|---|---|---|---|
| **SERIES 7530cc** | | | | | | | |
| **#20 1/4″** | 30° | .250 [6.4] | 1.7 [43.2] | 1.0 [25.4] | .045 [1.1] | .030 [0.8] | 5 |
| **#20 3/8″** | | .375 [9.5] | 1.7 [43.2] | 1.0 [25.4] | .063 [1.6] | | 5 |
| **#20 1/2″** | | .500 [12.7] | 1.7 [43.2] | 1.0 [25.4] | | .063 [1.6] | 5 |
| **#22 5/8″** | | .625 [15.9] | 2.2 [55.9] | 1.5 [38.1] | | .094 [1.4] | 14 |
| **#22 7/8″** | | .750 [19.1] | 2.2 [55.9] | 2.0 [50.8] | .125 [3.2] | .156 [4.0] | 14 |
| **#22 1″** | | 1.00 [25.4] | 2.7 [68.6] | 2.0 [50.8] | | .188 [4.8] | 14 |
| **#22 1-1/4″** | | 1.25 [31.75] | 2.7 [68.6] | 2.5 [63.5] | .156 [4.0] | | 19 |
| **#22 1-1/2″** | | 1.5 [38.1] | 2.7 [68.6] | 3.0 [76.2] | .250 [6.4] | .250 [6.4] | 27 |

V openings larger than 1.50″ are available.

Dotted lines indicate the Heavy Duty concept — available on all acute dies.



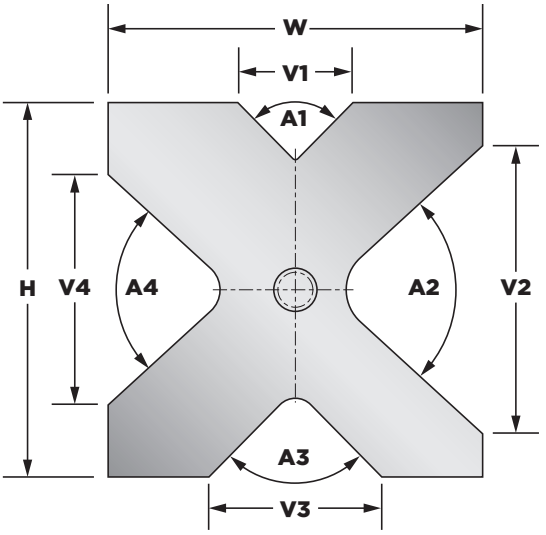
Outside widths shown are bar sizes prior to cleanup.

# 4-WAY DIES

For quick die changes where multiple bends are required. All dies are supplied with tapped holes on each end for lifting. **HOLDER REQUIRED** or alternative method of securing die should be considered.

**IMPORTANT:** When ordering, indicate if you are matching an existing 4-way die holder to ensure fitment.

Special angles and configurations are made to order. Provide us with your dimensions and we can make it.

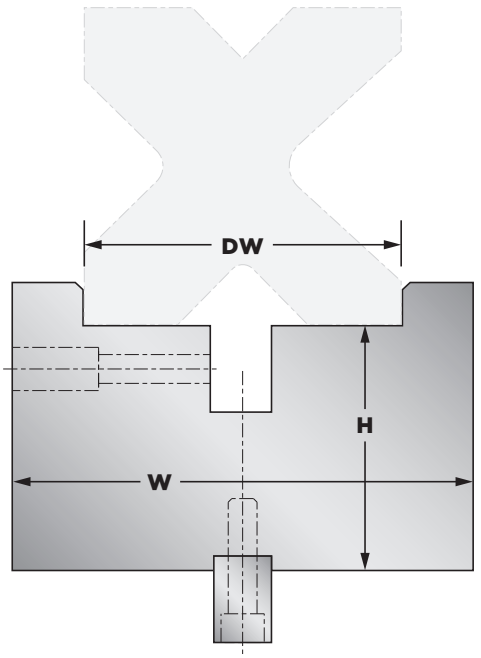



| Part No. | Angles | | | | V-Openings | | | | H Height | W Width | Weight per foot lbs. |
|---|---|---|---|---|---|---|---|---|---|---|---|
| | A1 | A2 | A3 | A4 | V1 | V2 | V3 | V4 | | | |
| **SERIES 754wdc** | | | | | | | | | | | |
| **#4A4** | 89° | 85° | 89° | 89° | 3/4″ | 1-1/2″ | 7/8″ | 1-1/8″ | 2-1/4″ | 2-1/4″ | 13 |
| **#4B4** | 89° | 85° | 89° | 85° | 7/8″ | 2″ | 1-1/8″ | 1-1/2″ | 2-3/4″ | 2-3/4″ | 19 |
| **#4C4** | 89° | 85° | 85° | 85° | 1″ | 2-1/2″ | 1-1/2″ | 2″ | 3-1/4″ | 3-1/4″ | 24 |
| **#4D4** | 89° | 85° | 85° | 85° | 1-1/8″ | 3″ | 1-1/2″ | 2″ | 3-5/8″ | 3-5/8″ | 29 |
| **#4E4** | 85° | 85° | 85° | 85° | 1-1/2″ | 4″ | 2″ | 3″ | 5-1/4″ | 5-1/4″ | 56 |

# 4-WAY DIE ADAPTERS

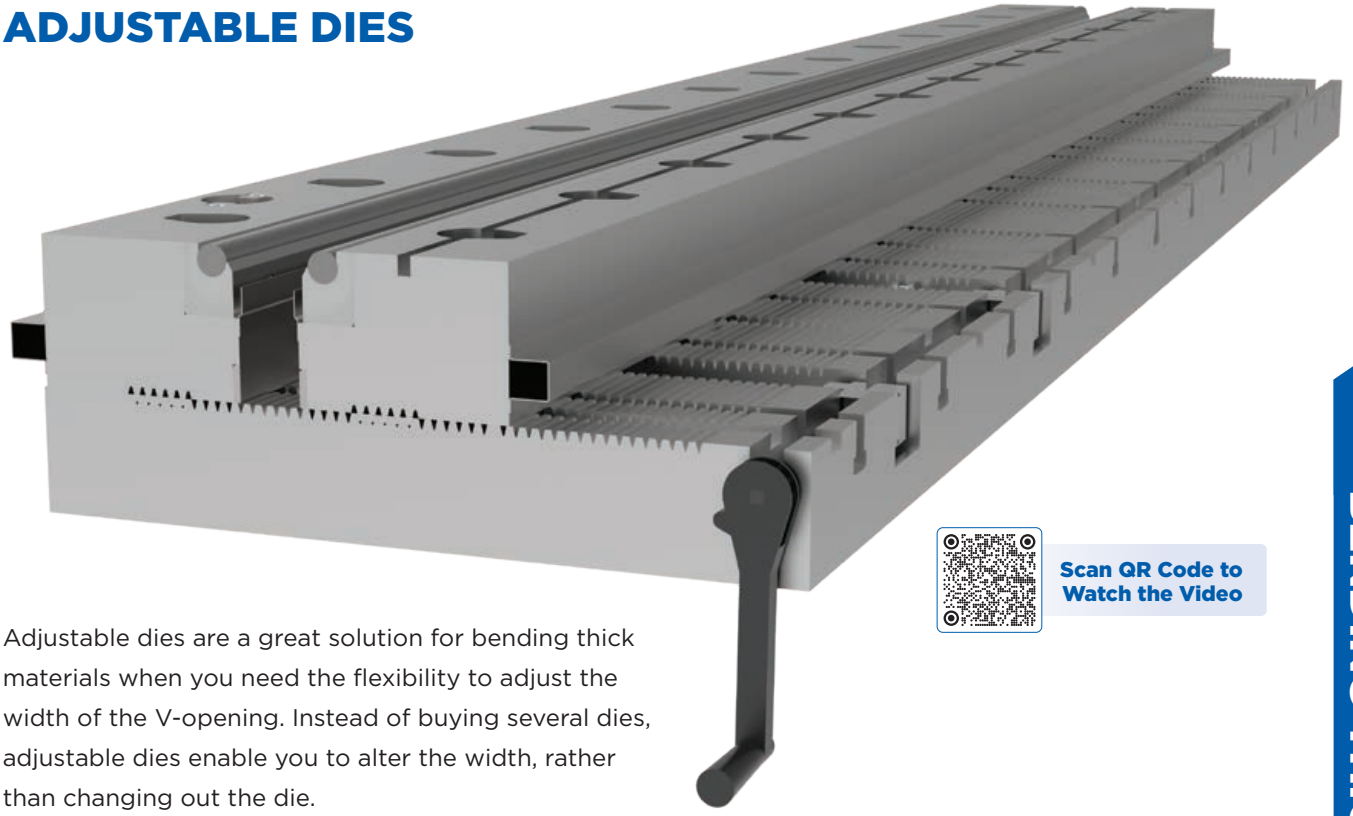
| Part No. | H Height | W Width | DW Die Opening | Weight per foot |
|---|---|---|---|---|
| **SERIES 754whc — ADAPTERS** | | | | |
| **4A** | 2″ | 3-1/2″ | 2.28 | 35 lbs. |
| **4B** | 2″ | 4″ | 2.78 | 40 lbs. |
| **4C** | 2-1/2″ | 4-1/2″ | 3.28 | 50 lbs. |
| **4D** | 2-1/2″ | 5″ | 3.65 | 50 lbs. |
| **4E** | 2-1/2″ | 6-1/2″ | 5.28 | 70 lbs. |

Screw holes in 4-way adapters are 3/8″ 16 on 12″ centers.
Specify if die tang is required.




Outside widths shown are bar sizes prior to cleanup.

# ADJUSTABLE DIES



Scan QR Code to Watch the Video

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

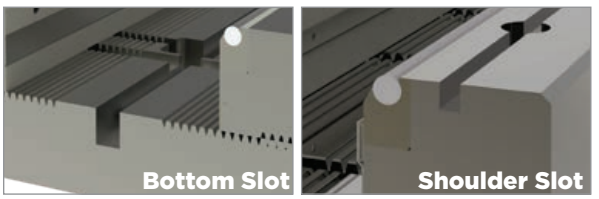
**Adjustable Die Features**

- Riding on spring-loaded ball bearings, openings are easily adjusted by one operator
- Available openings range from 1 to 26 inches and can be adjusted in 1-inch increments
- Capable of withstanding tonnage of up to 400 tons per foot, allowing easy thick material bending
- Induction hardened and hard chrome rollers help reduce required tonnage by as much as 20%
- Chrome rollers can be replaced at your facility

**Adjustable Die Options**

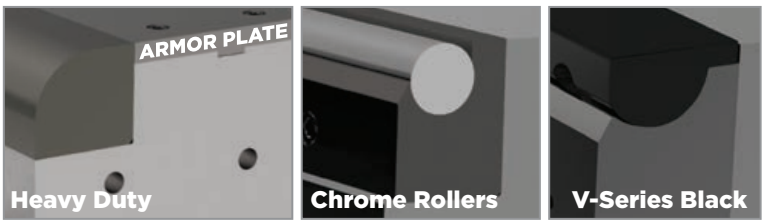
- Die assembly can be configured to remain on the press permanently and function as a standard die holder
- Cover bellows are available to keep the grooves that are used to adjust the dies free from dirt and dust
- Available clamping options for side blocks include manual and automated release and/or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

**Die Holder Slots**




**Opening Adjustments**

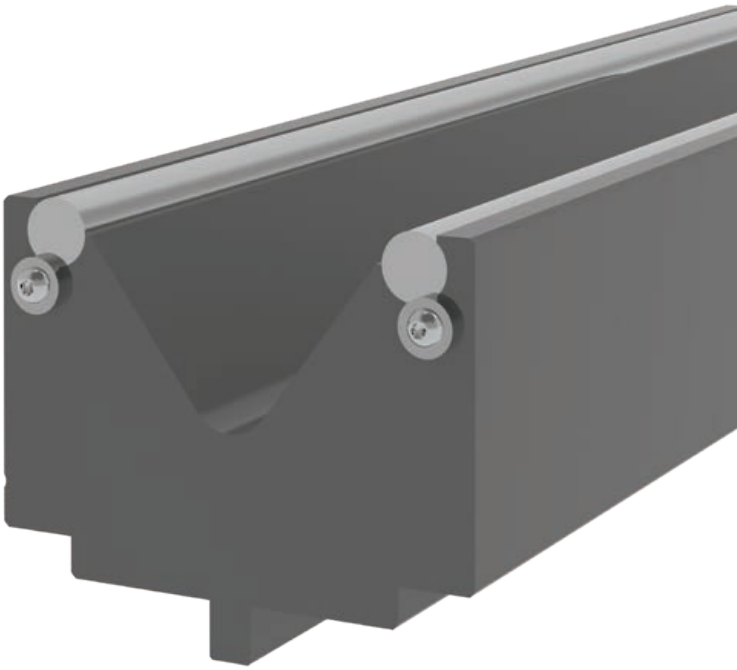

**Shoulder Inserts**



# REPLACEABLE SHOULDER DIES

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

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



**Scan QR Code for More Thick Material Solutions**

# DOVETAIL HOLDER AND RADIUS

**Lighten Your Load with Two-Piece Punches**

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

**Replaceable Radius Punch Highlights**

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

**Dovetail** **T Style**

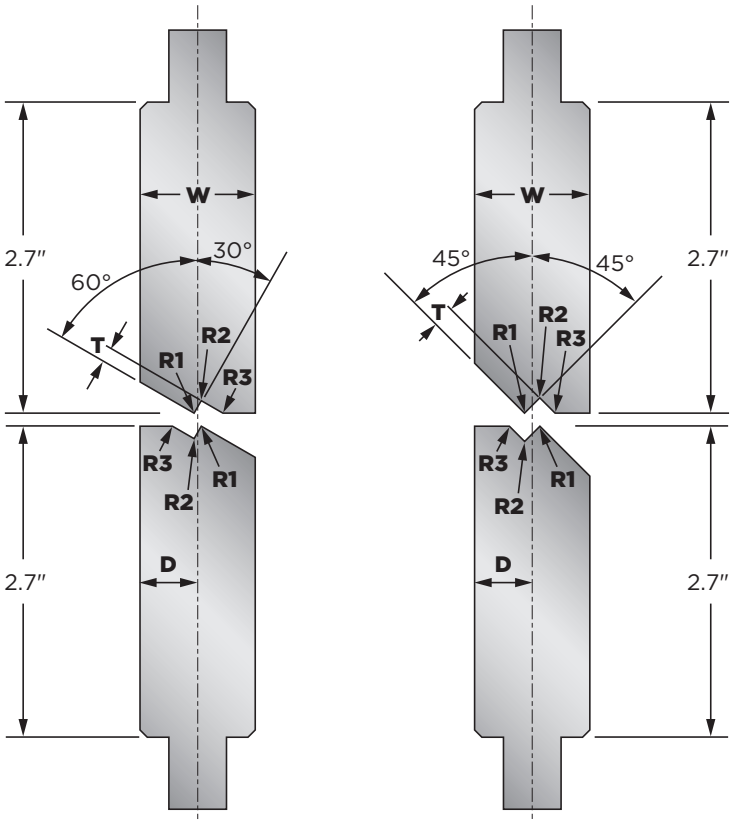
**Details**

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

**Scan QR Code to Watch the Video**

# OFFSET PUNCH & DIE SETS

For producing two 90° bends simultaneously.




**#10**
**30° / 60°**

**#12**
**Balanced**
**45° / 45°**

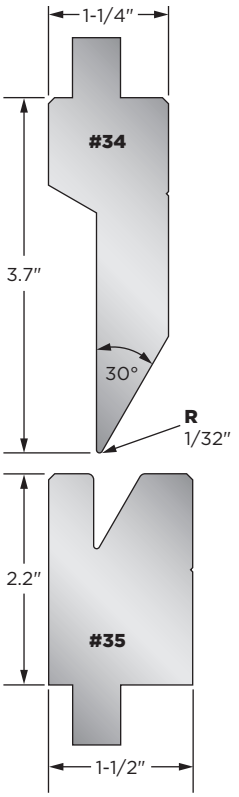
| Set Part No. | Angle | T Offset inch [mm] | W Width inch [mm] | Effective V inch [mm] | R1/R2 Radius inch [mm] | R3 Shoulder Radius inch [mm] | D Centerline inch [mm] | Weight per foot lbs. |
|---|---|---|---|---|---|---|---|---|
| **SERIES 731cc** | | | | | | | | |
| **#10 3/16″** | 30°/60° | 3/16 [4.8] | 1.0 [25.4] | .133 [3.4] | 1/64 [0.4] | 1/64 [0.4] | 1/2 [12.7] | 20 |
| **#12 1/4″** | 45°/45° | 1/4 [6.4] | 1.0 [25.4] | .354 [9] | | | | |
| **#12 5/16″** | | 5/16 [8] | 1.0 [25.4] | .441 [11.2] | | | | |
| **#12 3/8″** | | 3/8 [9.5] | 1.25 [31.8] | .530 [13.5] | 1/32 [0.8] | 1/32 [0.8] | 5/8 [15.9] | 26 |
| **#12 1/2″** | | 1/2 [12.7] | 1.25 [31.8] | .707 [18] | | | | |
| **#12 5/8″** | | 5/8 [15.9] | 1.5 [38.1] | .884 [22.5] | | | 3/4 [19.1] | 32 |
| **#12 3/4″** | | 3/4 [19.1] | 2 [50.8] | 1.061 [26.9] | | | 1.0 [25.4] | 39 |
| **#12 7/8″** | | 7/8 [22.2] | 2 [50.8] | 1.237 [31.4] | | | | |
| **#12 1″** | | 1 [25.4] | 2 [50.8] | 1.414 [35.9] | | | | |

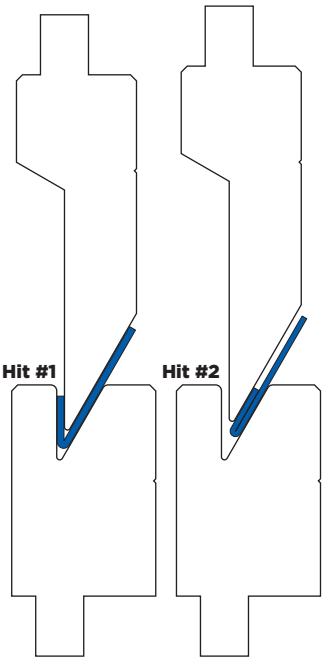
Outside widths shown are bar sizes prior to cleanup.

# HEMMING PUNCH & DIE SETS

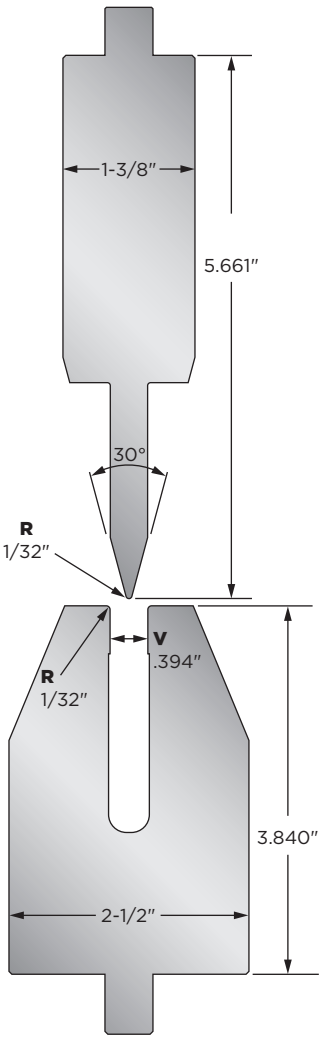


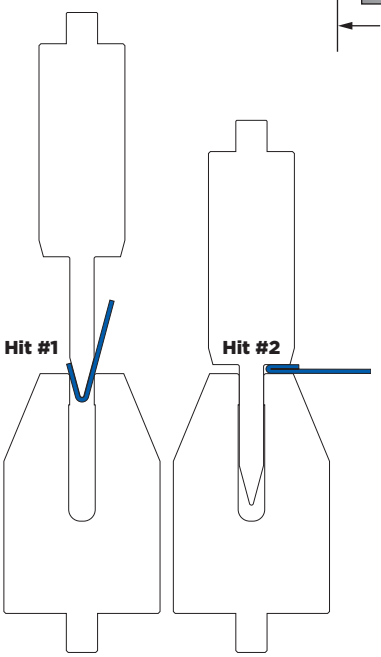
For bending and crimping the edge of a sheet 18 gauge or lighter. (For heavier material, contact our tooling technicians.) Two strokes produce a flattened hem.




Note: Hit #2 does not penetrate as far as Hit #1 since there are two material thicknesses.

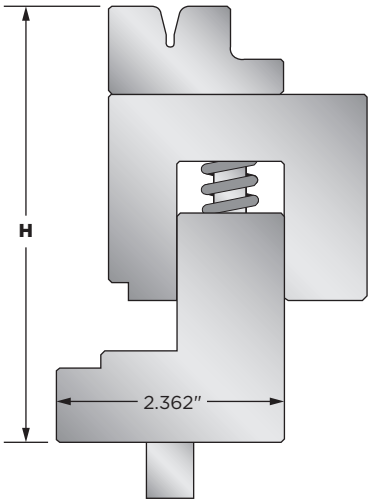


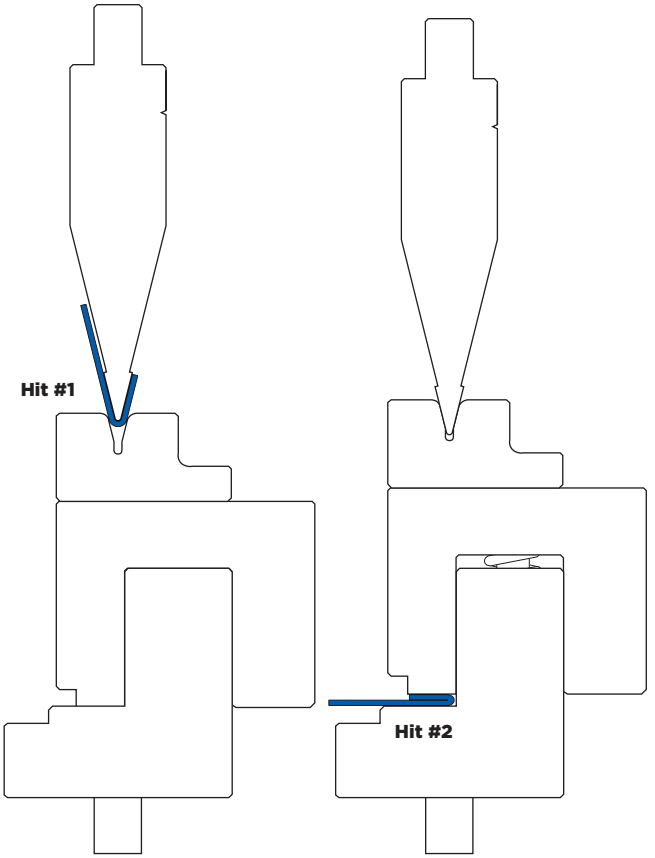




| Set Part No. | Description | Tonnage Capacity per foot | Weight per foot lbs. |
|---|---|---|---|
| **5.75″ TWO STAGE HEMMING PUNCH & DIE SET** | | | |
| **51919** | Punch | 25 | 18 |
| **53594** | Die | 21 | 28 |

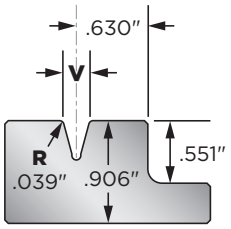
Outside widths shown are bar sizes prior to cleanup.

# HEMMING AND REPLACEMENT V-BLOCKS

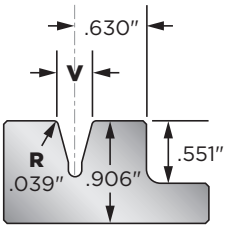


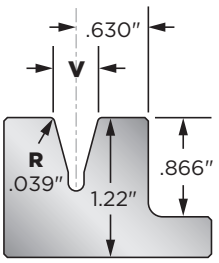

| Part No. | V inch [mm] | H Height inch [mm] | Tonnage Capacity per foot | Weight per foot lbs. |
|---|---|---|---|---|
| **TWO STAGE HEMMING DIE** | | | | |
| **42601c** | .236 [6.0] | 4.587 [116.5] | 20 | 31 |
| **42602c** | .315 [8.0] | 4.587 [116.5] | | |
| **42603c** | .394 [10.0] | 4.902 [124.5] | | 33 |
| **42608c** | .394 [10.0] | 5.402 [137.2] | 25 | 38 |



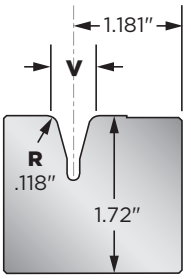

**43522**




**43523**




**43524**



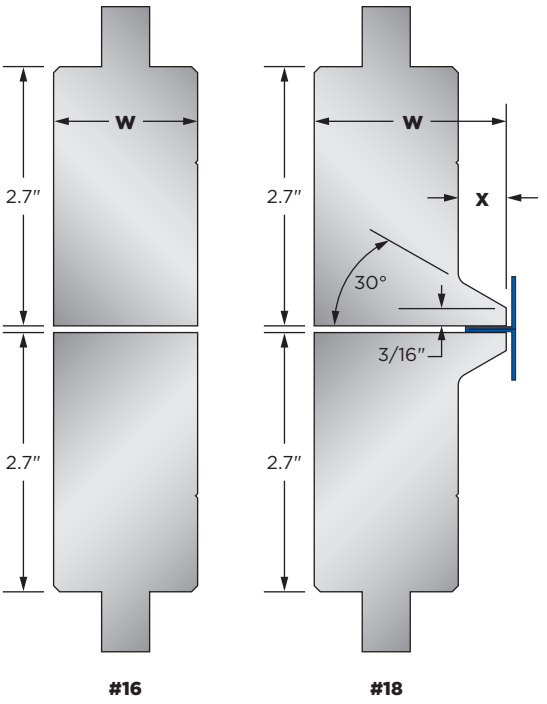

**43528**

| Part No. | V V-Opening inch [mm] | H Height inch [mm] | R Sh. Radius inch [mm] | Tonnage Capacity per foot | Weight per foot lbs. |
|---|---|---|---|---|---|
| **HEMMING REPLACEMENT V-BLOCKS** | | | | | |
| **43522** | .236 [6.0] | .906 [23.0] | .039 [1.0] | 20 | 4.4 |
| **43523** | .315 [6.0] | | | | |
| **43524** | .394 [10.0] | 1.22 [31.0] | | | 5.5 |
| **43528** | .394 [10.0] | 1.72 [43.7] | .118 [3.0] | 25 | 11 |

# FLATTENING DIES

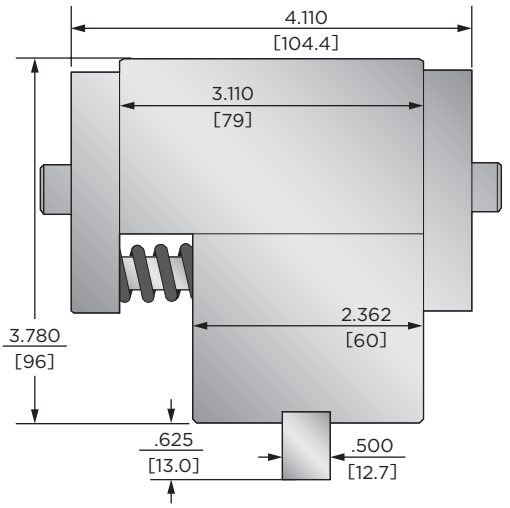


| Set Part No. | H Height inch [mm] | W Width inch [mm] | X inch [mm] | Weight per foot lbs. |
|---|---|---|---|---|
| **SERIES 705cc** | | | | |
| **#16 1-1/2"** | 2.7 [68.58] | 1.5 [38.1] | — | 29 |
| **#16 2"** | | 2 [50.8] | — | 39 |
| **#16 2-1/2"** | | 2.5 [63.5] | — | 51 |
| **#18 2"** | | 1.875 [47.63] | 1/2 [12.7] | 29 |
| **#18 2-1/2"** | | 2.375 [60.33] | 3/4 [19.05] | 27 |



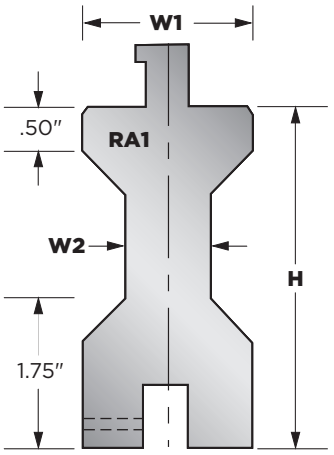

**#16** **#18**

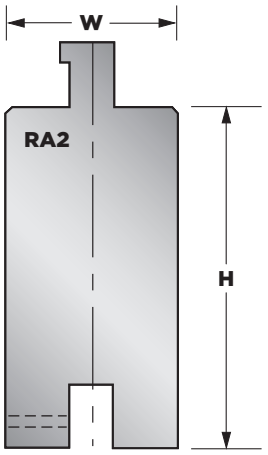
| Part No. | H Height inch [mm] | Max. Ton ft. [m] | Weight per foot lbs. |
|---|---|---|---|
| **THRUST ABSORBING FLATTENING DIE** | | | |
| **42311c** | 3.78 [96] | 30 [100] | 43.08 |

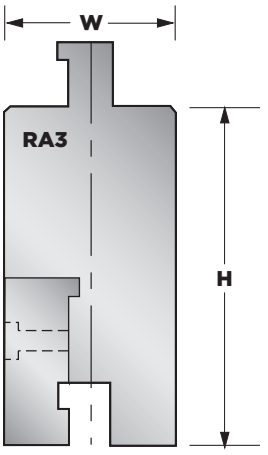



Outside widths shown are bar sizes prior to cleanup.

# PUNCH HOLDERS




| Part No. | Width | | H Height | | |
|---|---|---|---|---|---|
| | W1 | W2 | | | |
| RA1 | 1-1/2″ | .62″ | 3-5/8″ | 4-1/8″ | 5-1/8″ |
| | 2″ | 1″ | | | |
| | 2-1/2″ | 1-1/4″ | | | |

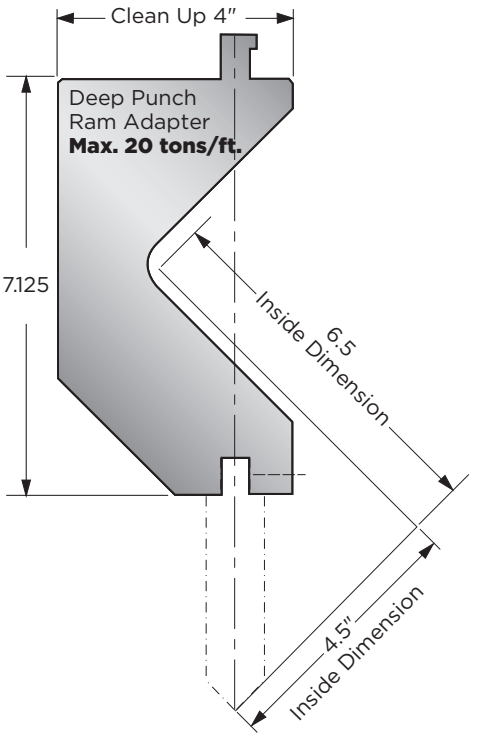
**NOTE:** Any Punch Holder with a width of 2″ or greater can be made to accept a Hook/Safety Tang.

Outside widths shown are bar sizes prior to cleanup.

| Part No. | W Width | H Height | | |
|---|---|---|---|---|
| RA2 | 1-1/2″ | 3-5/8″ | 4-1/8″ | 5-1/8″ |
| | 2″ | | | |
| | 2-1/2″ | | | |
| | 3″ | 4-1/8″ | 5-1/8″ | |
| RA3 | 2″ | 3-5/8″ | 4-1/8″ | 5-1/8″ |
| | 2-1/2″ | | | |
| | 3″ | 3-3/4″ | 4-1/8″ | |

**Extra High Gooseneck Punch Holders** can be manufactured to accept insert style punches — this allows for a larger inside dimension to be formed.

Almost any size punch or die adapter can be made. Contact our tooling technicians for price and lead time.



# EXPRESS CROWNING® SYSTEM

Scan QR Code for More Crowning

The Express Crowning® system is the precise and consistent option for controlling deflection in your press brake.

The Express Crowning system crowns the beam overall and in smaller, micro-crown adjustments for fine tuning. It provides a new bending surface for your brake and the ability to adjust the height so that your upper and lower beam are parallel.

Like all Wilson Tool products, the Express Crowning system is built to last. Its body is hardened to 28–32 HRC, which makes it substantially tougher than the competition.

**The system offers two choices of control for die securing:**

- Set screws every inch on center for manual tightening
- Hydraulic control with 8mm diameter pins every 0.837″ [21.25mm]

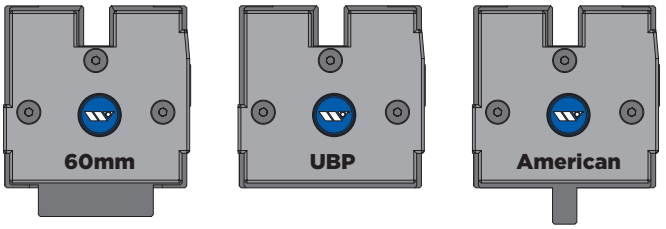
**And, two choices for crowning power:**

- Easily removable **HAND CRANK** with digital display in imperial or metric
- **ELECTRIC MOTOR** to crown the beam using the machine's CNC control

**Key Features**

- OEM or aftermarket mounting
- Micro crowning every 200mm
- Adjustable 0–0.130″ [0–3.3mm]


**AVAILABLE FOR HEAVY DUTY APPLICATIONS!**




**M/H = ACTUATION**
M = Manual
H = Hydraulic
90 = 90mm

**XX = MOUNT STYLE**
UB = UBP
AM = American
60 = 60mm
90 = 90mm

**X = ADJUST**
L = Crowning Left
R = Crowning Right

| LENGTH | PART NO. |
|---|---|
| 2380mm / 94″ / 7.8 ft. | AD**M/H**2380-20**XX**C**X**WIL |
| 2423mm / 95″ / 7.9 ft. | AD**M/H**2423-20**XX**C**X**WIL |
| 2550mm / 100″ / 8.4 ft. | AD**M/H**2550-20**XX**C**X**WIL |
| 2720mm / 107″ / 8.9 ft. | AD**M/H**2720-20**XX**C**X**WIL |
| 3038mm / 120″ / 10.0 ft. | AD**M/H**3038-20**XX**C**X**WIL |
| 3060mm / 120″ / 10.0 ft. | AD**M/H**3060-20**XX**C**X**WIL |
| 3230mm / 127″ / 10.6 ft. | AD**M/H**3230-20**XX**C**X**WIL |
| 3570mm / 141″ / 11.7 ft. | AD**M/H**3570-20**XX**C**X**WIL |
| 3655mm / 144″ / 12.0 ft. | AD**M/H**3655-20**XX**C**X**WIL |
| 4080mm / 161″ / 13.4 ft. | AD**M/H**4080-20**XX**C**X**WIL |
| 4250mm / 167″ / 13.9 ft. | AD**M/H**4250-20**XX**C**X**WIL |
| 4590mm / 181″ / 15.1 ft. | AD**M/H**4590-20**XX**C**X**WIL |

Additional lengths available upon request. Lengths shown indicate the actual clamping surface. Add the length of the end cap to get the overall length.

**Actuation Options**

Hand crank drive, electric motor, mount kit sold separately from beam.

**Hand Crank Drive**

| PART NO. |
|---|
| 987341 |

**Electric Drive**

- Power cord included
- Specify voltage

| VOLTAGE | PART NO. |
|---|---|
| **3-PHASE 60HZ** | |
| 230V | CNC-323060 |
| 460V | CNC-346060 |
| **3-PHASE 50HZ** | |
| 230V | CNC-323050 |
| 400V | CNC-340050 |

# SPECIAL TOOLING


EUROPEAN


WT-STYLE


AMERICAN

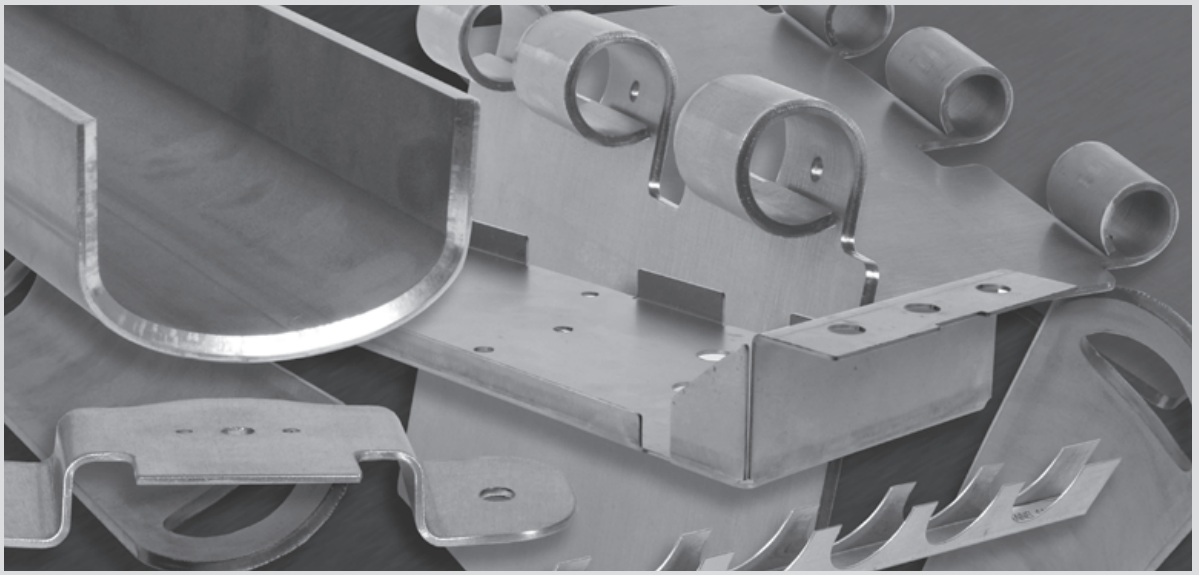

RFA-STYLE

## CHALLENGE OUR "NEVER SAY NO" ATTITUDE

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

**Quality Materials — Quality Control**
We combine premium materials with specialized manufacturing systems to produce extraordinary products that outlast the competition.

**Quick Quotes — Short Lead Times**
With the fastest lead times in the industry, our tool might ship before the competition even provides a quote.



# BRAKE PARTNER®

**Make Punch Press Forms in the Press Brake**

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

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




Scan QR Code to Watch the Video

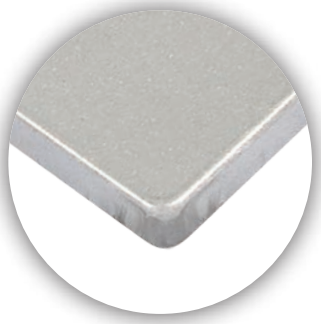
**Enjoy These Cost Saving Benefits**

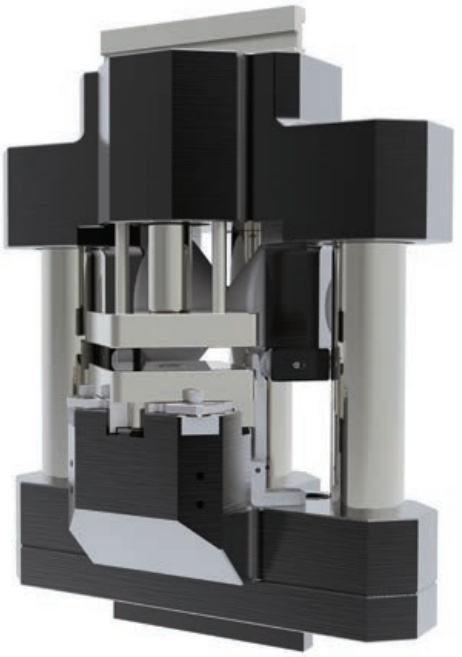
- Reduce press brake special tooling costs
- Punch press tooling has shorter lead times
- Put your existing press brakes to work on applications that were previously impossible on a punching machine
- Reduce outsourcing of punching applications
- Streamline equipment usage and create more flexibility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

# CORNER FORMER

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

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







## 3 SIMPLE STEPS TO A FINISHED CORNER

**Step 1: Bend with Flare**

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

**Step 2: Corner Former**

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

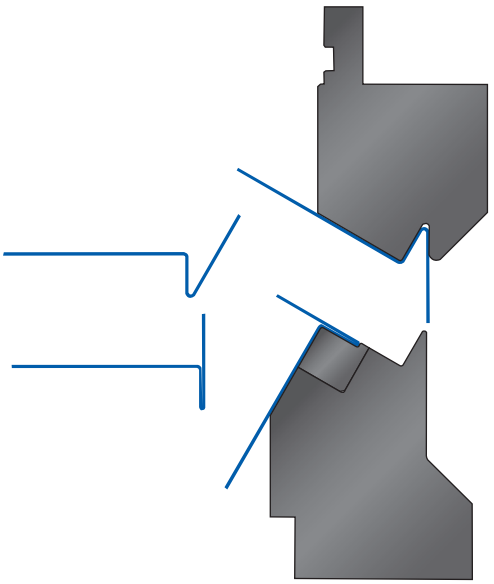
**Step 3: Corner Cropper/Trim**

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

**Scan QR Code to Watch the Video**

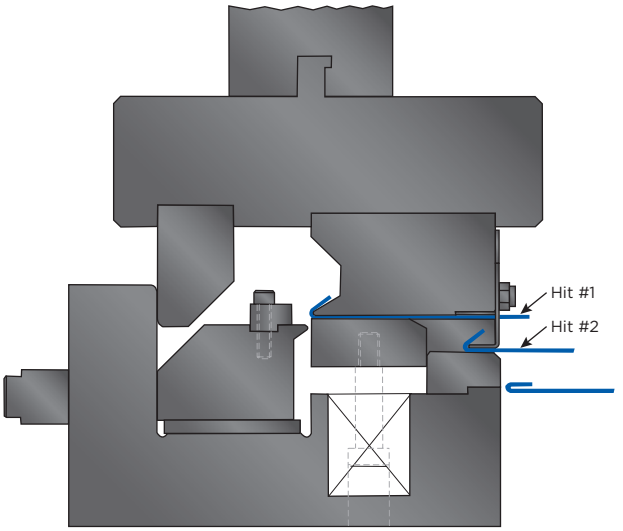

**Scan QR Code to See How Much You Can Save**

# CUSTOM HEMMING

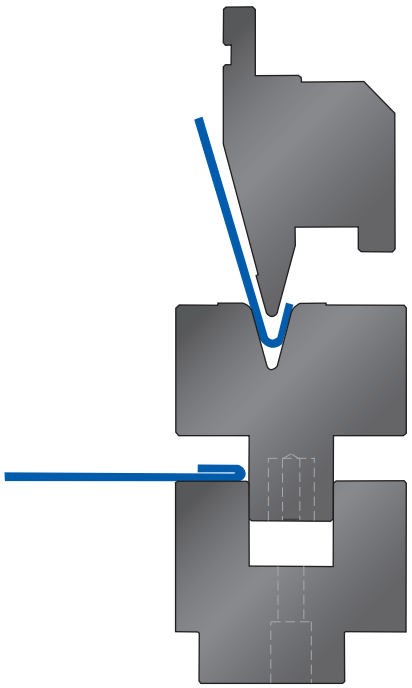


**AH1 — ANGLE HEM**

Typically used to form seams in excess of 1/2 inch.

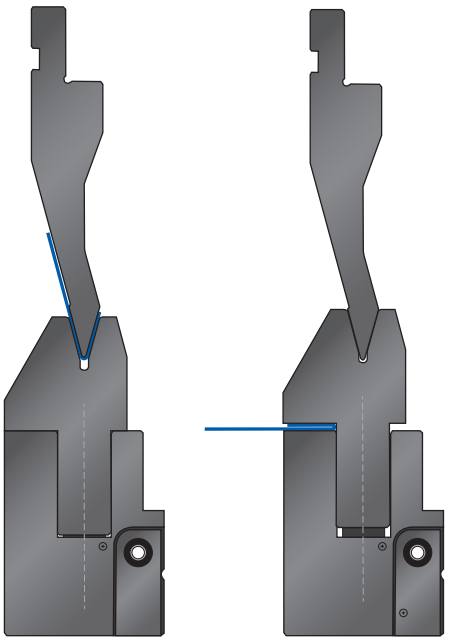



**FSH1 — FLAT SHEET HEM**



**HDH1 — HEAVY DUTY HEM**

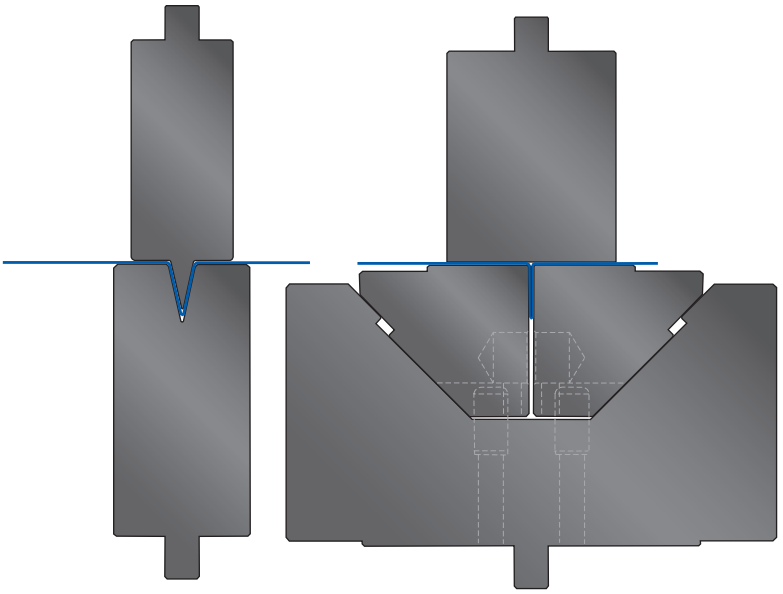
Heavy duty hemming for thick gauge applications.



**PH1 — PNEUMATIC HEM**

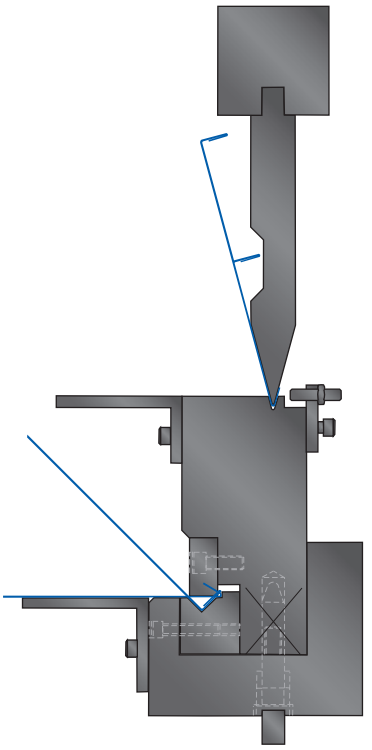
This tool set introduces pneumatic cylinders to rapidly open and close the pre-form insert. This set removes the inconsistency associated with pre-forming or acute bending on a spring actuated insert.

# CUSTOM HEMMING

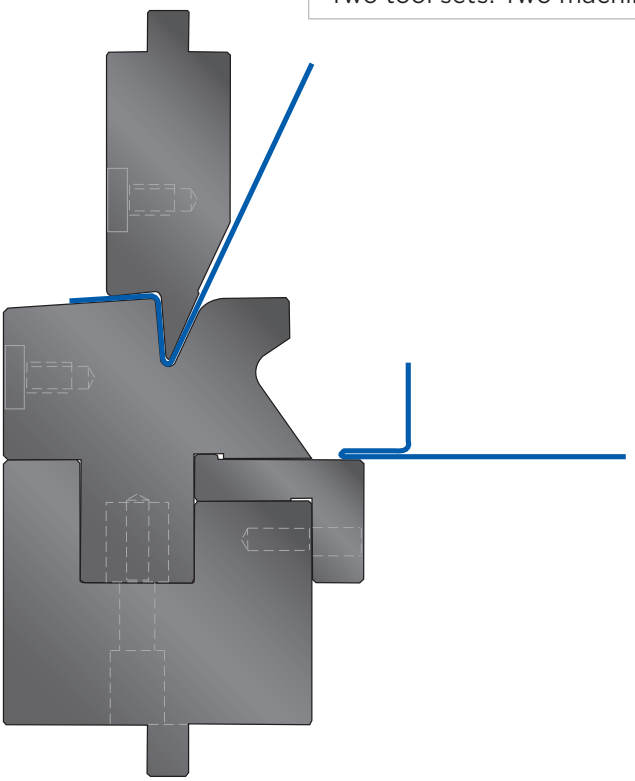


**SH1 — SEAM HEM**

Two tool sets. Two machine strokes



**SSH2 — STANDING SEAM HEM**



**SSH1 — STANDING SEAM HEM**

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

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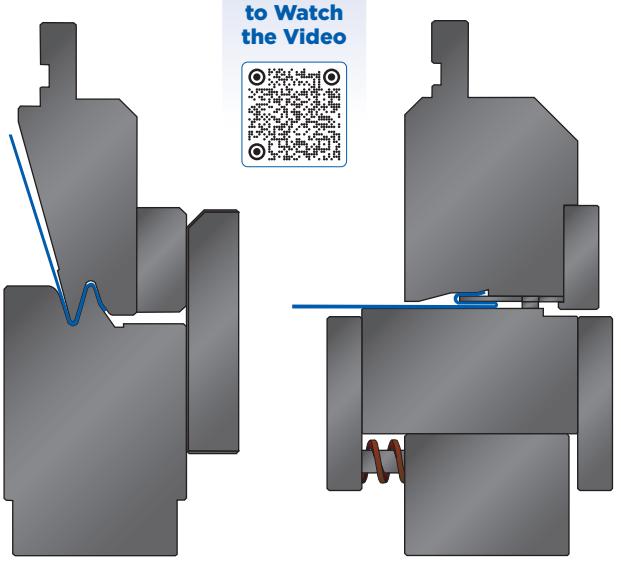
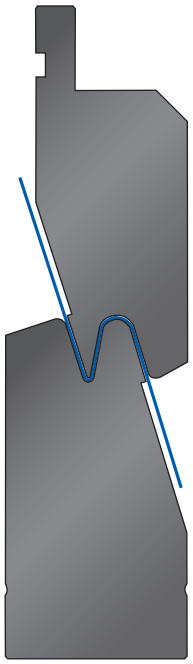


**ZH1 — Z HEM**

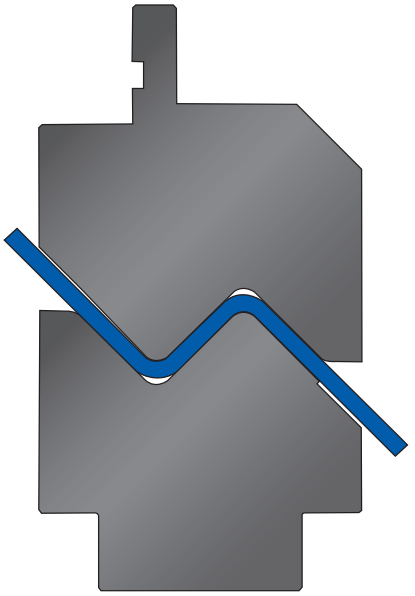
Creates a Z-hem or a Clip hem. Shim can be built in to maintain a gap in the hem. Two tool sets. Two machine strokes.

# OFFSET TOOLS





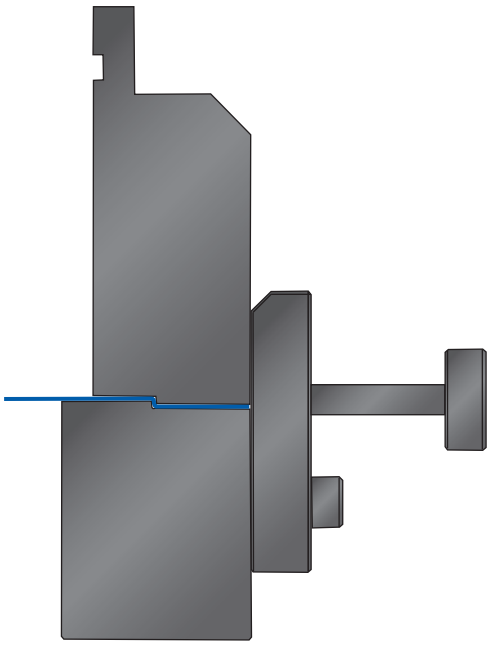
Scan QR Code to Watch the Video



**LO1 — LARGE OFFSET**

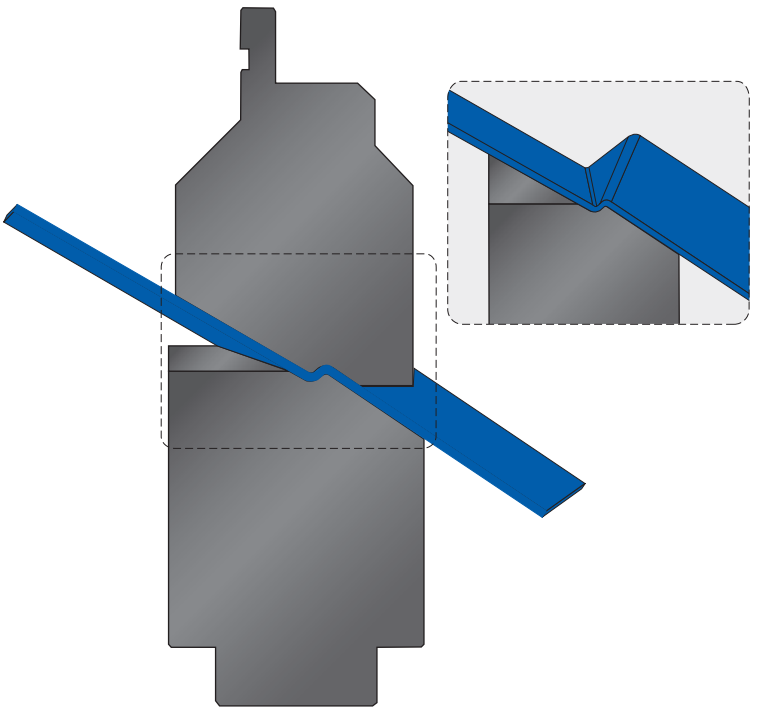
Used for heavy gauge, large offset bending.

**AO1 — ANGLED OFFSET**



**HO1 — HORIZONTAL OFFSET**

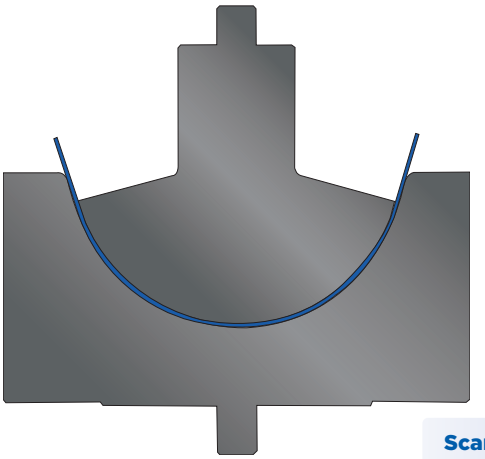
For offsets that are approximately one material thickness. Prevents material whip up. Thrust plates and adjustable back gauging are provided.



**NPO1 — NON PARALLEL OFFSET**

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

# LARGE RADII



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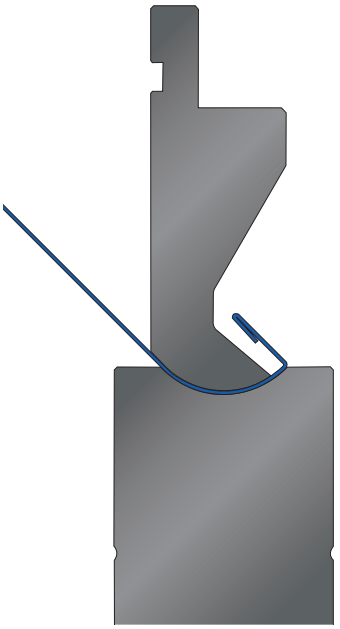
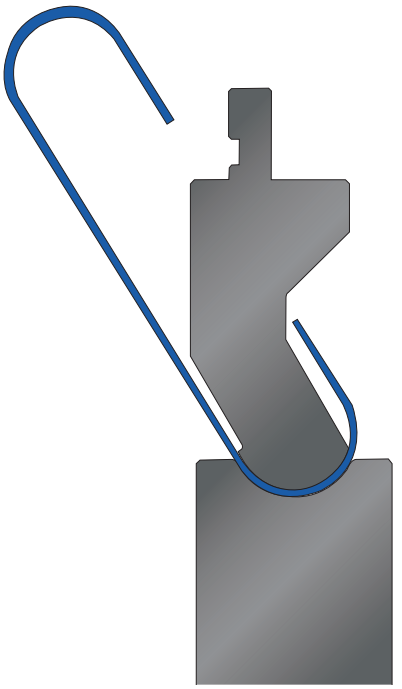
**LR1 — LARGE RADIUS**

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



**LR2 — MULTI-HIT RADIUS**

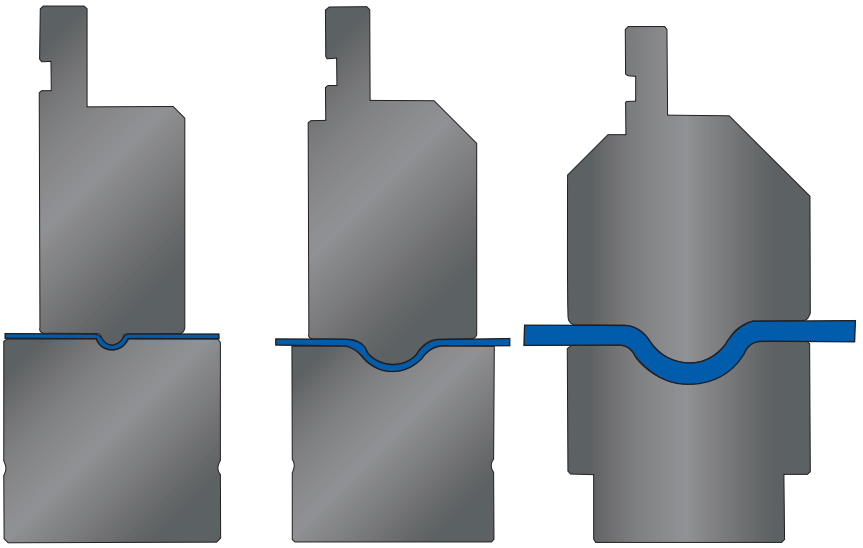
Used when a full radius is required before the flange. The solution may require multiple strokes.



**LR3 — MULTI-HIT RADIUS**

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

## STRENGTHENING RIB



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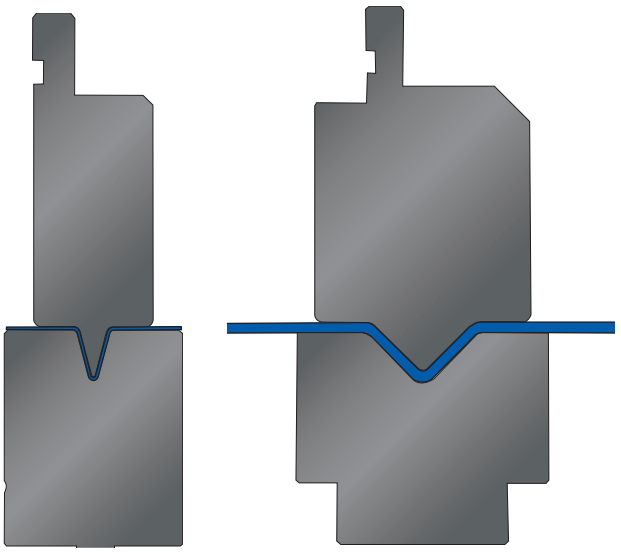
**SR1 — STRENGTHENING RIB**

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

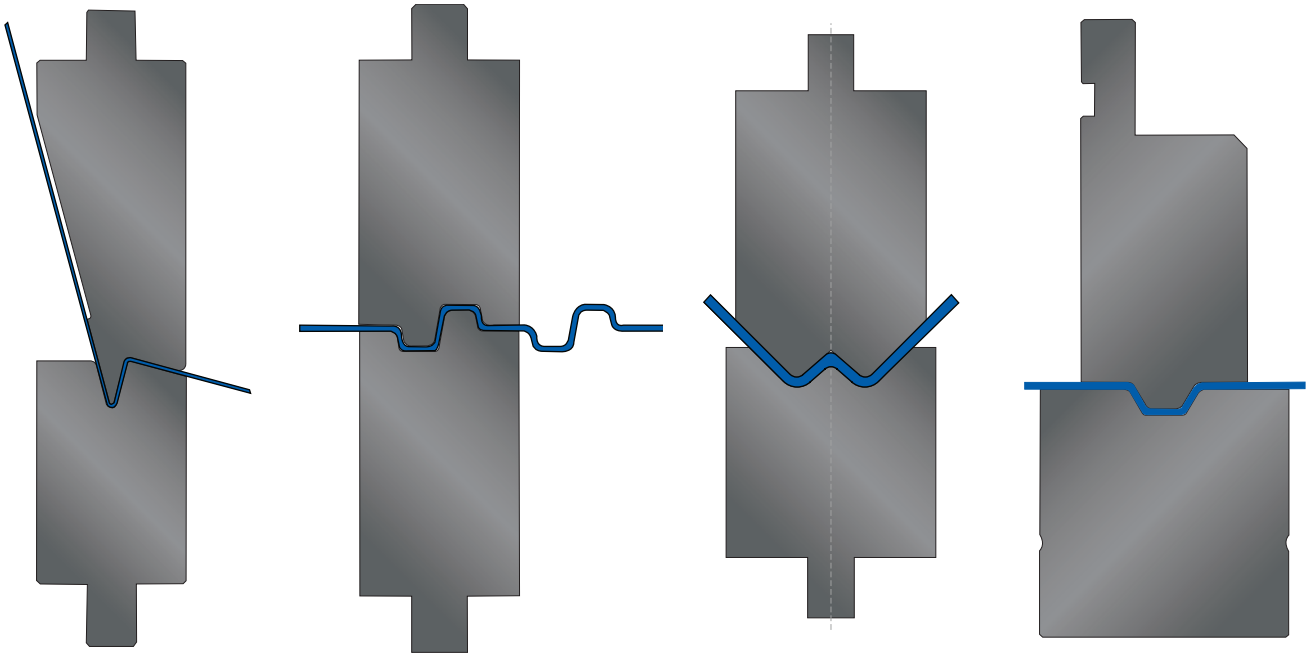
## V-RIB



**VR1 — V RIB**

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

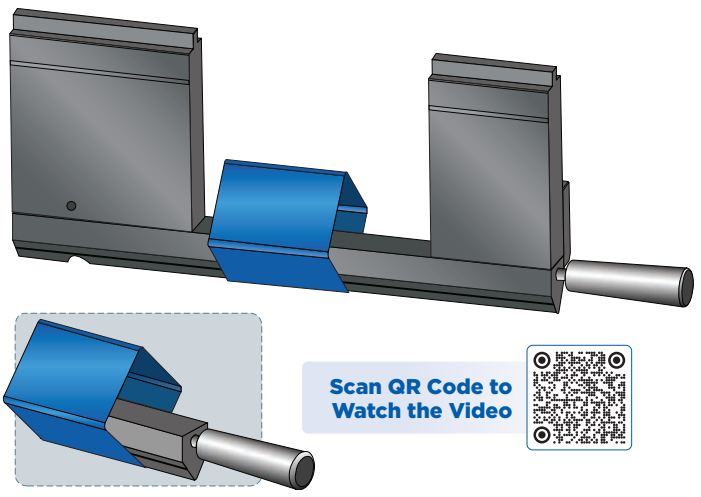
# FORMING



| FM1 — FORMING | FM2 — FORMING | FM3 — FORMING | OH1 — OPEN HAT |
|---|---|---|---|

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





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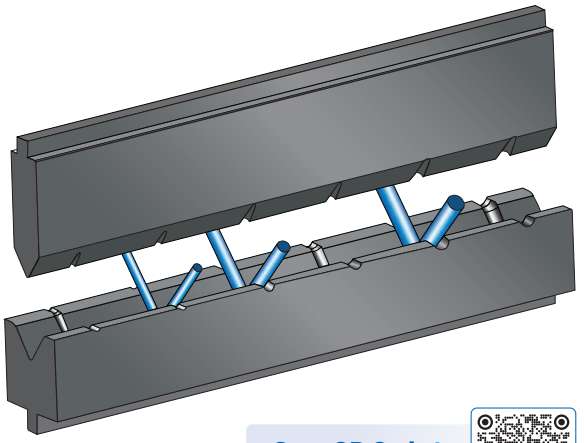
**W1 — WINDOW**

Used when minimum return flange clearance is required.



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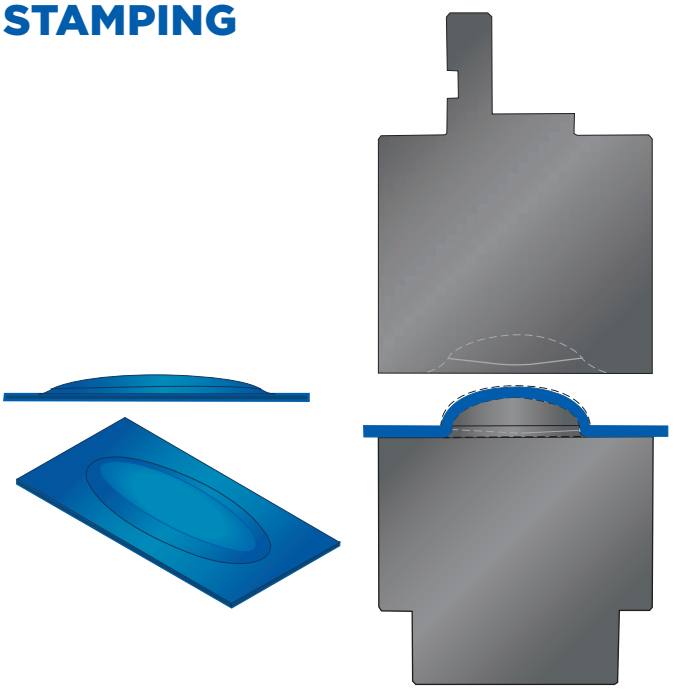
**RB1 — ROD BENDING**

Provides nesting for the rod during the forming process.

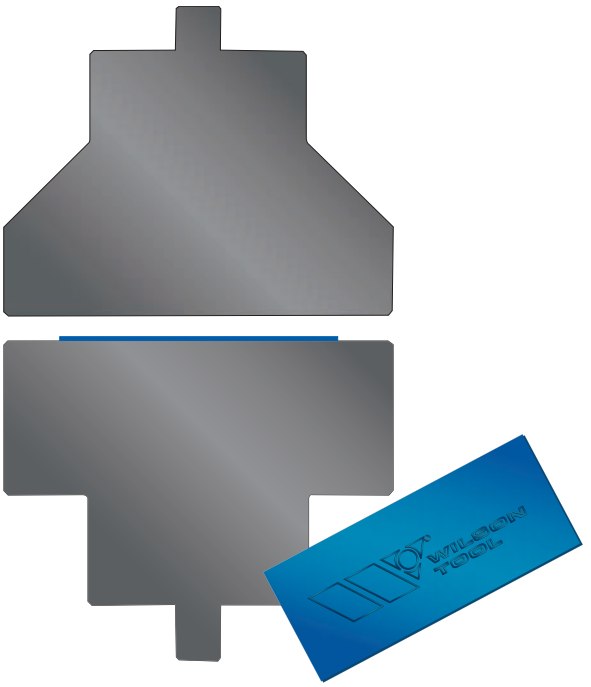
# STAMPING



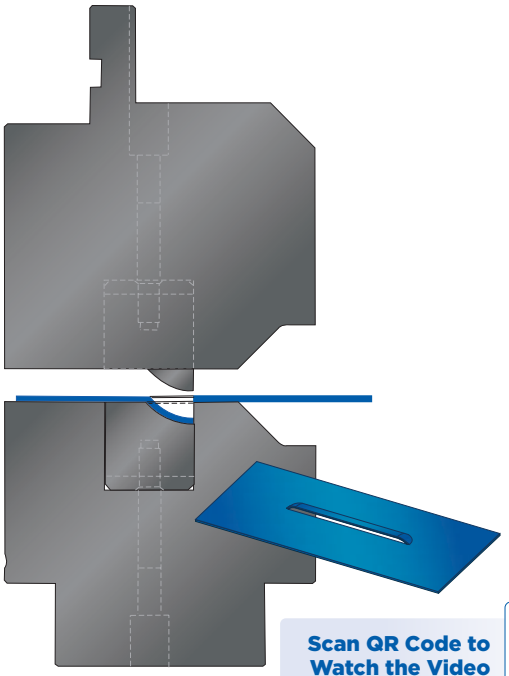


## EM1 — EMBOSS

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



## LG1 — LOGO



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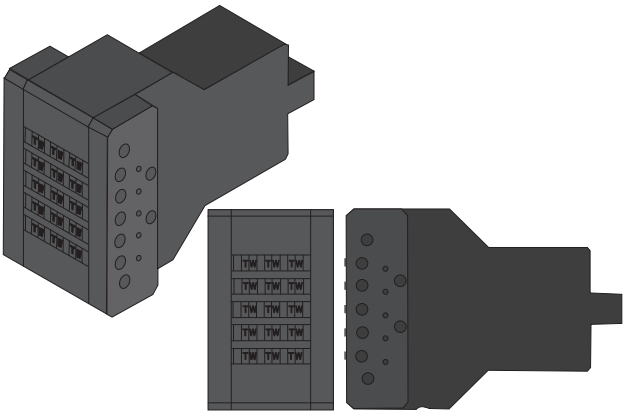
## LL1 — LOUVER

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

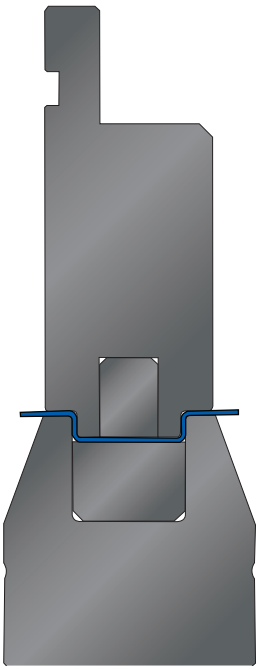


## LS1 — LETTER STAMP

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

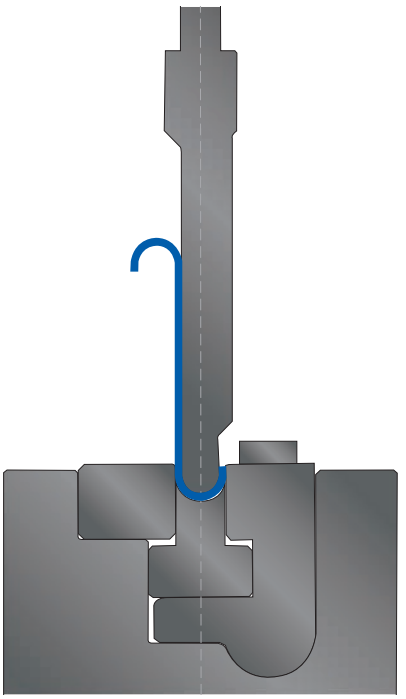
| Part No. | Description | Size |
|---|---|---|
| 5LSP25 / 5LSP25G | Punch Character Holder | 3.75" Staged |
| 50049SD | Flattening Block Die | — |
| 6898 | Character | 3/32" |
| 6896 | Character | 1/8" |

# MECHANICAL



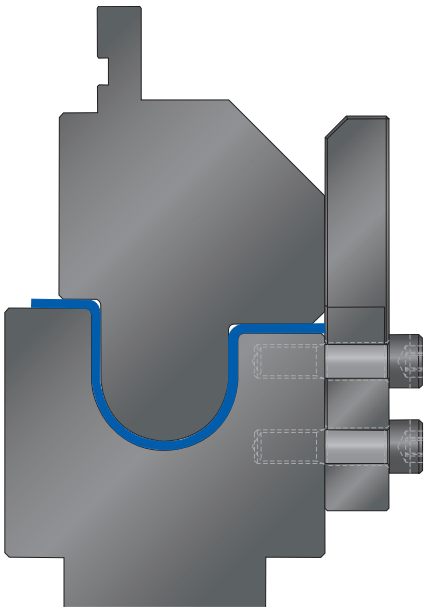
**HT1 — HAT CHANNEL**

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



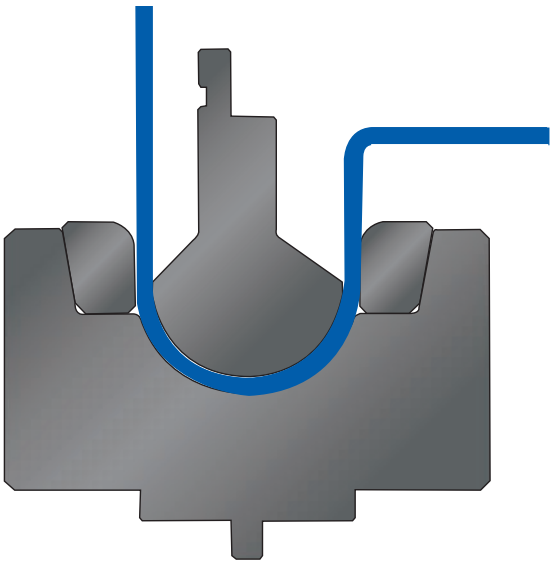
**UC1 — U CHANNEL**

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



**UC2 — U CHANNEL**

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

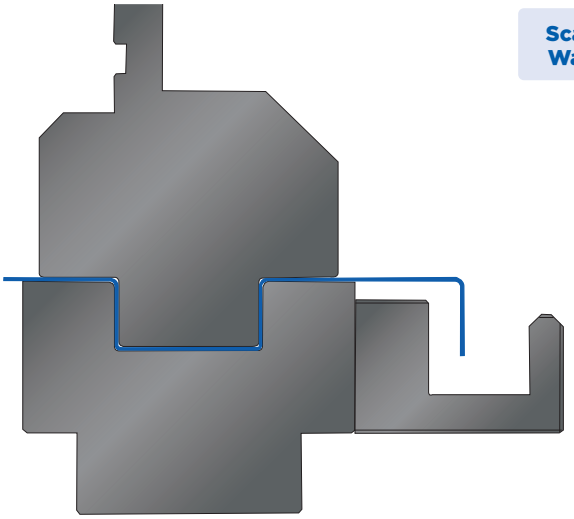


**UC3 — U CHANNEL**

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

# MECHANICAL





## C1 — CHANNEL

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

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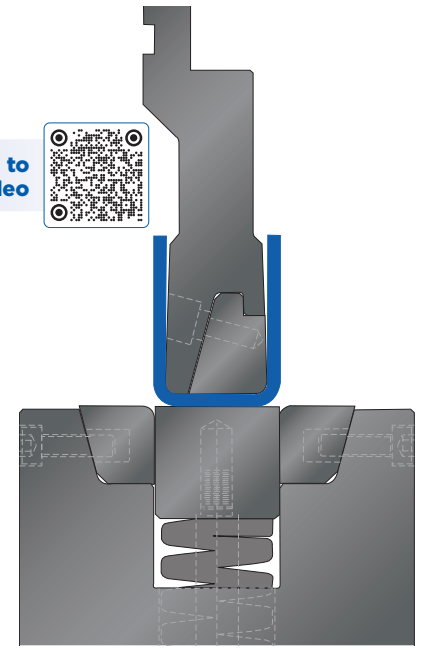
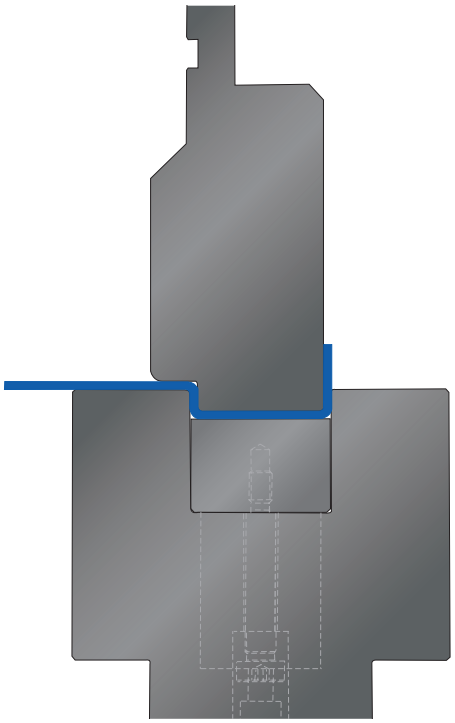


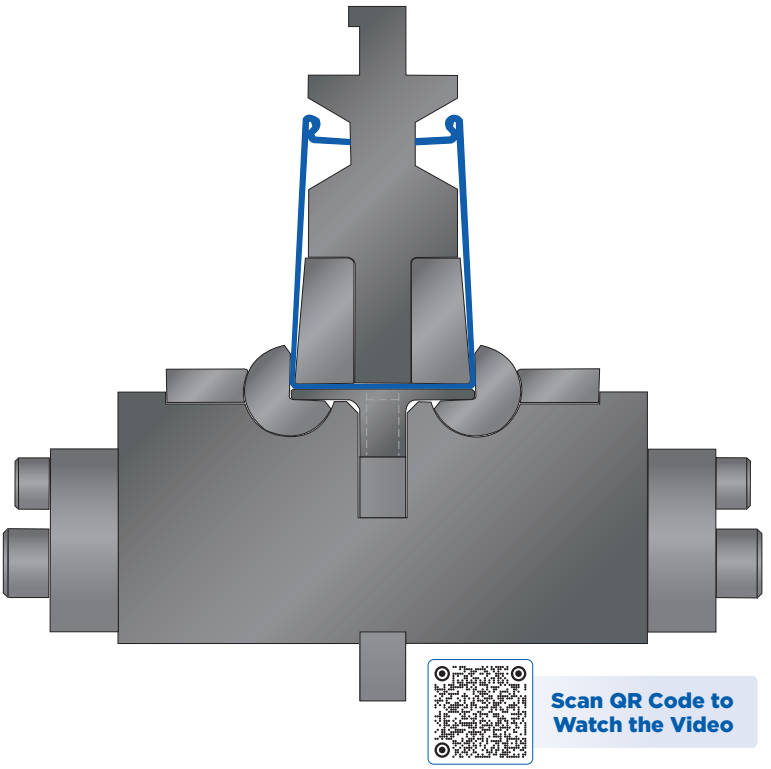
## C2 — CHANNEL

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



## C3 — CHANNEL

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



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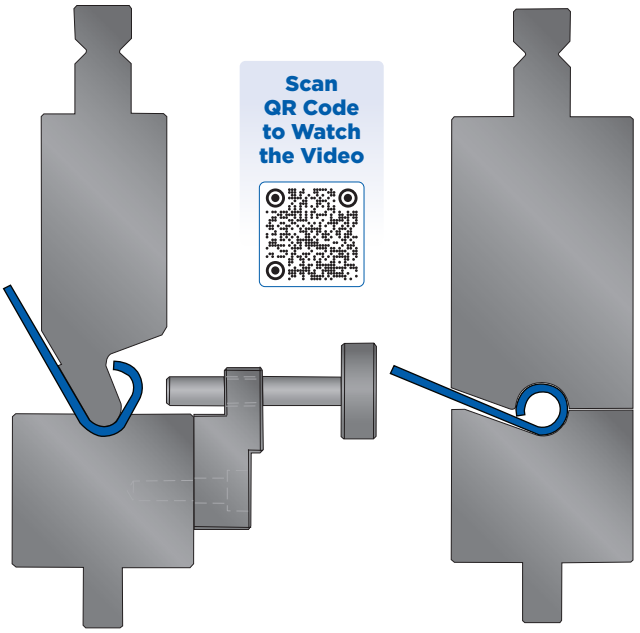
## C4 — ROTARY BEND CHANNEL

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

# MECHANICAL





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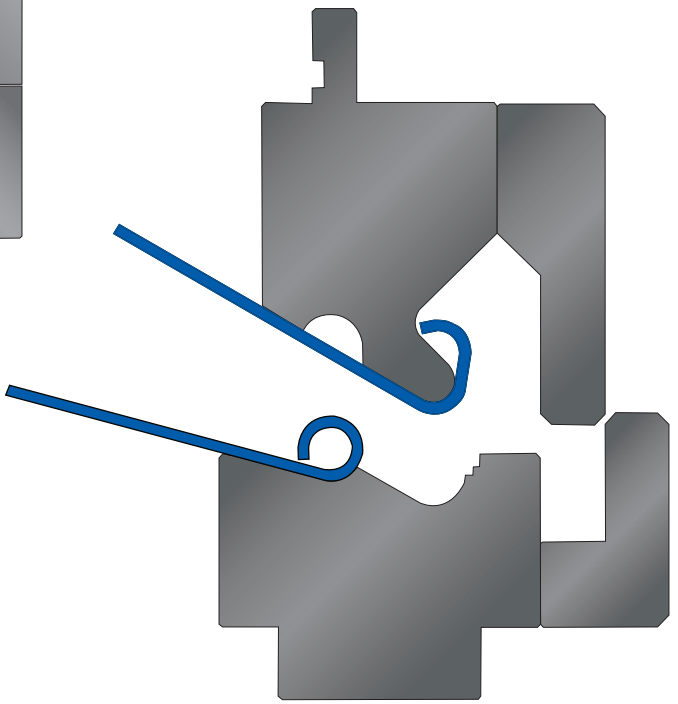
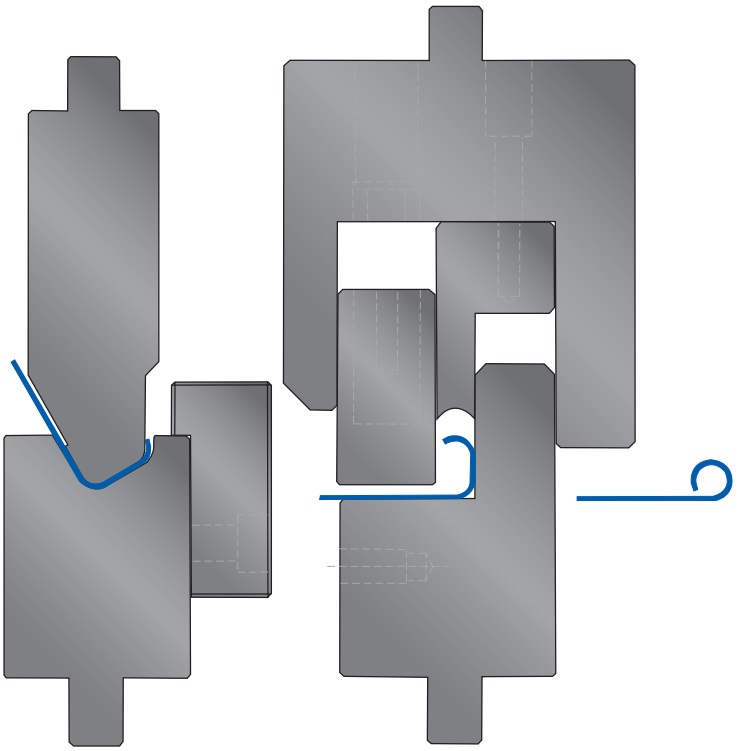
## CL1 — CURL TOOL SET

Two tool sets, three machine strokes.



## CL2 — CURL TOOL SET

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

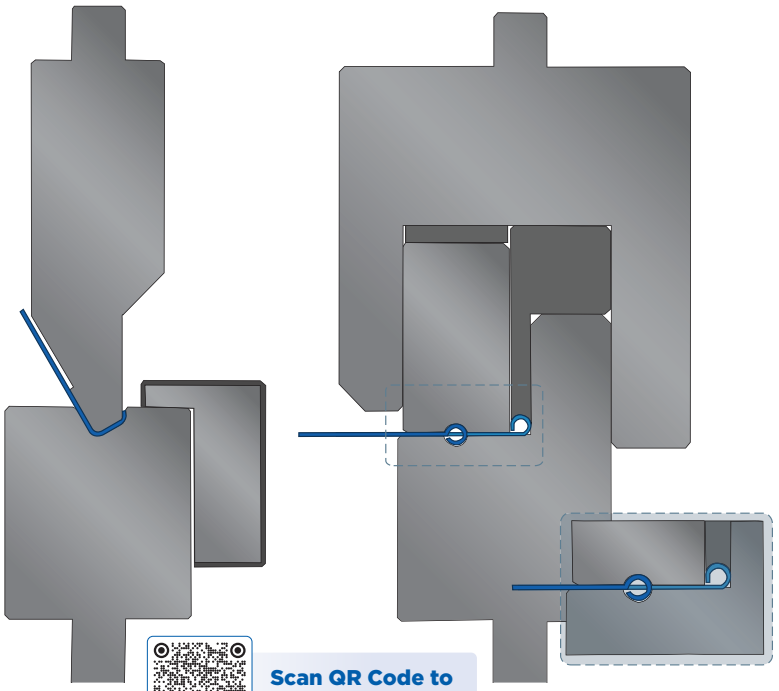


## CL3 — CURL

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

# MECHANICAL





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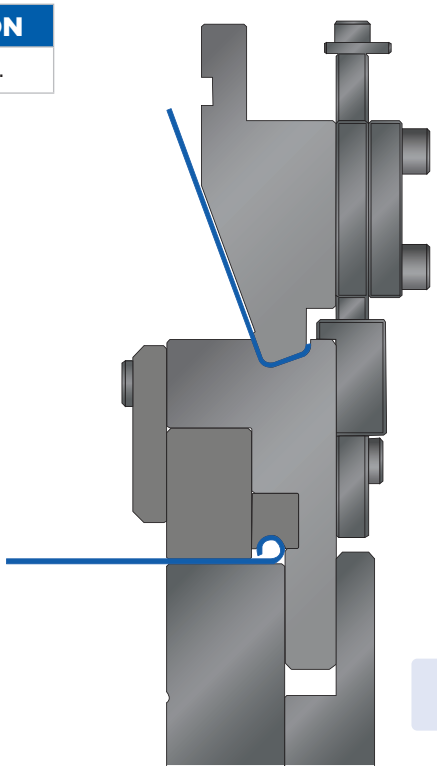
**CL4 — CENTER CURL APPLICATION**

Two tool sets, three machine strokes.



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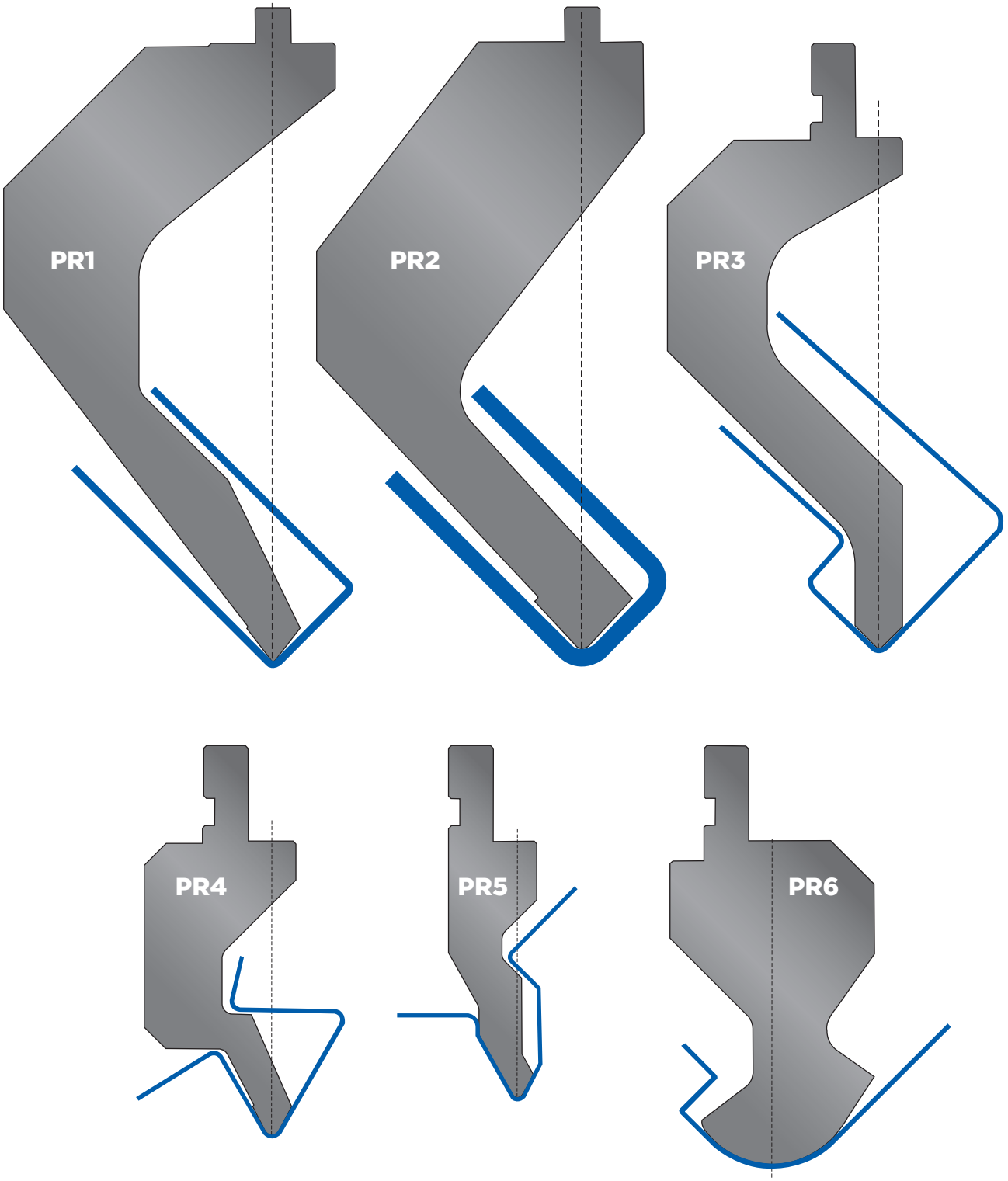
**CL5 — DOUBLE DECKER TOOL SET**

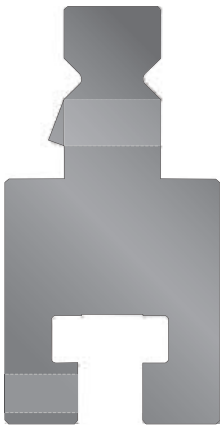
Used for hinges and corner beading.
One tool set, two machine strokes.

# SPECIAL SHAPE PUNCHES



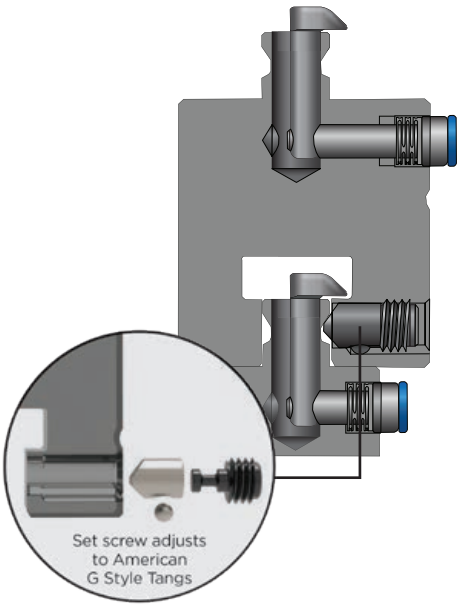
# PUNCH HOLDERS





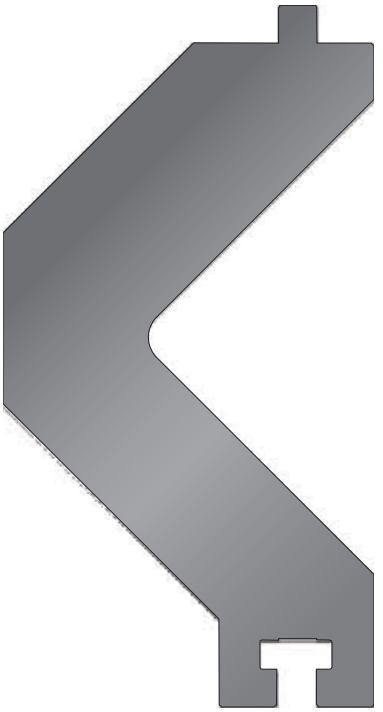
**WT — AMERICAN**

With Set Screws

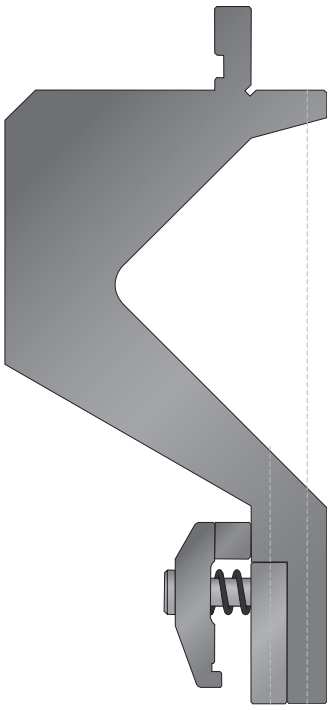



**AMERICAN SELF-SEAT HOLDER**

WT to American with Clamp Plate



**AMERICAN DEEP GOOSENECK HOLDER**



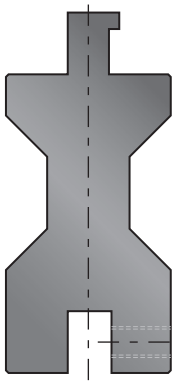
**EURO Z1 OR Z2 CLAMPING**

Part No. 43002

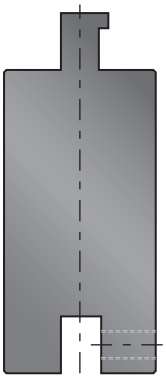
**PUNCH HOLDERS**

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

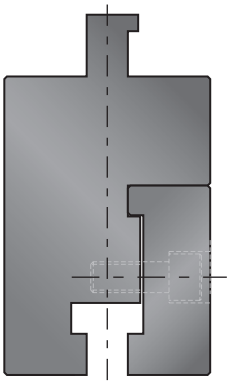
# PUNCH HOLDERS



**RA1 — DOG BONE**



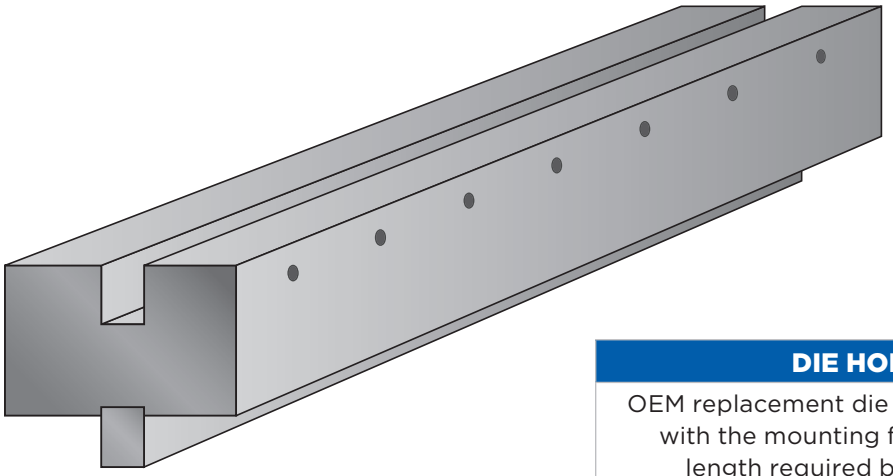
**RA2 — SET SCREW**



**RA3 — CLAMP PLATE**

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

# DIE HOLDERS



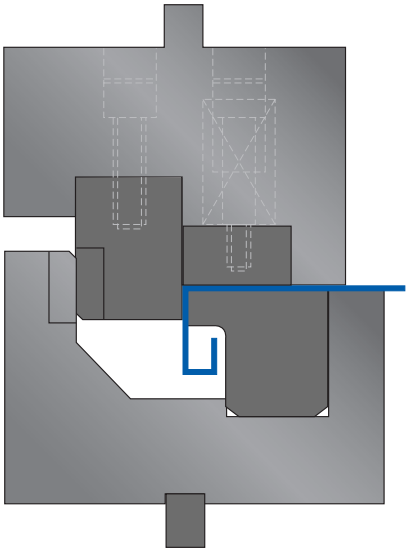
**DIE HOLDERS**

OEM replacement die holders are available with the mounting features and in the length required by your machine.

Die holders can be made in small sections or one piece to fit the length of your machine.

# WIPING AND ROTARY BENDING





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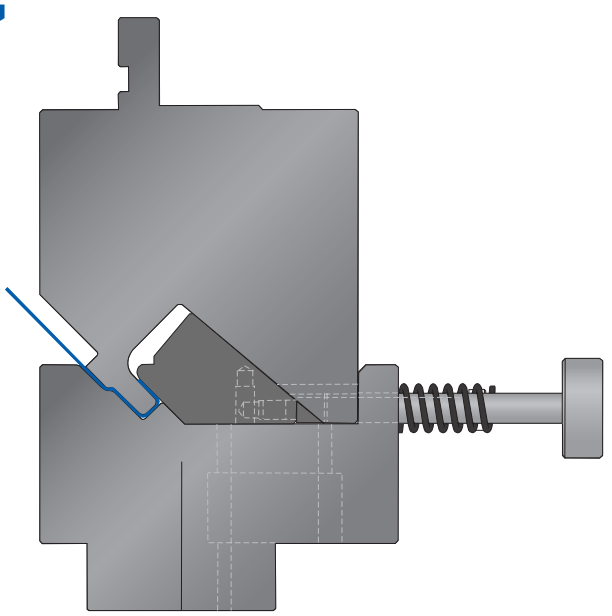
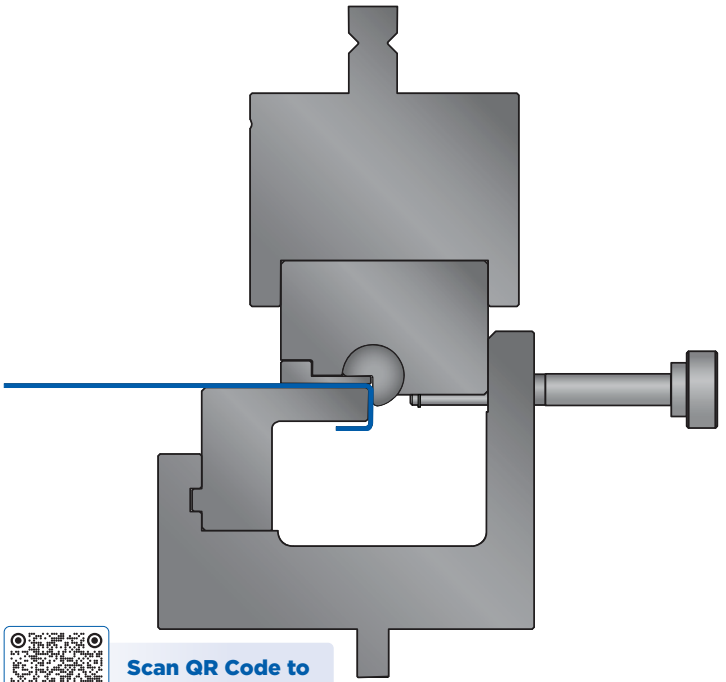


## WD1 — WIPE DOWN

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

## WO1 — WIPING FORM

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



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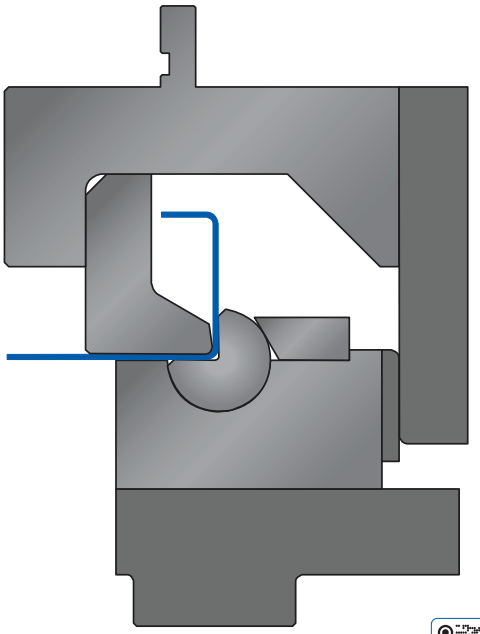
## RTD — FORM DOWN



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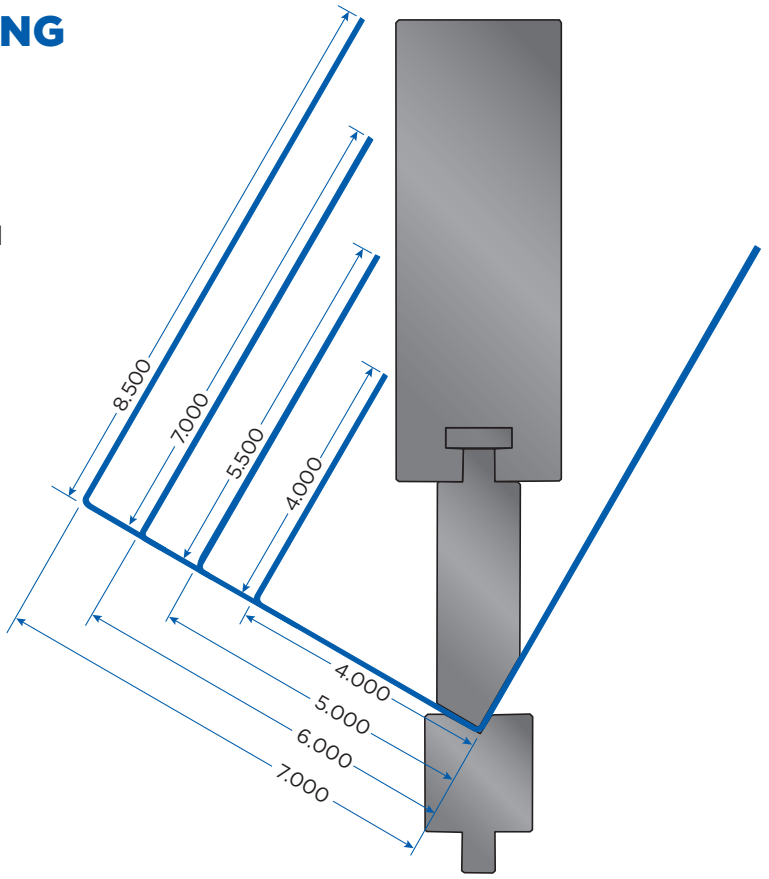
## RTU — FORM UP

## ROTARY FLANGE FORMING

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

# 30/60 DEEP BOX BENDING

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




# SWING EAR SECTIONS

- Box bending with return flanges.
- Standard bend length 150mm each ear on all punch profiles. 100mm length available on select profiles.
- Ear(s) recess/fall in left to right .50 – .75", not to be confused with vertical movement. There will be approximately 1.0 – 1.5" of relief to rotate and drop the finished part.
- Punch profile will match the standard profile only in height, angle and radius. Width will be wider where hinged.

**Scan QR Code to Watch the Video**

Left and right ear sections shown in illustration.

# UNITIZED TOOLING

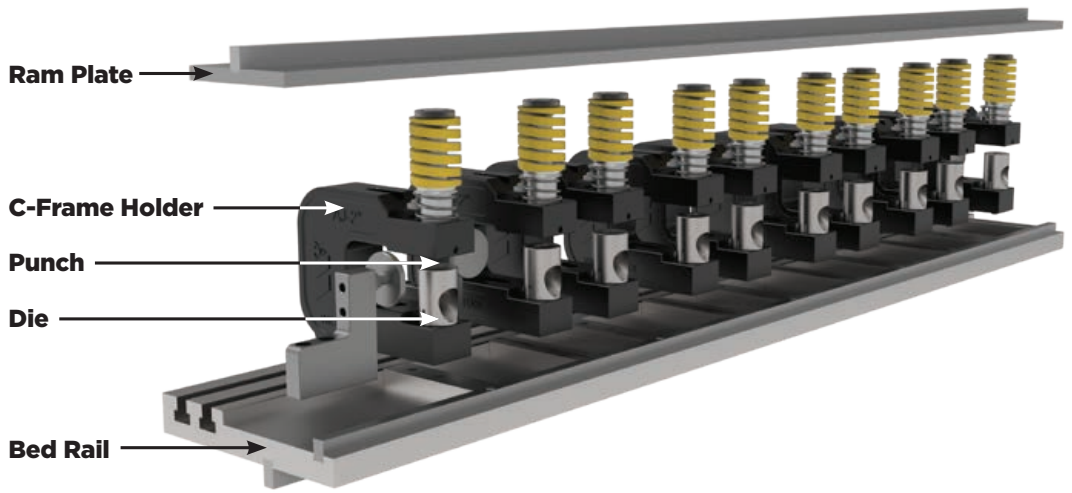
Unitized tooling offers flexibility for various applications, including press brakes, Multicyl setups, and presses. For press brakes, simply attach the units to a bed rail or use a job-specific template. These templates function as a plug-and-play system: attach the template to the machine, secure it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

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

**Scan QR Code to View the Catalog**



**Tooling shown below mounted on a bed rail.**



# AIR BENDING FORCE CHART

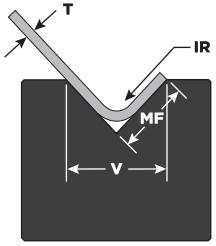
## METRIC V-OPENINGS & IMPERIAL TONNAGE

**NOTE:** Formulas and chart are for reference only.

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

**STANDARD FORMULAS FOR SELECTING A V-OPENING**

**Material Thickness:** 2.6mm or Less = T x 6
3.00mm – 8.0mm = T x 8
9.00mm – 12.00mm = T x 10
14.00mm & Thicker = T x 12




| GAUGE | DEC. inch [mm] | | | V (mm) | 4 | 6 | 7 | 8 | 10 | 12 | 14 | 16 | 18 | 20 | 25 | 32 | 40 | 50 | 63 | 80 | 100 | 125 |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | V (in.) | 0.157 | 0.236 | 0.276 | 0.315 | 0.394 | 0.472 | 0.551 | 0.630 | 0.709 | 0.787 | 0.984 | 1.260 | 1.575 | 1.969 | 2.480 | 3.150 | 3.937 | 4.921 |
| | | | | MF | 0.110 | 0.165 | 0.193 | 0.220 | 0.276 | 0.331 | 0.397 | 0.454 | 0.510 | 0.567 | 0.709 | 0.945 | 1.181 | 1.476 | 1.860 | 2.362 | 2.953 | 3.789 |
| | | | | IR | 0.026 | 0.039 | 0.046 | 0.052 | 0.066 | 0.079 | 0.092 | 0.105 | 0.118 | 0.131 | 0.164 | 0.210 | 0.262 | 0.328 | 0.413 | 0.525 | 0.656 | 0.820 |
| 20 | 0.036 | [.9] | TONS PER FOOT | | 5.4 | **3.6** | 3.0 | 2.5 | 2.0 | 1.7 | | | | | | | | | | | | |
| 18 | 0.048 | [1.2] | | | | 7.2 | **5.8** | 4.8 | 3.7 | 2.7 | 2.4 | 2.0 | | | | | | | | | | |
| 16 | 0.060 | [1.5] | | | | | | 7.8 | **6.0** | 5.0 | 4.2 | 3.5 | 3.1 | 2.7 | | | | | | | | |
| 14 | 0.075 | [1.9] | | | | | | | 11.3 | **7.5** | 7.1 | 5.6 | 4.8 | 4.1 | 3.2 | | | | | | | |
| 13 | 0.090 | [2.3] | | | | | | | | 12.5 | **10.1** | 8.2 | 7.2 | 5.4 | 3.7 | | | | | | | |
| 12 | 0.105 | [2.7] | | | | | | | | 15.8 | 13.0 | 10.5 | **9.5** | 7.5 | 5.6 | 4.0 | | | | | | |
| 11 | 0.120 | [3] | | | | | | | | | | 16.1 | 13.1 | 10.1 | **7.2** | 5.0 | 3.8 | | | | | |
| 10 | 0.135 | [3.4] | | | | | | | | | | | | 12.0 | **8.1** | 6.2 | 4.7 | 3.5 | | | | |
| 9 | 0.150 | [3.8] | | | | | | | | | | | | | 13.1 | **9.0** | 6.7 | 5.2 | | | | |
| 3/16″ | 0.188 | [4.8] | | | | | | | | | | | | | 24.1 | 15.0 | **11.3** | 7.5 | 5.8 | | | |
| 1/4″ | 0.250 | [6.35] | | | | | | | | | | | | | | 30.0 | 20.0 | **15.0** | 10.5 | 8.5 | | |
| 5/16″ | 0.313 | [8] | | | | | | | | | | | | | | | 37.6 | 25.0 | **18.8** | 13.1 | 10.0 | |
| 3/8″ | 0.375 | [9.5] | | | | | | | | | | | | | | | | 38.3 | 28.1 | 22.5 | **15.0** | 11.3 |
| 7/16″ | 0.438 | [11.1] | | | | | | | | | | | | | | | | | 35.0 | 28.0 | 24.0 | **17.0** |
| 1/2″ | 0.500 | [12.7] | | | | | | | | | | | | | | | | | 52.0 | 39.0 | 30.0 | **22.0** |
| 5/8″ | 0.625 | [16] | | | | | | | | | | | | | | | | | | 70.0 | 52.5 | 37.5 |
| 3/4″ | 0.750 | [19] | | | | | | | | | | | | | | | | | | | | 66.0 |
| 1″ | 1.000 | [25.4] | | | | | | | | | | | | | | | | | | | | |

**Larger v-openings generate less tonnage.**

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

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

**Scan QR Code to Watch the Video**

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



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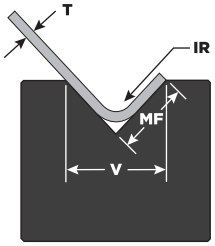
**US Headquarters** tel: 800.445.4518 | bending@wilsontool.com

# AIR BENDING FORCE CHART

## IMPERIAL V-OPENINGS & IMPERIAL TONNAGE

**NOTE:** Formulas and chart are for reference only.

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




**STANDARD FORMULAS FOR SELECTING A V-OPENING**

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

| GAUGE | DEC. inch [mm] | | V (in.) | 0.250 | 0.313 | 0.375 | 0.500 | 0.625 | 0.750 | 0.875 | 1.000 | 1.125 | 1.250 | 1.500 | 2.000 | 2.500 | 3.000 | 3.500 | 4.000 | 5.000 |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | MF | 0.180 | 0.225 | 0.270 | 0.360 | 0.450 | 0.540 | 0.630 | 0.720 | 0.810 | 0.900 | 1.080 | 1.440 | 1.800 | 2.159 | 2.519 | 2.879 | 3.599 |
| | | | IR | 0.042 | 0.052 | 0.063 | 0.084 | 0.104 | 0.125 | 0.146 | 0.167 | 0.188 | 0.209 | 0.251 | 0.334 | 0.418 | 0.501 | 0.585 | 0.668 | 0.835 |
| 20 | 0.036 | [.9] | TONS PER FOOT | **2.9** | 2.2 | 1.7 | 1.2 | 1.0 | | | | | | | | | | | | |
| 18 | 0.048 | [1.2] | | 7.0 | **4.0** | 2.9 | 2.2 | 1.6 | 1.3 | | | | | | | | | | | |
| 16 | 0.060 | [1.5] | | | 7.8 | **5.6** | 3.6 | 2.7 | 2.2 | 1.7 | | | | | | | | | | |
| 14 | 0.075 | [1.9] | | | | 11.7 | **6.0** | 4.5 | 3.4 | 3.0 | 2.5 | 2.1 | | | | | | | | |
| 13 | 0.090 | [2.3] | | | | | 12.2 | **6.8** | 5.4 | 4.3 | 3.7 | 3.3 | 2.9 | | | | | | | |
| 12 | 0.105 | [2.7] | | | | | | 10.1 | **7.4** | 6.3 | 5.4 | 4.4 | 4.0 | 3.2 | | | | | | |
| 11 | 0.120 | [3] | | | | | | | 10.5 | 8.8 | **7.2** | 6.2 | 5.4 | 4.3 | 3.2 | | | | | |
| 10 | 0.135 | [3.4] | | | | | | | | 11.3 | 9.6 | **8.4** | 7.0 | 5.6 | 4.1 | | | | | |
| 9 | 0.150 | [3.8] | | | | | | | | | 13.1 | 11.9 | **9.0** | 6.7 | 5.2 | 3.5 | | | | |
| 7 | 0.188 | [4.8] | | | | | | | | | | 16.4 | 14.0 | **11.2** | 7.6 | 5.8 | 4.5 | | | |
| 1/4″ | 0.250 | [6.35] | | | | | | | | | | | 28.8 | 22.0 | **15.3** | 11.5 | 9.1 | 7.5 | 6.2 | |
| 5/16″ | 0.312 | [8] | | | | | | | | | | | | 38.0 | 26.0 | **19.2** | 16.0 | 12.5 | 10.6 | 7.6 |
| 3/8″ | 0.375 | [9.5] | | | | | | | | | | | | | 41.0 | 29.9 | 24.0 | **19.4** | 16.0 | 12.3 |
| 7/16″ | 0.438 | [11.1] | | | | | | | | | | | | | | 45.2 | 35.0 | 28.0 | **24.0** | 17.0 |
| 1/2″ | 0.500 | [12.7] | | | | | | | | | | | | | | | 47.9 | 39.0 | 33.1 | **24.0** |
| 5/8″ | 0.625 | [16] | | | | | | | | | | | | | | | | 69.5 | 58.0 | 42.2 |
| 3/4″ | 0.750 | [19] | | | | | | | | | | | | | | | | | 92.0 | 69.0 |
| 7/8″ | 0.875 | [22] | | | | | | | | | | | | | | | | | | 104.0 |
| 1″ | 1.000 | [25.4] | | | | | | | | | | | | | | | | | | |

Larger v-openings generate less tonnage.

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

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

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

# TONNAGE ESTIMATES

**Making Multiple Bends Formula on a Press Brake**

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

## MULTIPLY METAL THICKNESS BY FACTOR = TONS PER FT.

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

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

# PRESS BRAKE SPECIALS CHECKLIST

| | | | |
|---|---|---|---|
| Company: | | | |
| Contact: | | | |
| Phone: | | Sales Engineer: | |
| Quote #: | | Sales Desk Contact: | |

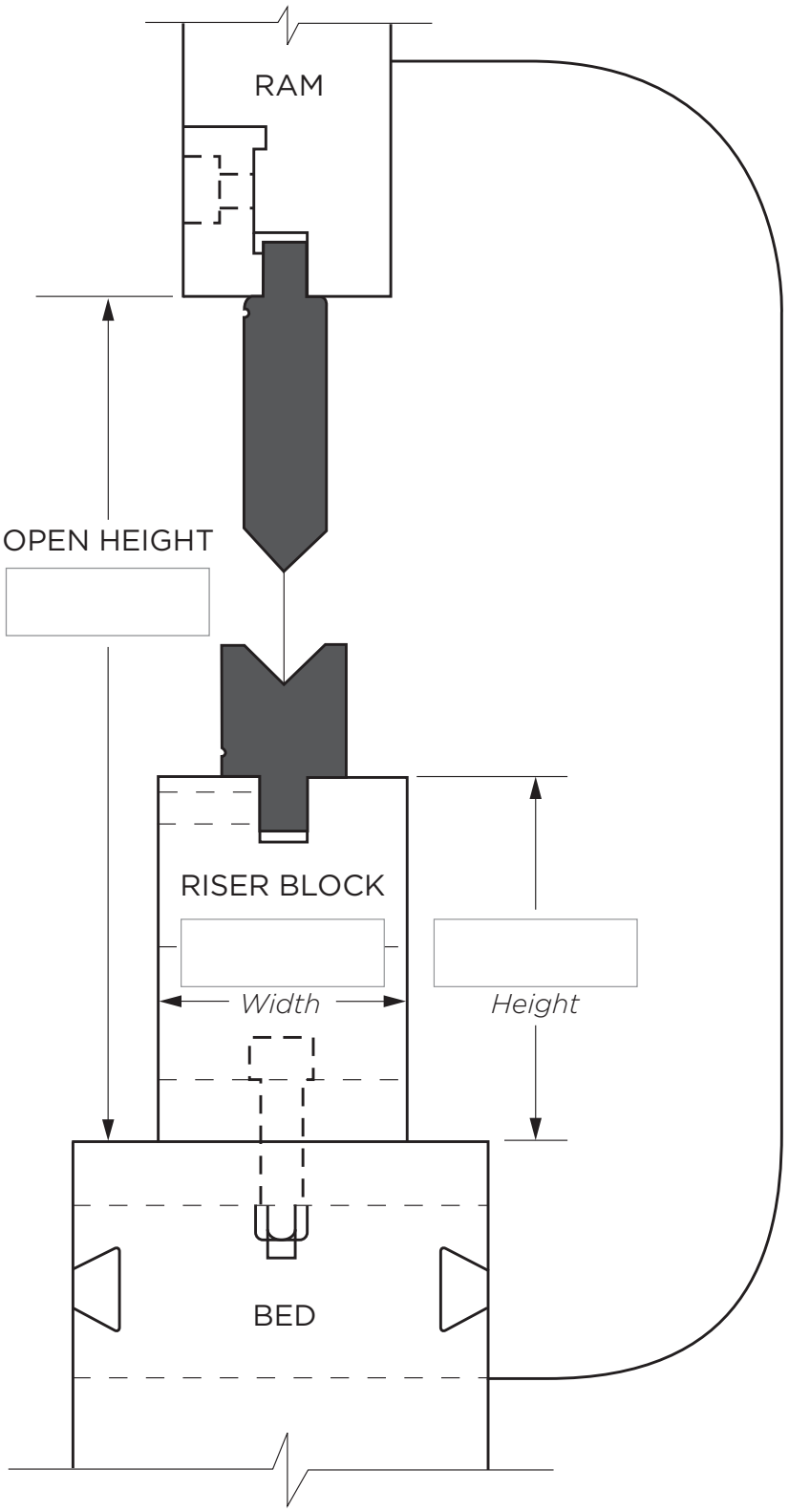
| MACHINE SPECIFICATIONS | | | |
|---|---|---|---|
| **BRAKE MAKE/MODEL** | | **TONNAGE** | |
| **OVERALL LENGTH** | | **APPROX. AGE** | |
| **STROKE** | *Open Height* | *Closed Height* | |

| TOOLING AND APPLICATION | | | |
|---|---|---|---|
| **TOOLING TYPE** | ☐ American ☐ European ☐ WT ☐ Bystronic ☐ Other | | |
| **LENGTH OF BEND** | | | |
| **MATERIAL TYPE** | | **THICKNESS** | |
| Is customer currently performing this bend? ☐ Yes ☐ No<br>If YES, specify if this is a ☐ Wilson Tool Repeat ☐ Replicate Customer Tool ☐ Redesign | | | |
| Explain: | | | |

| TOLERANCE BLOCK | |
|---|---|
| **PART RADII TOLERANCE** | *Tolerances tighter than ±5% may affect price/lead time* |
| **PART BEND ANGLE TOLERANCE** | *Tolerances tighter than ±3% may affect price/lead time.* |
| **ESTIMATED ANNUAL USAGE** | |

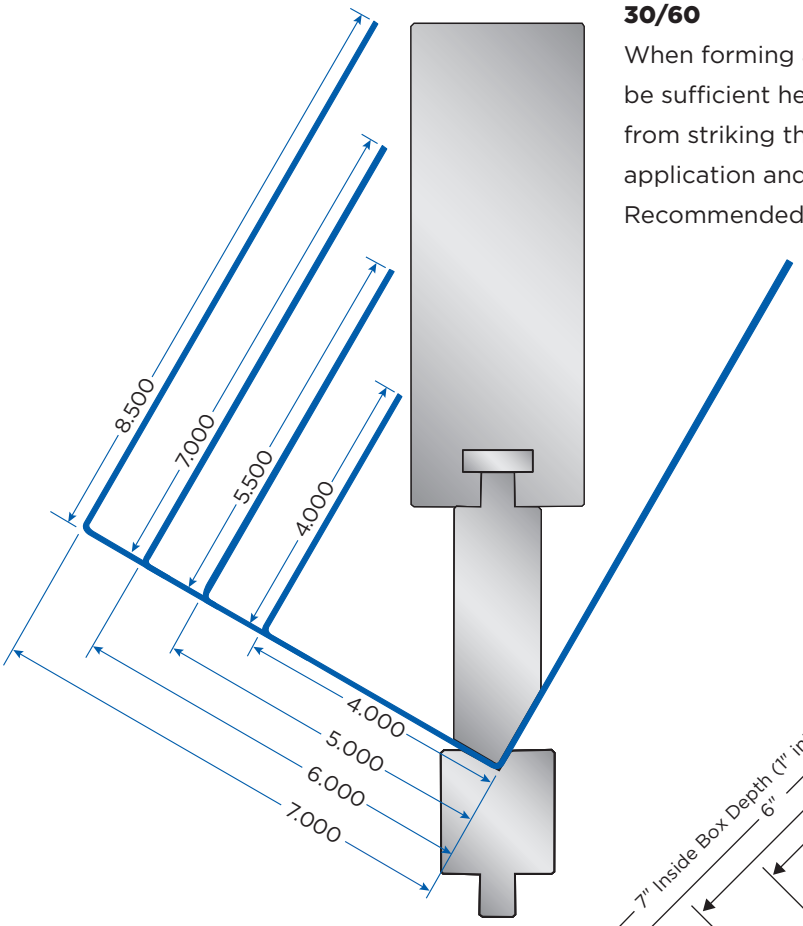
REFERENCE

# TYPICAL PRESS SETUP



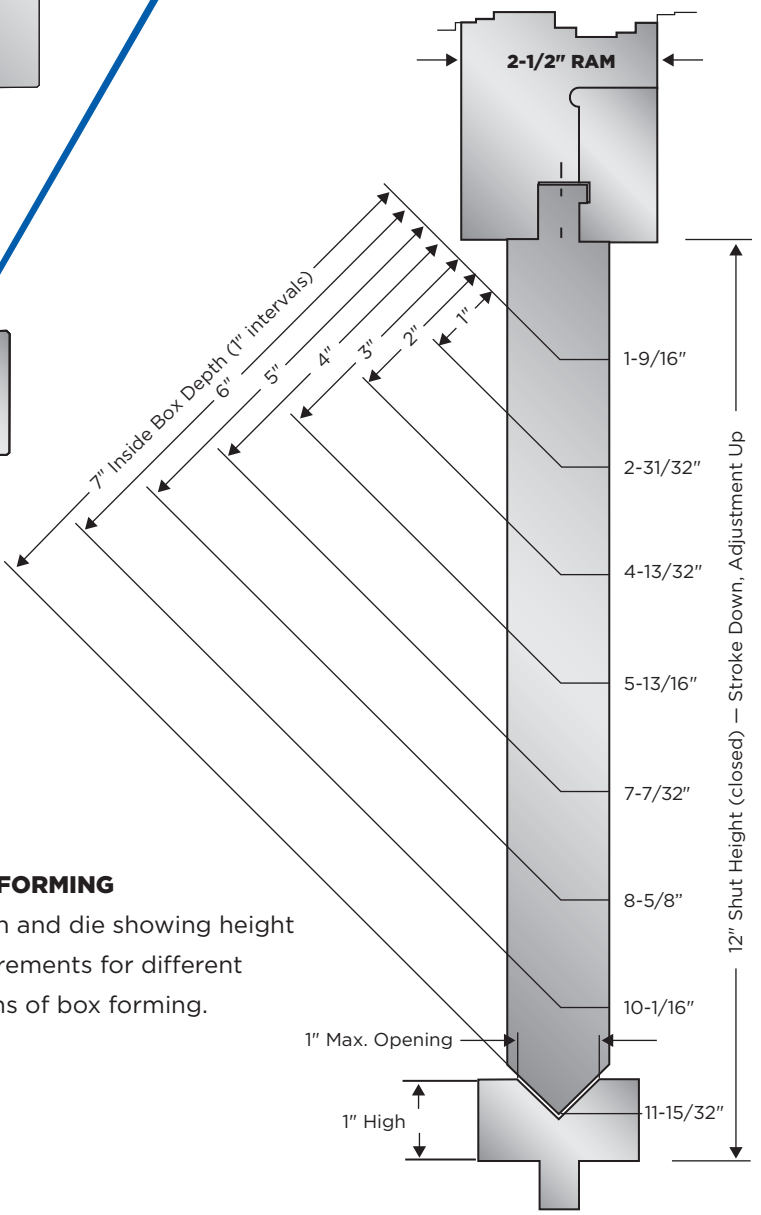
# 30/60 PUNCH PROFILE REFERENCE CHARTS






**30/60**

When forming a four-sided box, the punch must be sufficient height to prevent the pre-formed side from striking the upper beam. This is a thrusting application and not suitable for all press brakes. Recommended for up to 16g.




**BOX FORMING**

Punch and die showing height requirements for different depths of box forming.

# TOOL STORAGE

## XTREME STORAGE CABINET

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

### CUSTOM COLOR OPTIONS

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

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

| | Catalog Numbers | | | |
|---|---|---|---|---|
| **Xtreme Storage Cabinet Detail** | **5103A** | **5104A** | **5105A** | **5106A** |
| **Number of Drawers** | 3 | 4 | 5 | 6 |
| **Cabinet Height** (outside dim.) | 62" [1575mm] | 62" [1575mm] | 62" [1575mm] | 62" [1575mm] |
| **Width** (left to right – outside dim.) | 23" [585mm] | 30" [762mm] | 37" [940mm] | 44" [118mm] |
| **Depth / Tool Space** (front to back – inside dim.) | 44" [1118mm] | 44" [1118mm] | 44" [1118mm] | 44" [1118mm] |
| **Number of Tool Trays** | 12 | 16 | 20 | 24 |
| **Total Length* of Tooling** (1 tool/tray – inside dim.) | 40' [12.1m] | 53' [16.1m] | 66.5' [20.2m] | 80' [24.3m] |
| **Total Length* of Tooling** (2 tools/tray – inside dim.) | 80' [24.3m] | 106' [32.3m] | 133' [40.5m] | 160' [48.7m] |

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

ACCESSORIES

# TOOL STORAGE



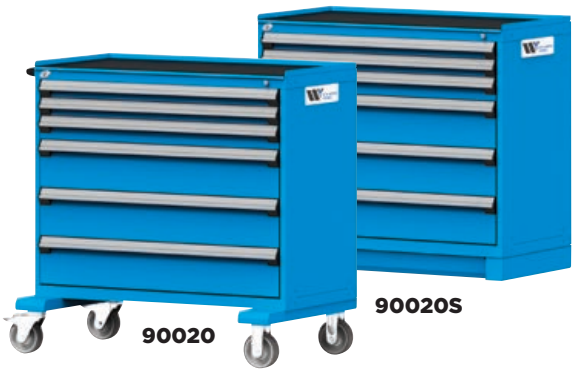
## PRESS BRAKE TOOL STORAGE


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

### Tip-up Cabinet for American-Style Punches

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

| Part No. | W x D x H | Drawer Sizes |
|---|---|---|
| 90020S | 48" x 24" x 43" | 2 – 1.75" [44.4mm]<br>1 – 2.75" [69.9mm]<br>3 – 6.75" [171.4mm] |
| 90020 | 48" x 24" x 47.5" | |




### Lay-Down Cabinet for Press Brake Tooling

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

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


### CUSTOM COLOR OPTIONS

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

*Colors may differ slightly from those shown.*

# MEASURING TOOLS

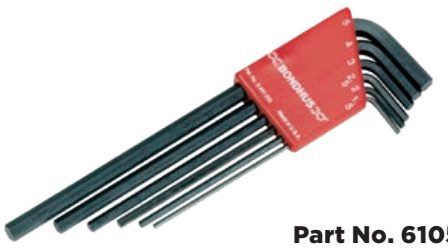
## DIGITAL ANGLE CUBE



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

# HAND TOOLS

## METRIC HEX KEY WRENCH SET



**Part No. 6105**

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

## SOFT FACE HAMMER

**Part No. 6106**

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

## MAGNET SQUARE

**Part No. 974150**

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

# GAUGING TOOLS

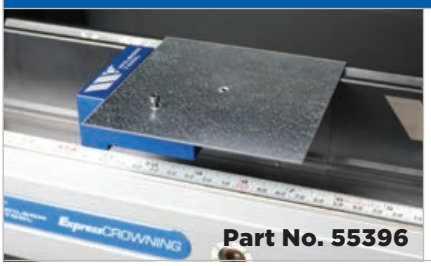


## DIAL ADJUSTABLE SQUARING ARM



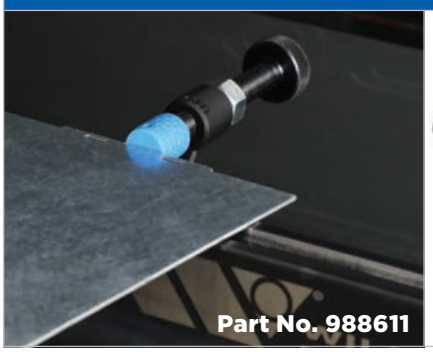
Infinite angle squaring arm with tool-free adjustment can be used as a left or right hand gauge. Significant magnetic holding power keeps the unit in place. Small enough to be out of the way, yet big enough to provide a sizable surface to rest the material being bent.

## MAGNETIC SQUARING BLOCK




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

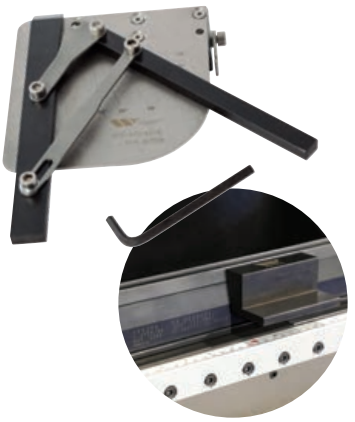
## MAGNETIC GAUGE




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

| Part No. | Description |
|---|---|
| 988741 | Blue Threaded Cap |

## MAGNETIC SQUARING ARM

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

| Part No. | Description |
|---|---|
| 42750L | Magnetic Squaring Arm LEFT |
| 42750R | Magnetic Squaring Arm RIGHT |
| 42750A | 30° Die Adapter |

# MARK-FREE BENDING

## URETHANE ROLLS — 6 in. x 100 ft.

| Part No. | Thickness | Durometer | Description |
|---|---|---|---|
| 42530 | .015" [.4mm] | 85A (Milky White) | • More elastic than blue<br>• Well suited for deeper draw applications<br>• Will not last as long as blue for 90° bends |
| 42531 | .030" [.8mm] | | |
| 42532 | .022" [.56mm] | 95A (Blue) | • A more ridged solution<br>• Lasts considerably longer than the white options in many applications<br>• Harder and less elastic than blue<br>• Not suited for deeper draw applications |

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

## PROTECTIVE FABRIC DRAPE


Forms a protective barrier between the sheet metal and the die shoulders during the bending process. Lasts 5–8 times longer than a urethane drape.

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

## DRAPE HOLDER


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

# THE DIVISIONS OF WILSON TOOL INTERNATIONAL

## BENDING

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

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

## STAMPING

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

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

## PUNCHING

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

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

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

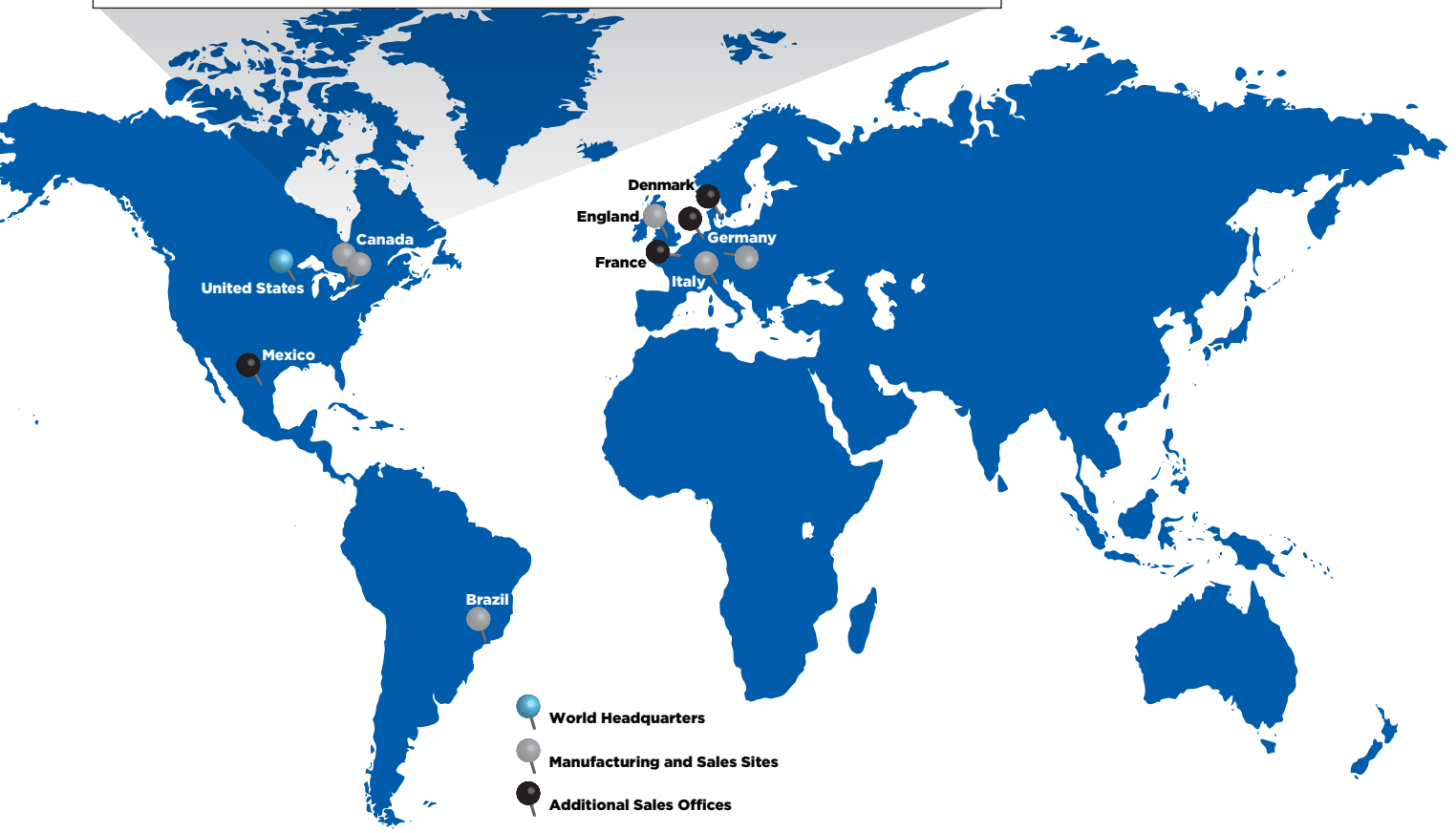
## ACCESSORIES

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

# NOTES

# WILSON TOOL INTERNATIONAL CANADA OFFICES

20 Ecopark Close, Brampton, Ontario L6Z 0B5
**800.268.4180** | **bending@wilsontoolcanada.com**




# YEARS OF INDUSTRY EXPERIENCE, NOW AVAILABLE GLOBALLY

The Wilson Tool International brand of American Planed (or "conventional") tooling is a lower cost option for customers whose applications do not require the tolerance and finish found in precision tooling. Planed tooling is built to a tolerance of ± .002" and made of a 28–32 HRC steel. Options for improving the hardness, life and precision of planer machined tooling are available upon request.

Our American Planed tooling is manufactured out of our Ontario, Canada plant.

WILSON TOOL

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