WILSON TOOL

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Available 24/7

LVD-STYLE
PRESS BRAKE TOOLING

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.

LVD-STYLE PRESS BRAKE TOOLING

TABLE OF CONTENTS

LVD-style press brake tooling is sold in North America only.

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

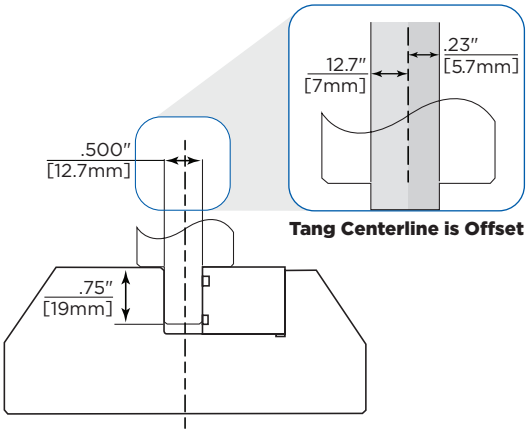
Please note, all orders are subject to Wilson Tool International's Terms and Conditions which include pricing, payment, delivery, warranties, and our return policy. To view our full Terms and Conditions, visit wilsontool.com/en-us/terms-conditions.

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.

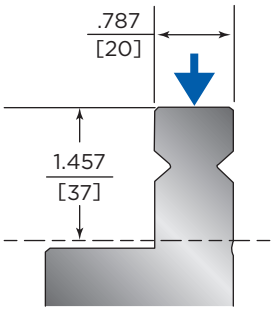
LVD-STYLE PRECISION TOOLING

Features

- Tooling can be loaded by a single operator
- Easy to store
- Standard sectionalized lengths
- Sectionalized punches include a left and right ear/horn
- All tooling heat treated with Nitrex® and/or laser hardening
- Each tool is laser marked with significant information
- Special tooling available — Contact a Tooling Technician



LVD Die Tang Design

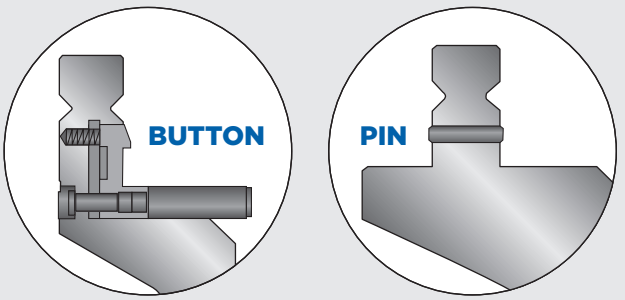


Precision Manufactured for Consistent Results

LVD-Style precision press brake tooling is manufactured to a tolerance of ± .0004″ [0.01mm] on all critical dimensions. Available long (20.08″ [510mm]), short (9.84″ [250mm]) and sectionalized (21.6″ [550mm]), tooling can be mixed and matched for consistent bending quality throughout multiple jobs. Taller, heavier punches can be made in lengths to accommodate your preference of buttons or solid safety tangs.

Push-Button Technology

Load and unload tools instantly with our unique push-button technology, eliminating the need for special clamps, holders or dedicated upper beams, significantly reducing costly downtime.

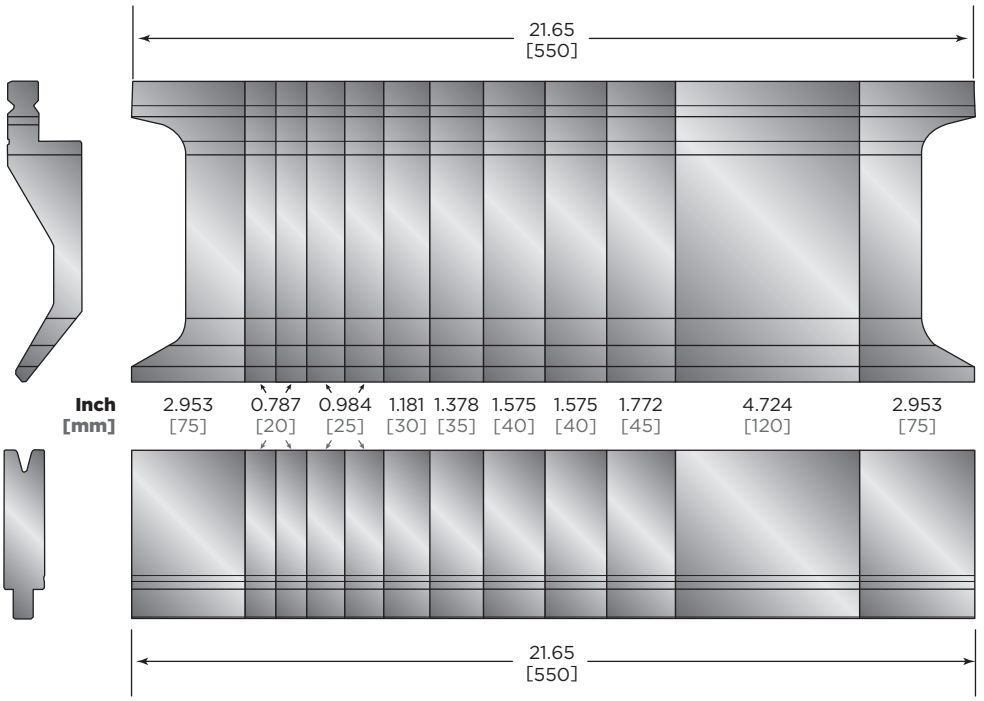


STONE Radius

STONE radius assures accurate bend angles along the entire bending length. LVD tooling is produced with a progressive radius on both sides of the V-opening, allowing the material to flow into the die more evenly and with less drag.

This unique design of the V-die reduces the friction between the material and the die encountered when bending, by creating a rolling condition as the material enters the die.

ORDERING INFORMATION



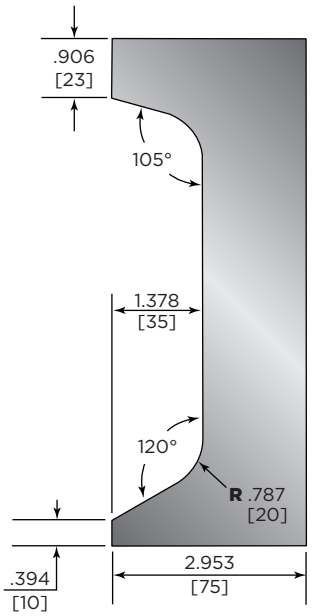
Standard Lengths

250 = 250mm (9.84″)
510 = 510mm (20.08″)
550S Sectionalized = 550mm (21.6″)

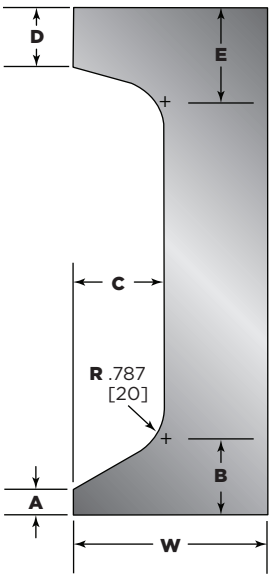
Sectionalized Lengths

	120mm	4.72″
(2)	75mm	2.95″
	45mm	1.77″
(2)	40mm	1.57″
	35mm	1.37″
	30mm	1.18″
(2)	25mm	0.98″
(2)	20mm	0.78″

STANDARD EAR PIECE

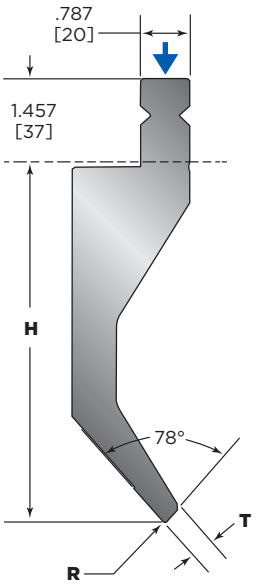


SPECIAL EAR PIECE



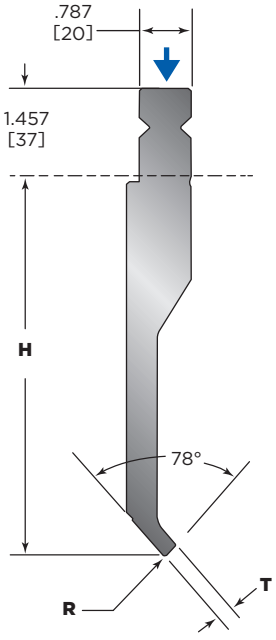
When ordering a special ear piece from Wilson Tool, please indicate the dimensions on this diagram.

ORDERING INFORMATION



78° SWAN NECK PUNCH

Cat. No.	T in. [mm]	R Tip Radius in. [mm]	H Working Height in. [mm]	kN/m	Max. Ton ft. [m]	250 9.8" [250mm]	510 20" [510mm]	550S Sectional 21.6" [550mm]
Profile: D10W								
TP00001	.374 [9.5]	.039 [1]	6.260 [159]	400	13 [44]			
TP00003	.570 [14.5]	.079 [2]		750	25 [83]			
TP00023		.118 [3]						
TP00024		.157 [4]						
TP00025		.197 [5]						
TP00026		.236 [6]						
TP00027		.315 [8]						
Profile: D15W								
TP00002	.374 [9.5]	.039 [1]	7.638 [194]	400	13 [44]			
TP00004	.570 [14.5]	.079 [2]		750	25 [83]			
TP00028		.118 [3]						
TP00029		.157 [4]						
TP00030		.197 [5]						
TP00031		.236 [6]						
TP00032		.315 [8]						



78° GOOSENECK PUNCH

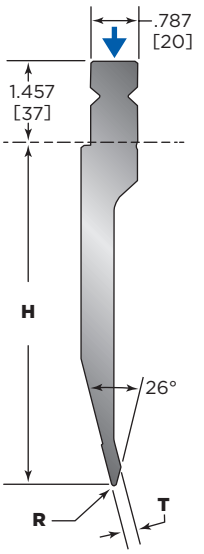
Cat. No.	T in. [mm]	R Tip Radius in. [mm]	H Working Height in. [mm]	kN/m	Max. Ton ft. [m]	250 9.8" [250mm]	510 20" [510mm]	550S Sectional 21.6" [550mm]
Profile: E10W								
TP00005	.256 [6.5]	.039 [1]	6.260 [159]	400	13 [44]			
TP00007	.354 [9]	.079 [2]		680	23 [75]			
TP00033		.118 [3]						
TP00034		.157 [4]						
TP00035		.197 [5]						
TP00036		.236 [6]						
Profile: E15W								
TP00006	.256 [6.5]	.039 [1]	7.638 [194]	400	13 [44]			
TP00008	.354 [9]	.079 [2]		680	23 [75]			
TP00037		.118 [3]						
TP00038		.157 [4]						
TP00039		.197 [5]						
TP00040		.236 [6]						

↓ Tonnage for ear sections is 20% less than the stated capacity.
Indicates how tonnage is applied to punches

Tooling for special applications available upon request.

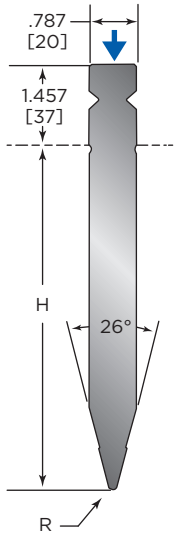
26° ACUTE PUNCH

Cat. No.	T in. [mm]	R Tip Radius in. [mm]	H Working Height in. [mm]	kN/m	Max. Ton ft. [m]	250 9.8" [250mm]	510 20" [510mm]	550S Sectional 21.6" [550mm]
Profile: J10W								
TP00166	.216 [5.5]	.020 [.5]	6.260 [159]	200	7 [22]			
TP00009		.039 [1]		400	13 [44]			
TP00011	.268 [6.8]	.079 [2]		600	20 [66]			
TP00012		.098 [2.5]						
TP00041		.118 [3]						
TP00071		.157 [4]						
TP00072	.405 [10.3]	.197 [5]		880	22 [73]			
Profile: J15W								
TP00010	.216 [5.5]	.039 [1]	7.638 [194]	400	13 [44]			
TP00052	.268 [6.8]	.079 [2]		600	20 [66]			
TP00042		.118 [3]						



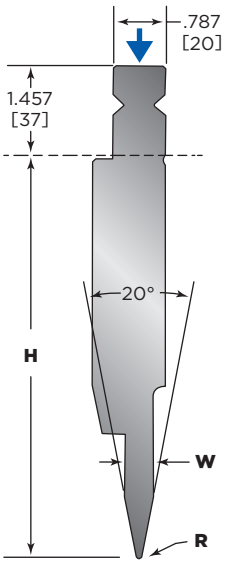
26° STRAIGHT PUNCH

Cat. No.	R Tip Radius in. [mm]	H Working Height in. [mm]	kN/m	Max. Ton ft. [m]	250 9.8" [250mm]	510 20" [510mm]	550S Sectional 21.6" [550mm]
Profile: R10W							
TP00013	.079 [2]	6.260 [159]	800	27 [88]			
TP00043	.118 [3]		1,200	40 [132]			
TP00044	.157 [4]		1,600	54 [176]			
TP00045	.197 [5]		2,000	67 [220]			
TP00046	.236 [6]						
TP00047	.315 [8]						
Profile: R15W							
TP00014	.118 [3]	7.638 [194]	1,200	40 [132]			
TP00048	.157 [4]		1,600	54 [176]			
TP00049	.197 [5]		2,000	67 [220]			
TP00050	.236 [6]						
TP00051	.315 [8]						



20° HEMMING PUNCH

Profile	Cat. No.	R Tip Radius in. [mm]	H Working Height in. [mm]	W Width in. [mm]	kN/m	Max. Ton ft. [m]	250 9.8" [250mm]	510 20" [510mm]	550S Sectional 21.6" [550mm]
Profile: P10W									
P10.08W	TP00017	.039 [1]	6.654 [169]	.268 [6.8]	400	13 [44]			
P10.10W	TP00018			.346 [8.8]					
P10.12W	TP00019			.425 [10.8]					
Profile: P15W									
P15.08W	TP00020	.039 [1]	8.425 [214]	.268 [6.8]	400	13 [44]			
P15.10W	TP00021			.346 [8.8]					
P15.12W	TP00022			.425 [10.8]					

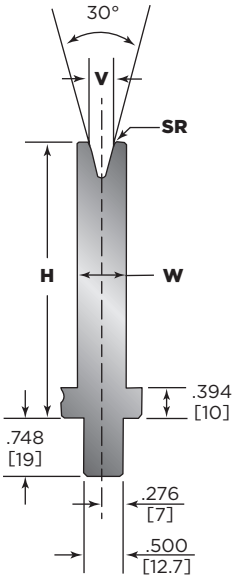


Tonnage for ear sections is 20% less than the stated capacity.
Indicates how tonnage is applied to punches

Tooling for special applications available upon request.

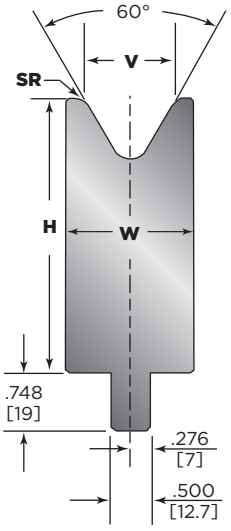
PUNCHES

30° SINGLE V DIE



Cat. No.	V Opening in. [mm]	H Height in. [mm]	W Width in. [mm]	SR Shoulder Radius in. [mm]	kN/m	Max. Ton ft. [m]	250 9.8" [250mm]	510 20" [510mm]	550S Sectional 21.6" [550mm]
90mm Tall Dies									
TP00077	.236 [6]	3.543 [90]	.551 [14]	.031 [0.8]	250	8 [25]			
TP00081	.315 [8]		.630 [16]		260	9 [29]			
TP00085	.394 [10]		1.023 [26]	.039 [1.0]	460	15 [51]			
TP00089	.472 [12]		1.023 [26]	.047 [1.2]					
TP00097	.630 [16]		1.181 [30]	.063 [1.6]	510	17 [56]			
TP00105	.787 [20]		1.574 [40]	.079 [2.0]	680	23 [75]			
TP00109	.945 [24]		1.811 [46]	.094 [2.4]	930	31 [102]			
TP00113	1.181 [30]		2.205 [56]	.118 [3.0]	1,100	37 [121]			
TP00125	1.575 [40]		2.953 [75]	.157 [4.0]	1,400	47 [154]			
TP00131	1.969 [50]		3.543 [90]	.157 [4.0]	1,350	41 [138]			
130mm Tall Dies									
TP00078	.236 [6]	5.118 [130]	.551 [14]	.031 [0.8]	250	8 [25]			
TP00082	.315 [8]		.630 [16]		260	9 [29]			
TP00086	.394 [10]		1.023 [26]	.039 [1]	460	15 [51]			
TP00090	.472 [12]		1.023 [26]	.047 [1.2]					
TP00098	.630 [16]		1.181 [30]	.063 [1.6]	510	17 [56]			
TP00106	.787 [20]		1.574 [40]	.079 [2.0]	680	23 [75]			
TP00110	.945 [24]		1.811 [46]	.094 [2.4]	930	31 [102]			
TP00114	1.181 [30]		2.205 [56]	.118 [3]	1,100	37 [121]			
TP00126	1.575 [40]		2.953 [75]	.157 [4]	1,400	47 [154]			
TP00132	1.969 [50]		3.543 [90]	.157 [4]	1,700	52 [173]			

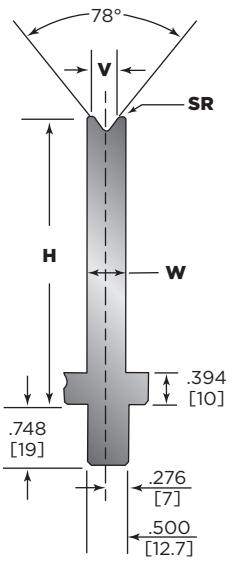
60° SINGLE V DIE



Cat. No.	V Opening in. [mm]	H Height in. [mm]	W Width in. [mm]	SR Shoulder Radius in. [mm]	kN/m	Max. Ton ft. [m]	250 9.8" [250mm]	510 20" [510mm]	550S Sectional 21.6" [550mm]
90mm Tall Dies									
TP00115	1.181 [30]	3.543 [90]	1.654 [42]	.118 [3]	1,050	35 [116]			
TP00127	1.575 [40]		2.165 [55]	.157 [4]	1,300	27 [143]			
TP00133	1.969 [50]		2.756 [70]		1,780	60 [196]			
TP00138	2.363 [60]		2.953 [75]	.197 [5]	1,700	57 [187]			
TP00146	3.150 [80]		4.331 [110]	.236 [6]	1,850	62 [204]			
130mm Tall Dies									
TP00116	1.181 [30]	5.118 [130]	1.654 [42]	.118 [3]	1,050	35 [116]			
TP00128	1.575 [40]		2.165 [55]	.157 [4]	1,300	44 [143]			
TP00134	1.969 [50]		2.756 [70]		1,780	60 [196]			
TP00139	2.363 [60]		2.953 [75]	.197 [5]	1,700	57 [187]			
TP00147	3.150 [80]		4.331 [110]	.236 [6]	2,500	83 [275]			
TP00154	3.937 [100]		4.921 [125]	.236 [6]	2,700	83 [275]			
TP00157	4.724 [120]		5.512 [140]	.315 [8]	1,800	55 [184]			

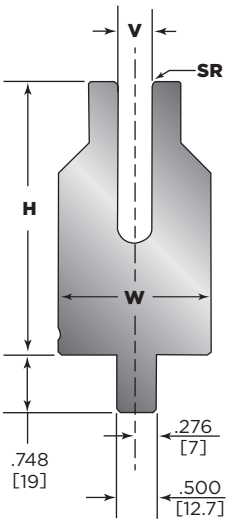
78° SINGLE V DIE

Cat. No.	V Opening in. [mm]	H Height in. [mm]	W Width in. [mm]	SR Shoulder Radius in. [mm]	kN/m	Max. Ton ft. [m]	250 9.8" [250mm]	510 20" [510mm]	550S Sectional 21.6" [550mm]
90mm Tall Dies									
TP00079	.236 [6]	3.543 [90]	.394 [10]	.031 [0.8]	280	9 [31]			
TP00083	.315 [8]		.472 [12]		320	11 [35]			
TP00087	.394 [10]		.551 [14]	.039 [1.0]	360	12 [40]			
TP00091	.472 [12]		.709 [18]	.047 [1.2]	500	17 [55]			
TP00099	.630 [16]		.984 [25]	.063 [1.6]	700	23 [77]			
TP00107	.787 [20]		1.181 [30]	.079 [2.0]	750	25 [83]			
TP00111	.945 [24]		1.260 [32]	.094 [2.4]	930	31 [102]			
TP00117	1.181 [30]		1.575 [40]	.118 [3]	1,150	39 [127]			
TP00129	1.575 [40]		1.969 [50]	.157 [4]	1,350	45 [149]			
TP00135	1.969 [50]		2.559 [65]	.157 [4]	1,800	60 [198]			
TP00140	2.363 [60]		2.953 [75]	.197 [5]	2,000	67 [220]			
TP00148	3.150 [80]		3.740 [95]	.236 [6]	2,300	77 [253]			
130mm Tall Dies									
TP00080	.236 [6]	5.118 [130]	.394 [10]	.031 [0.8]	280	9 [31]			
TP00084	.315 [8]		.472 [12]		320	11 [35]			
TP00088	.394 [10]		.551 [14]	.039 [1.0]	360	12 [40]			
TP00092	.472 [12]		.709 [18]	.047 [1.2]	500	17 [55]			
TP00100	.630 [16]		.984 [25]	.063 [1.6]	700	23 [77]			
TP00108	.787 [20]		1.181 [30]	.079 [2.0]	750	25 [83]			
TP00112	.945 [24]		1.260 [32]	.094 [2.4]	930	31 [102]			
TP00118	1.181 [30]		1.575 [40]	.118 [3]	1,150	39 [127]			
TP00130	1.575 [40]		1.969 [50]	.157 [4]	1,350	45 [149]			
TP00136	1.969 [50]		2.559 [65]	.157 [4]	1,800	60 [198]			
TP00141	2.363 [60]		2.953 [75]	.197 [5]	2,000	67 [220]			
TP00149	3.150 [80]		3.740 [95]	.236 [6]	2,300	77 [253]			



HEMMING DIE

Cat. No.	V Opening in. [mm]	H Height in. [mm]	W Width in. [mm]	SR Shoulder Radius in. [mm]	kN/m	Max. Ton ft. [m]	250 9.8" [250mm]	510 20" [510mm]	550S Sectional 21.6" [550mm]
90mm Tall Dies									
TP00189	.315 [8]	3.543 [90]	1.969 [50]	.031 [8]	360	12 [40]			
TP00190	.394 [10]			.039 [1.0]	300	10 [33]			
TP00191	.472 [12]			.047 [1.2]	210	7 [23]			
130mm Tall Dies									
TP00192	.315 [8]	5.118 [130]	1.969 [50]	.031 [8]	360	12 [40]			
TP00193	.394 [10]			.039 [1.0]	300	10 [33]			
TP00194	.472 [12]			.047 [1.2]	210	7 [23]			



SPECIAL TOOLING


EUROPEAN


WT-STYLE


AMERICAN

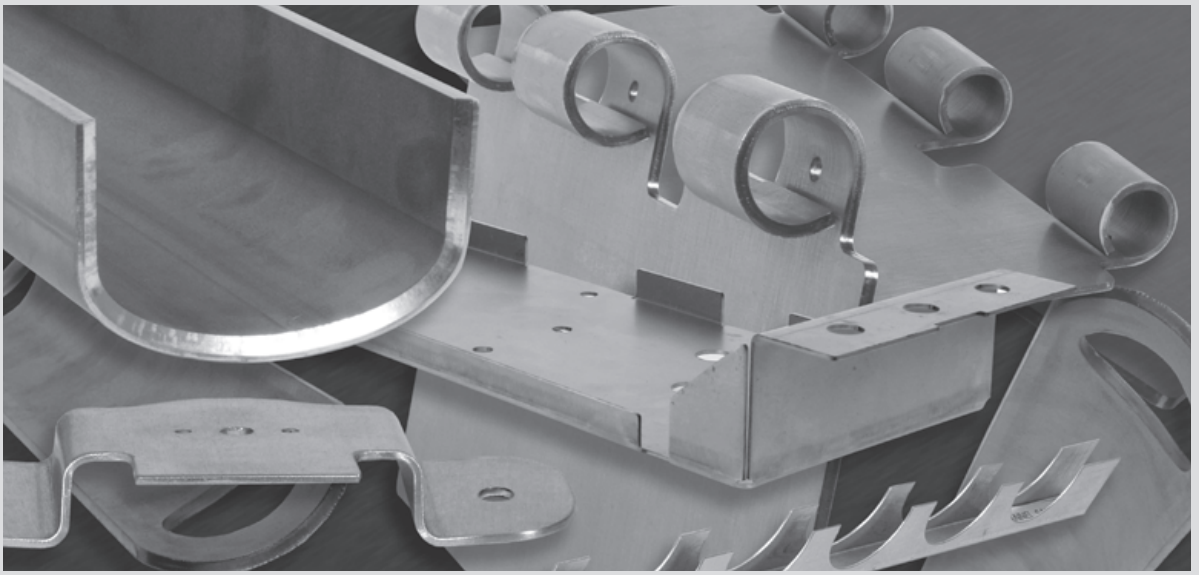

RFA-STYLE

CHALLENGE OUR "NEVER SAY NO" ATTITUDE

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

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

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



BRAKE PARTNER®

Make Punch Press Forms in the Press Brake

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

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

Enjoy These Cost Saving Benefits

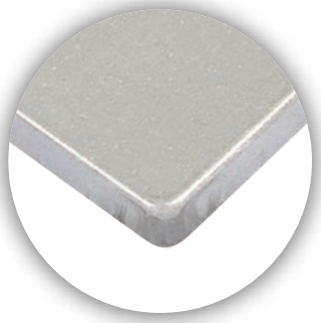
- Reduce press brake special tooling costs
- Punch press tooling has shorter lead times
- Put your existing press brakes to work on applications that were previously impossible on a punching machine
- Reduce outsourcing of punching applications
- Streamline equipment usage and create more flexibility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

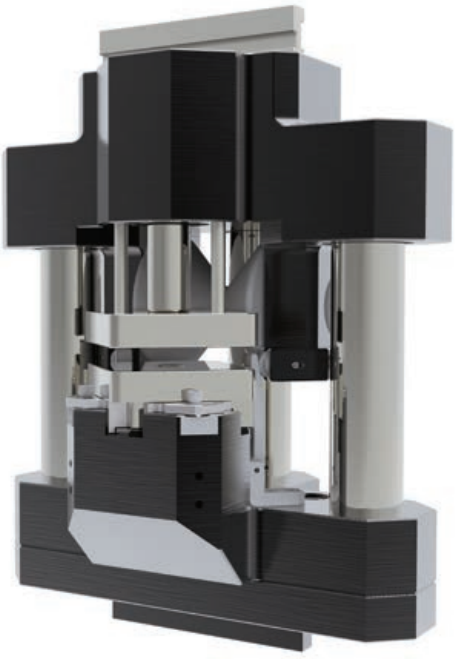
Scan QR Code to Watch the Video

SPECIALS

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.

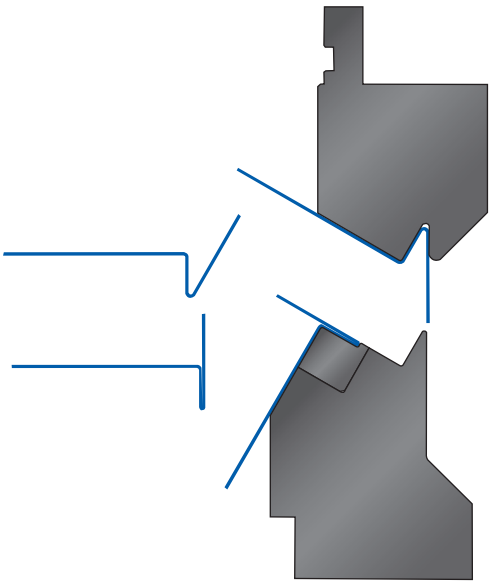
Step 2: Corner Former
After the engineered flare, the part is moved to the corner forming step to roll the edge. You now have a complete corner with extra material that needs to be trimmed.

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

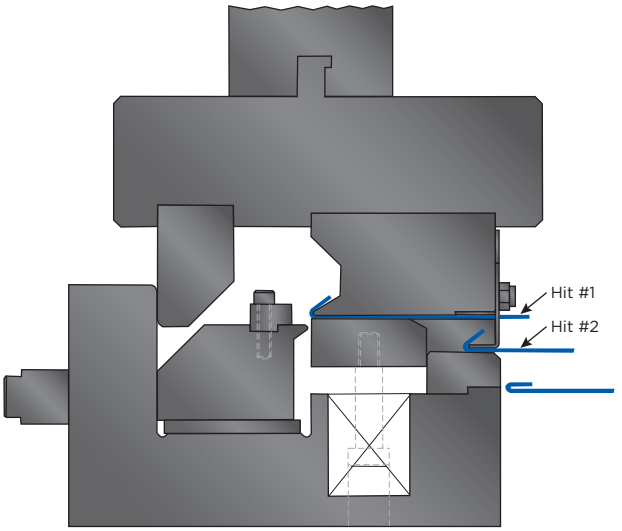
Scan QR Code to See How Much You Can Save

CUSTOM HEMMING

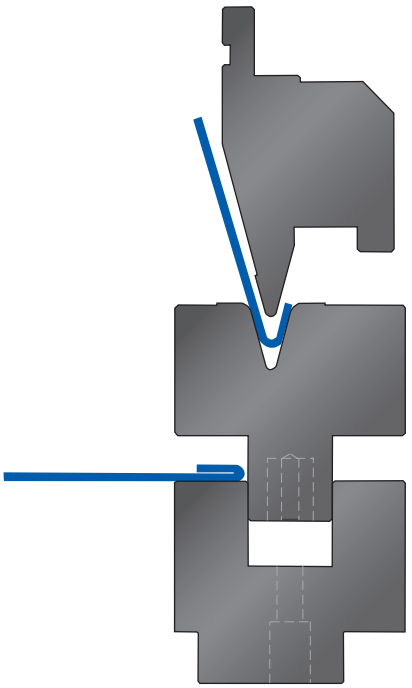


AH1 — ANGLE HEM

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

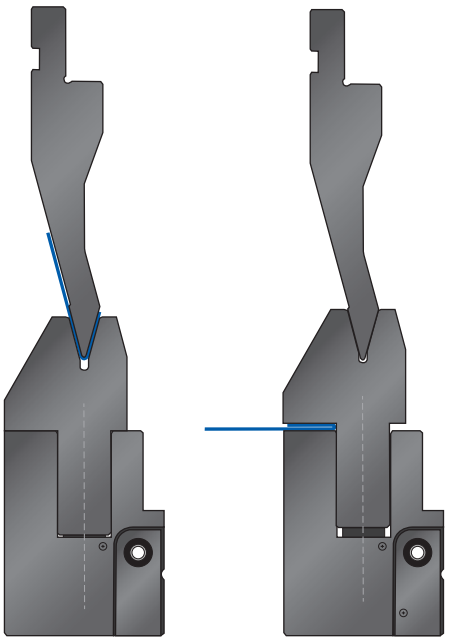


FSH1 — FLAT SHEET HEM



HDH1 — HEAVY DUTY HEM

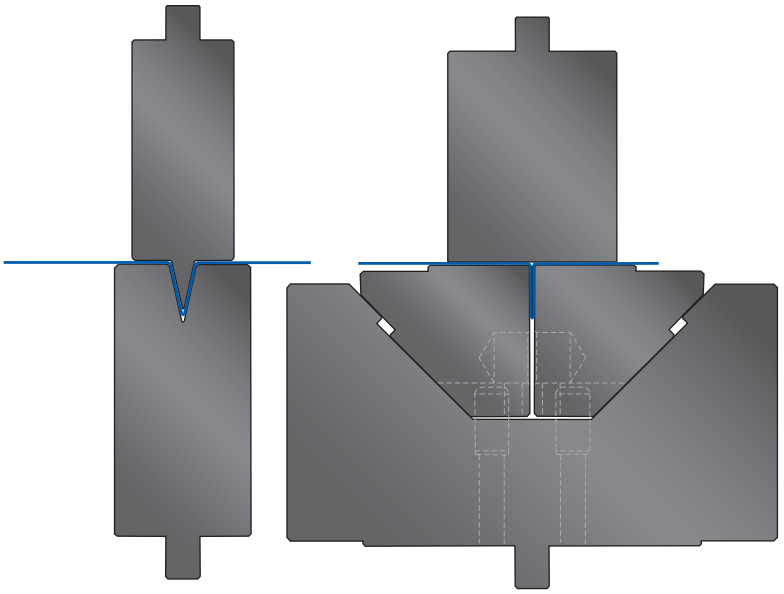
Heavy duty hemming for thick gauge applications.



PH1 — PNEUMATIC HEM

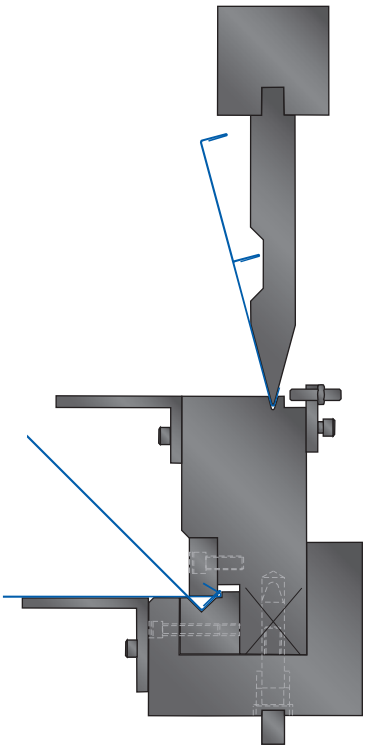
This tool set introduces pneumatic cylinders to rapidly open and close the pre-form insert. This set removes the inconsistency associated with pre-forming or acute bending on a spring actuated insert.

CUSTOM HEMMING

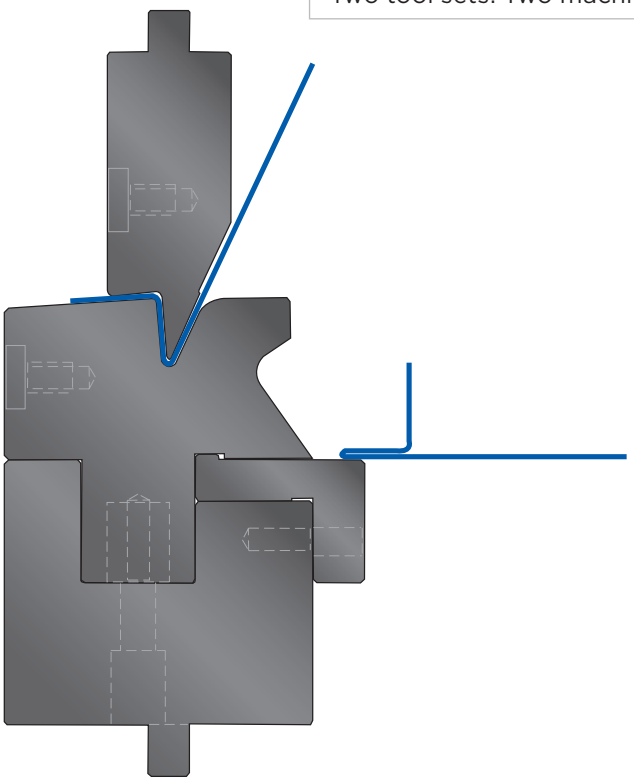


SH1 — SEAM HEM

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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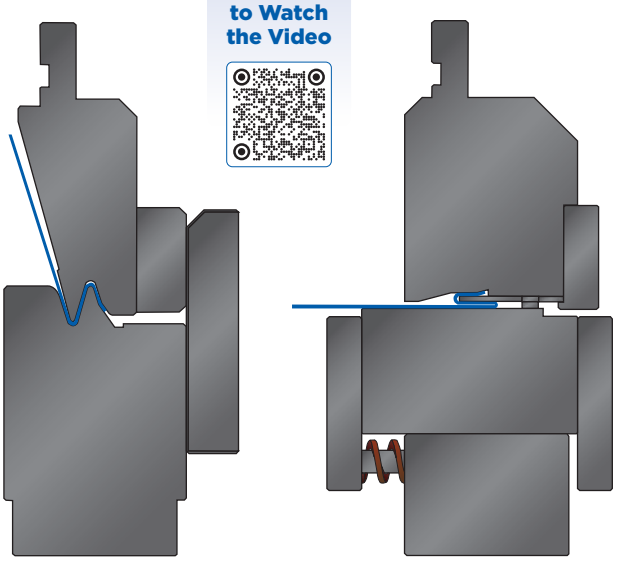
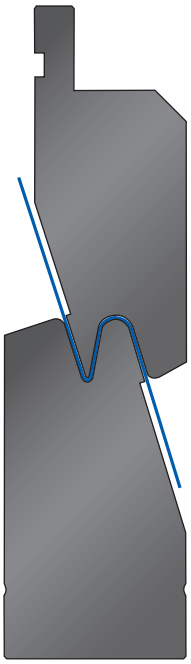


ZH1 — Z HEM

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



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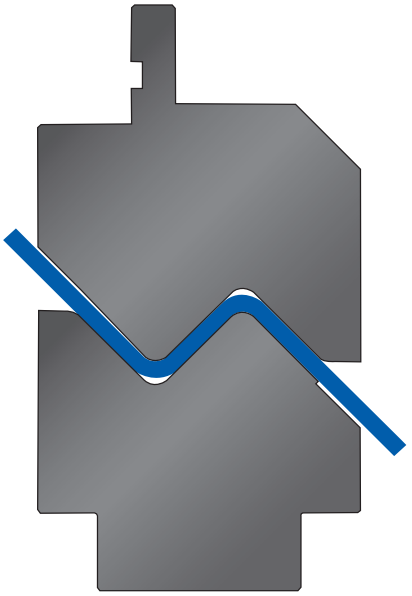
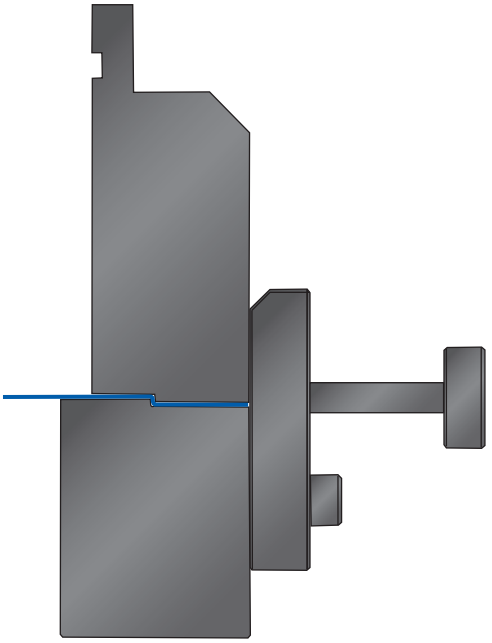
AO1 — ANGLED OFFSET



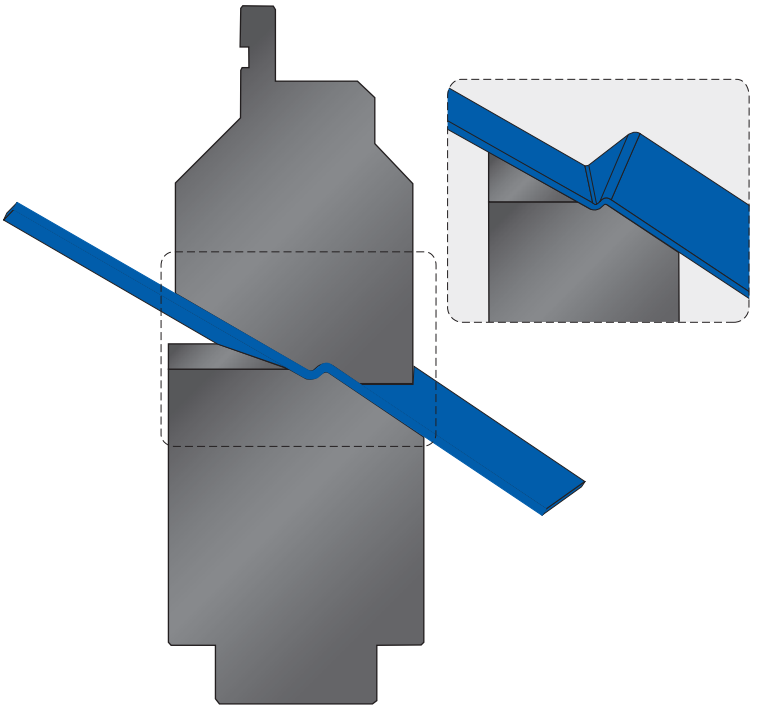
LO1 — LARGE OFFSET

Used for heavy gauge, large offset bending.



HO1 — HORIZONTAL OFFSET

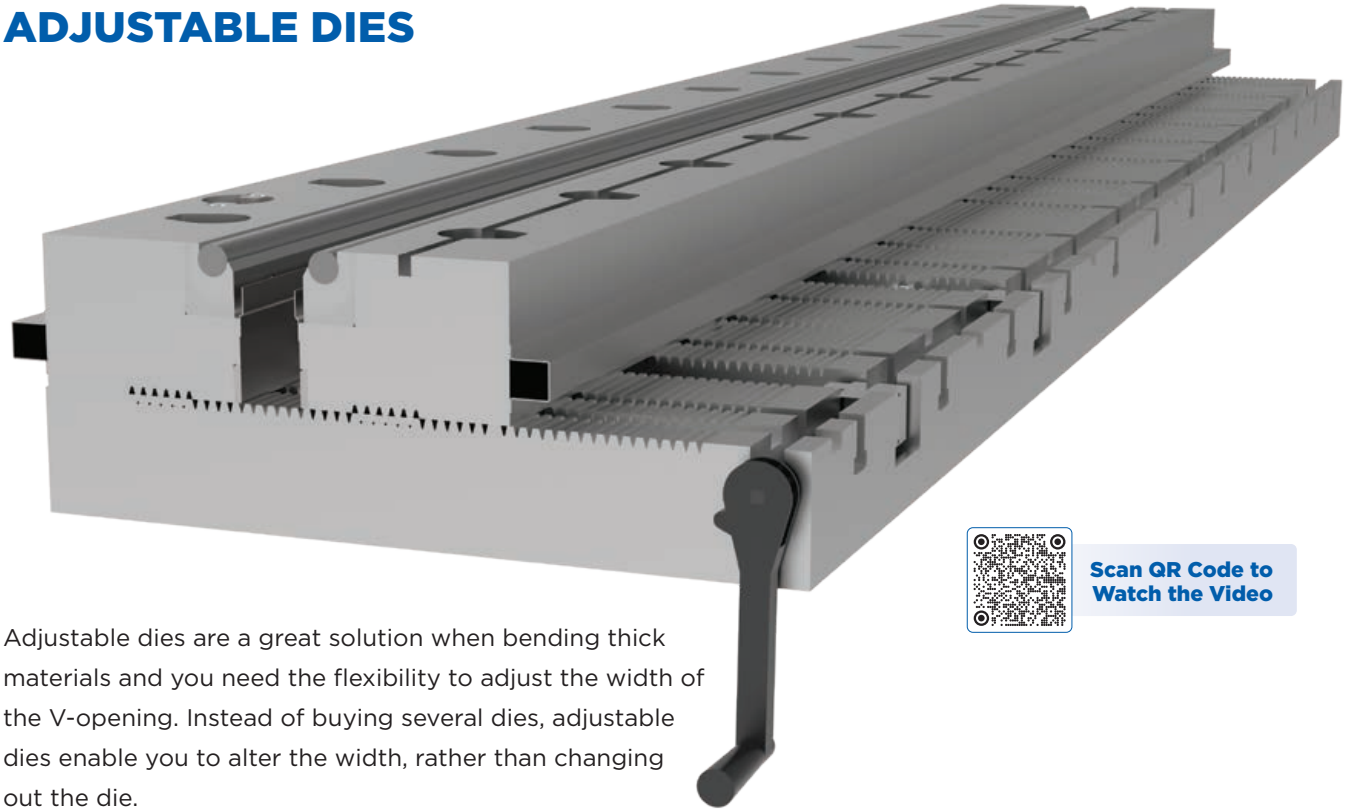
For offsets that are approximately one material thickness. Prevents material whip up. Thrust plates and adjustable back gauging are provided.



NPO1 — NON PARALLEL OFFSET

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

ADJUSTABLE DIES



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

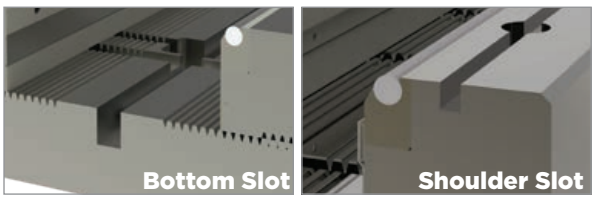
Adjustable Die Features

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

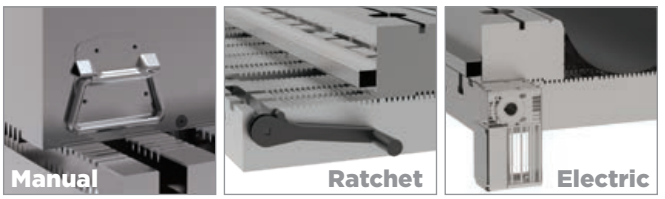
Adjustable Die Options

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

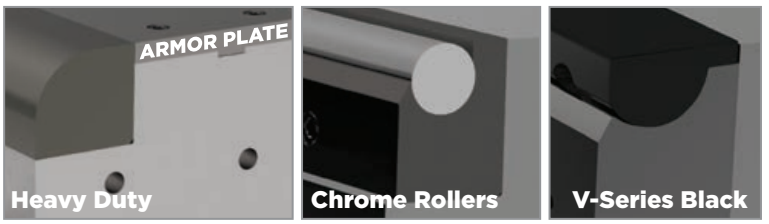
Die Holder Slots



Opening Adjustments



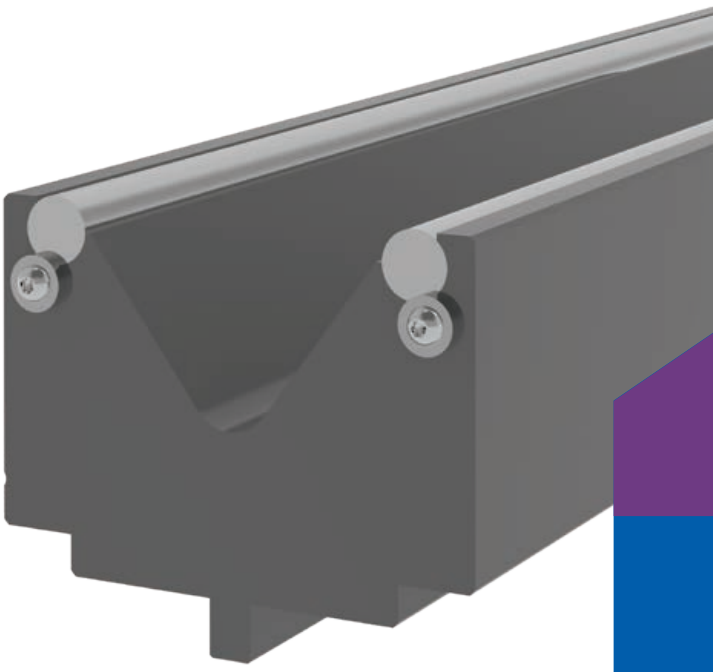
Shoulder Inserts



REPLACEABLE SHOULDER DIES

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

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



Scan QR Code for More Thick Material Solutions

DOVETAIL HOLDER AND RADIUS

Lighten Your Load with Two-Piece Punches

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

Replaceable Radius Punch Highlights

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

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

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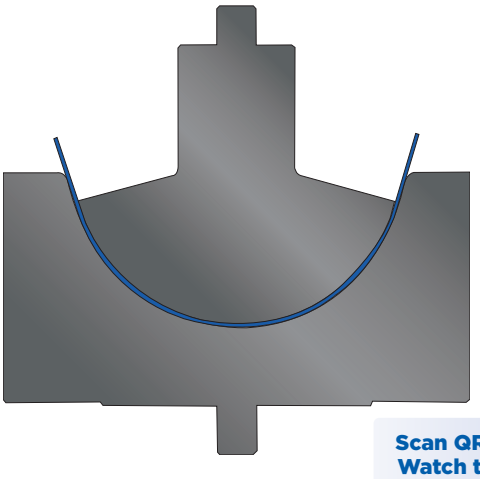
LARGE RADII



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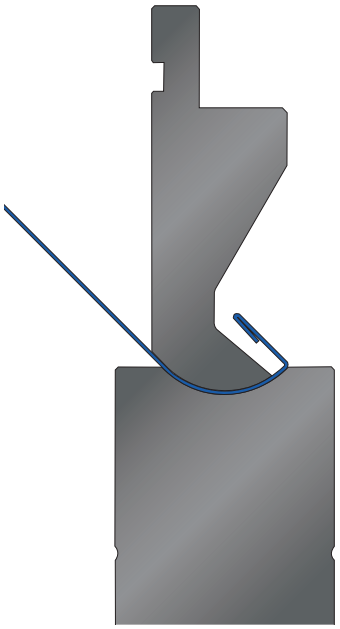
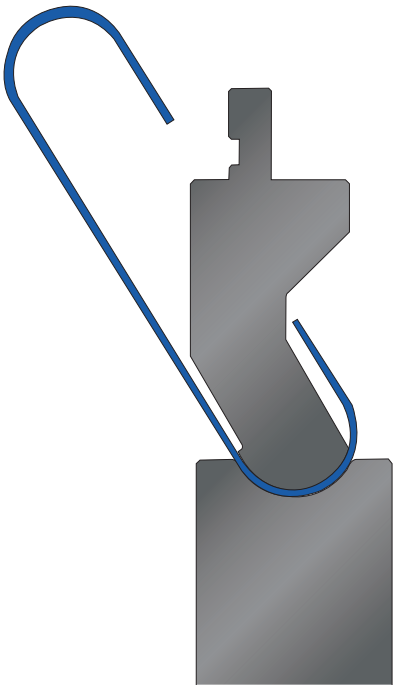
LR1 — LARGE RADIUS

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



LR2 — MULTI-HIT RADIUS

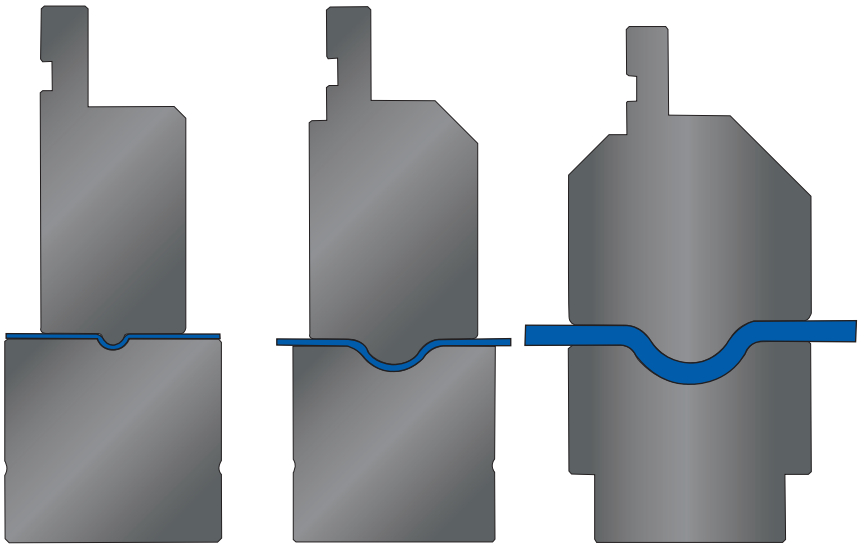
Used when a full radius is required before the flange. The solution may require multiple strokes.



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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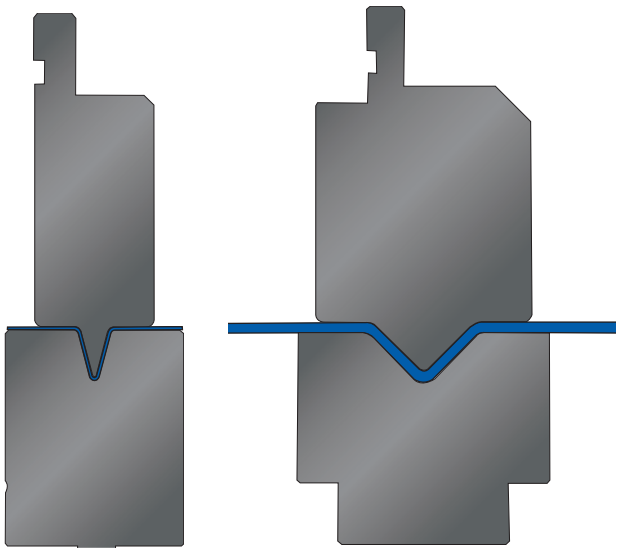
SR1 — STRENGTHENING RIB

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

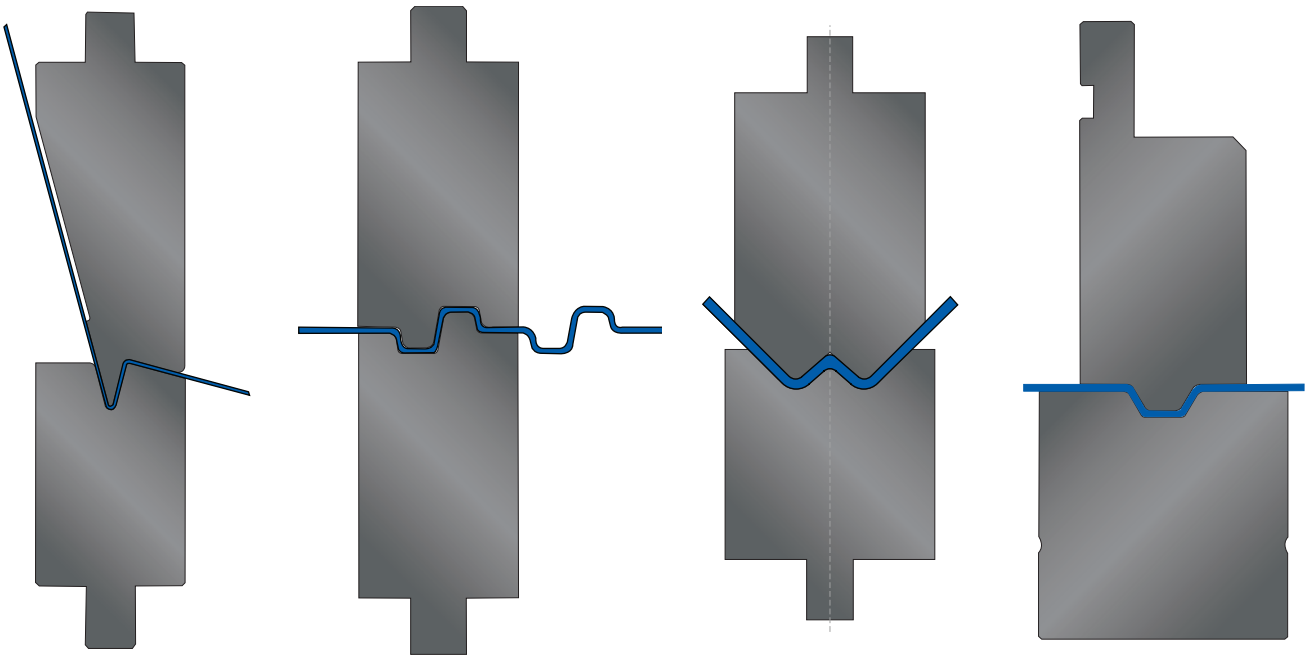
V-RIB



VR1 — V RIB

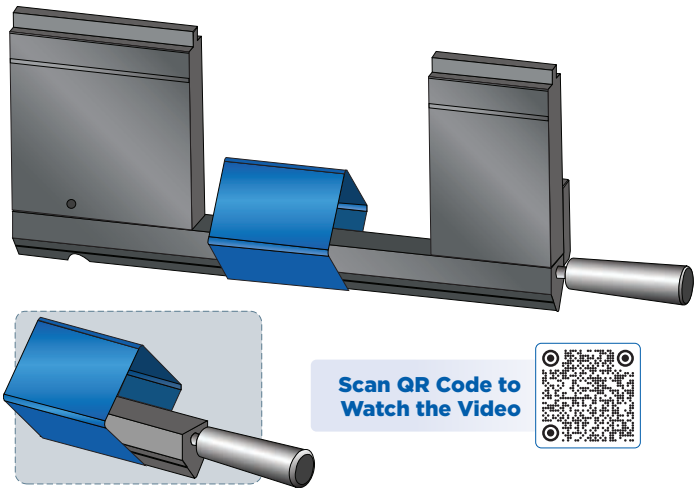
Produce a V rib in one stroke. Spring back allowance is built in.

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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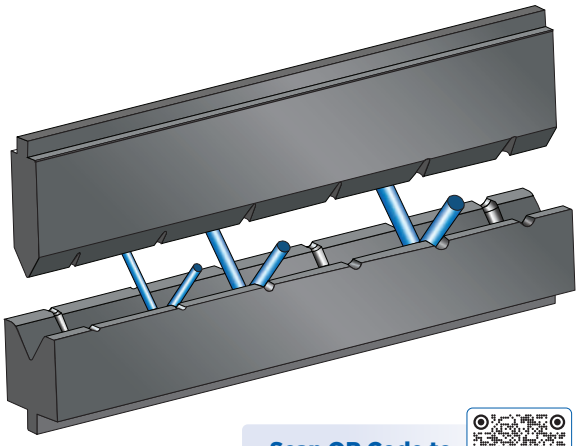
W1 — WINDOW

Used when minimum return flange clearance is required.



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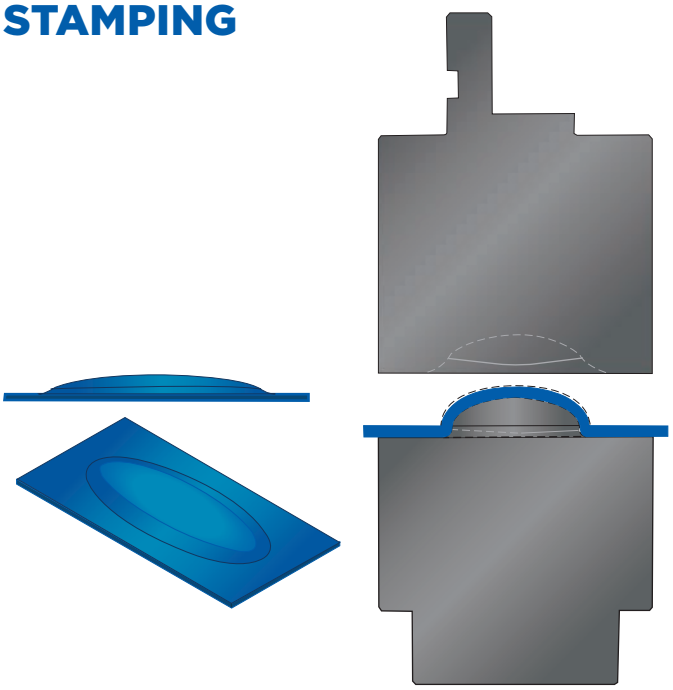
RB1 — ROD BENDING

Provides nesting for the rod during the forming process.

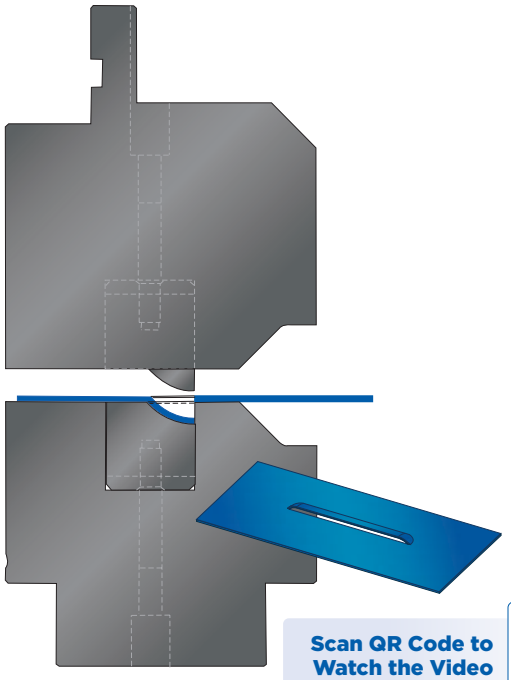
STAMPING



EM1 — EMBOSS

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

LG1 — LOGO



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LL1 — LOUVER

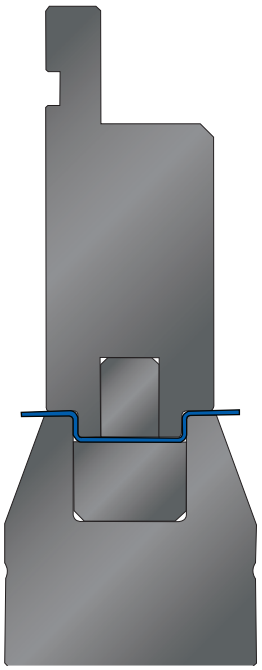
Multiple louver configurations are available. For louver forming, sheet must be pre-slit.

LS1 — LETTER STAMP

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

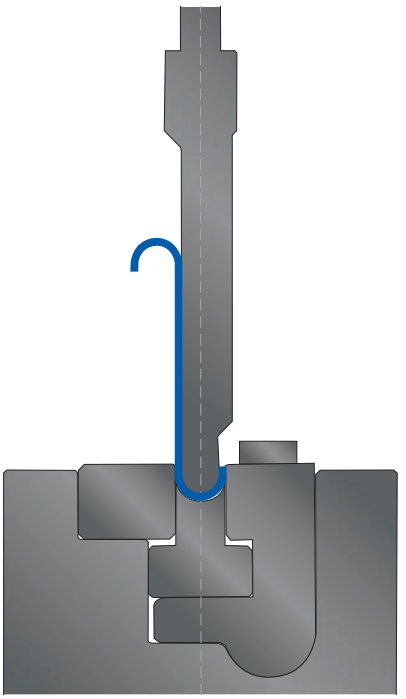
Part No.	Description	Size
6LSP25	Punch Character Holder	—
65300003-500	Flattening Block Die	—
6898	Characters (requires 26/row)	3/32″
6896	Characters (requires 20/row)	1/8″

MECHANICAL



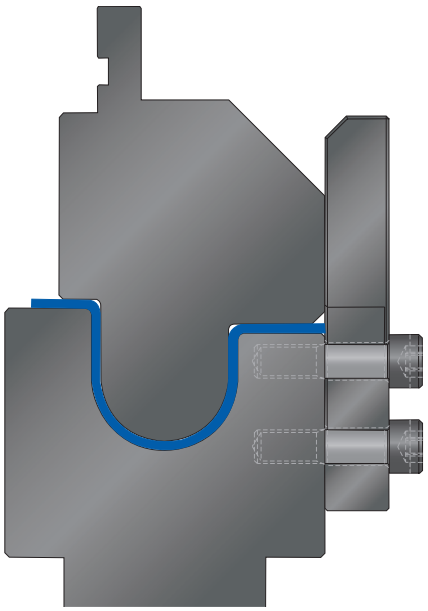
HT1 — HAT CHANNEL

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



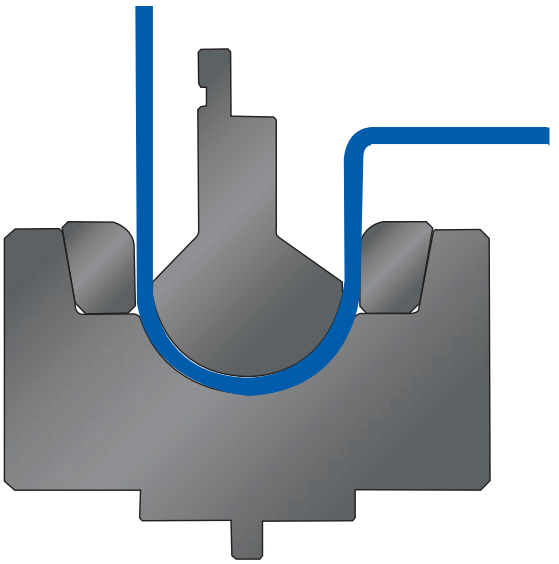
UC1 — U CHANNEL

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



UC2 — U CHANNEL

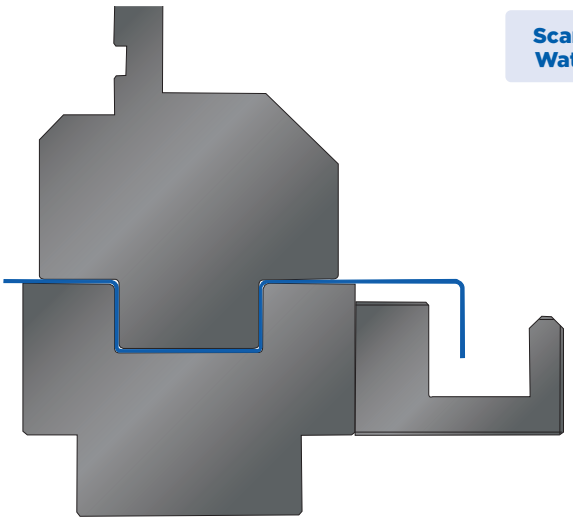
Recommended for applications where considerable spring back is encountered. Secondary flattening operations may be required.



UC3 — U CHANNEL

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

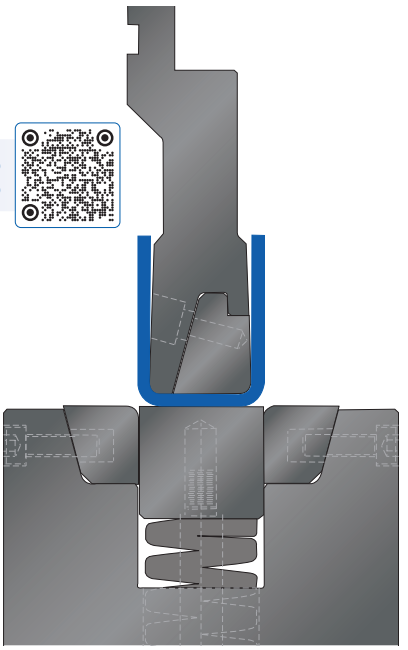
MECHANICAL



C1 — CHANNEL

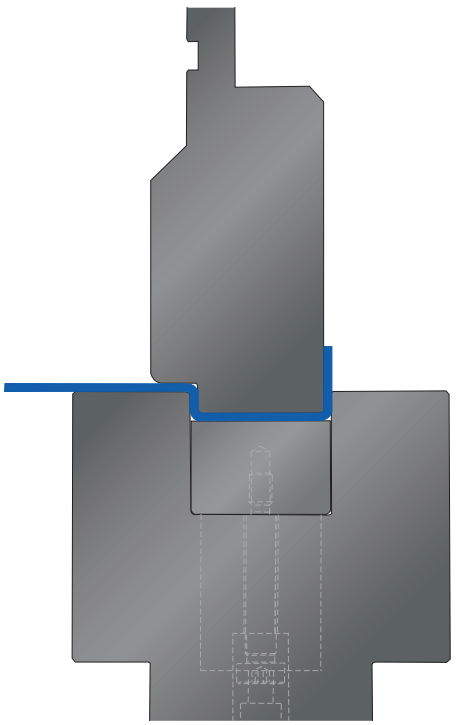
For deep channels when the channel bottom needs to remain flat.

Scan QR Code to Watch the Video



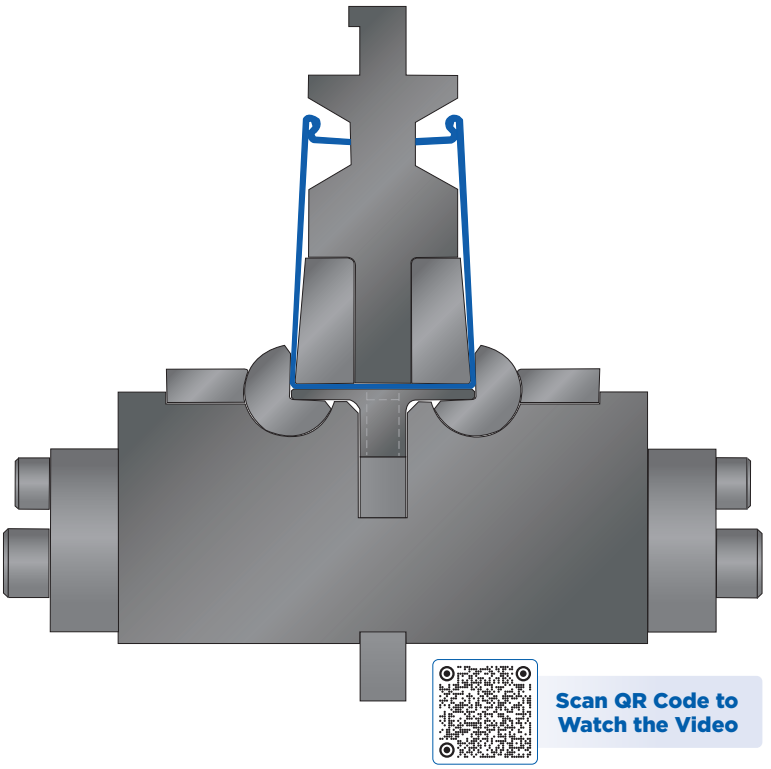
C2 — CHANNEL

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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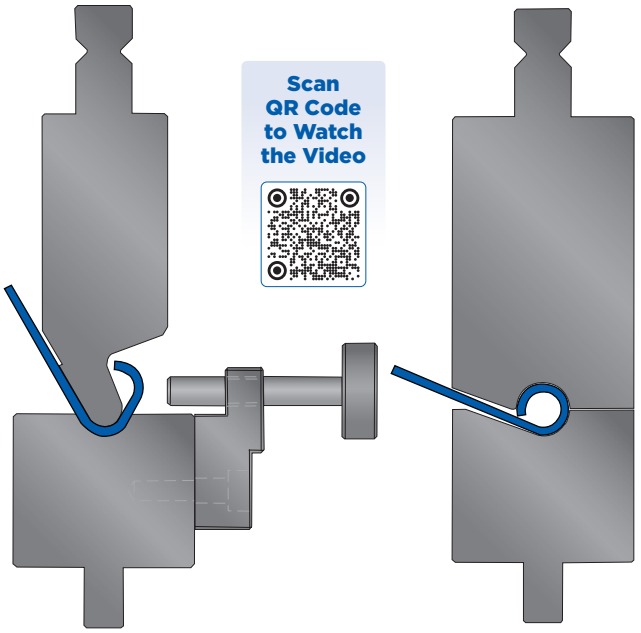
C4 — ROTARY BEND CHANNEL

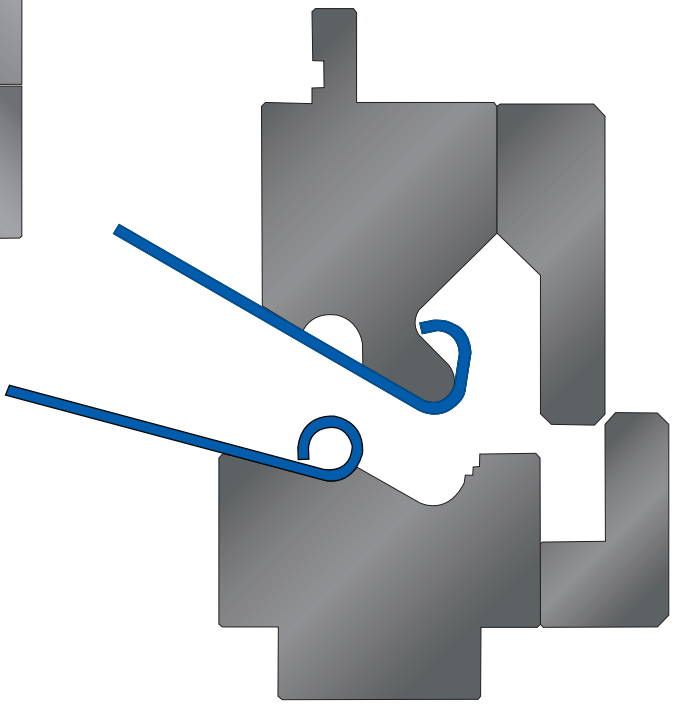
For deep channels when the channel bottom needs to remain flat.

MECHANICAL



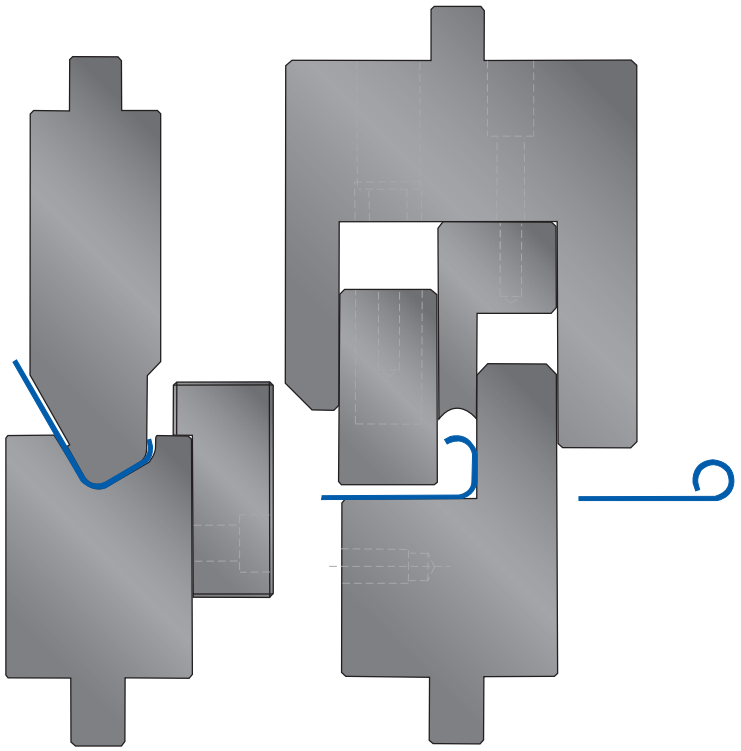
CL1 — CURL TOOL SET

Two tool sets, three machine strokes.



CL2 — CURL TOOL SET

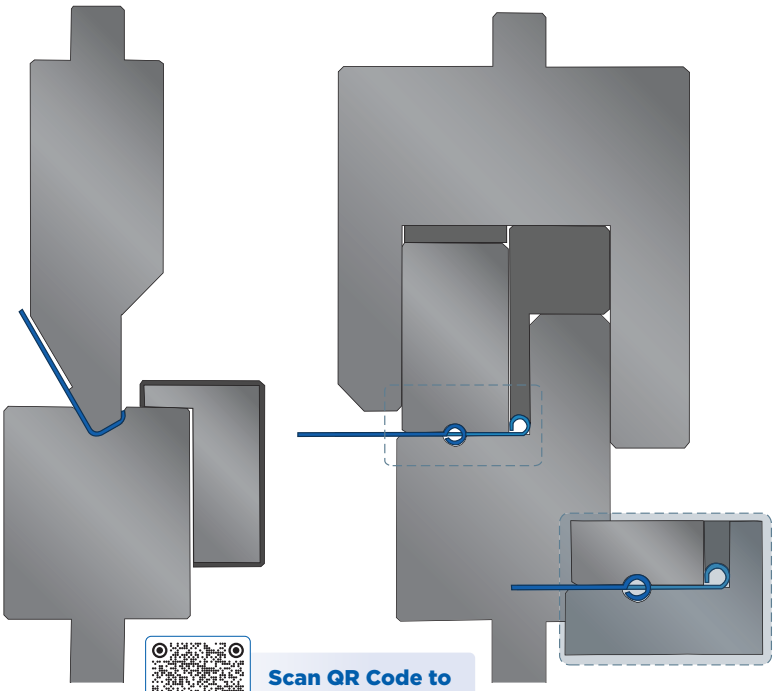
Typically used for thick materials and large diameter curls.
One tool set, three machine strokes.



CL3 — CURL

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

MECHANICAL



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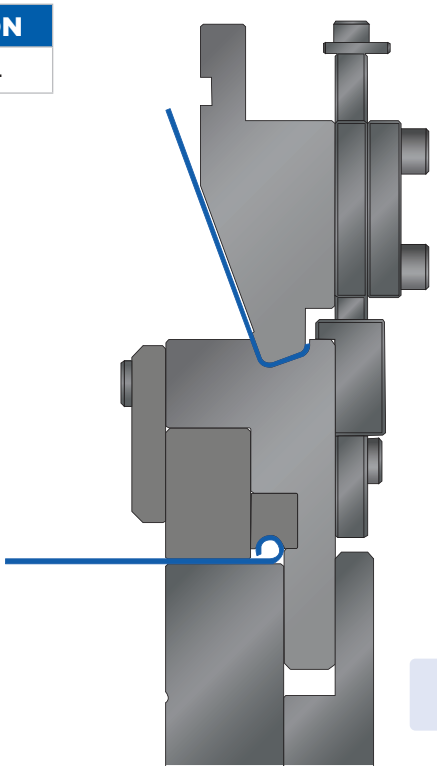
CL4 — CENTER CURL APPLICATION

Two tool sets, three machine strokes.

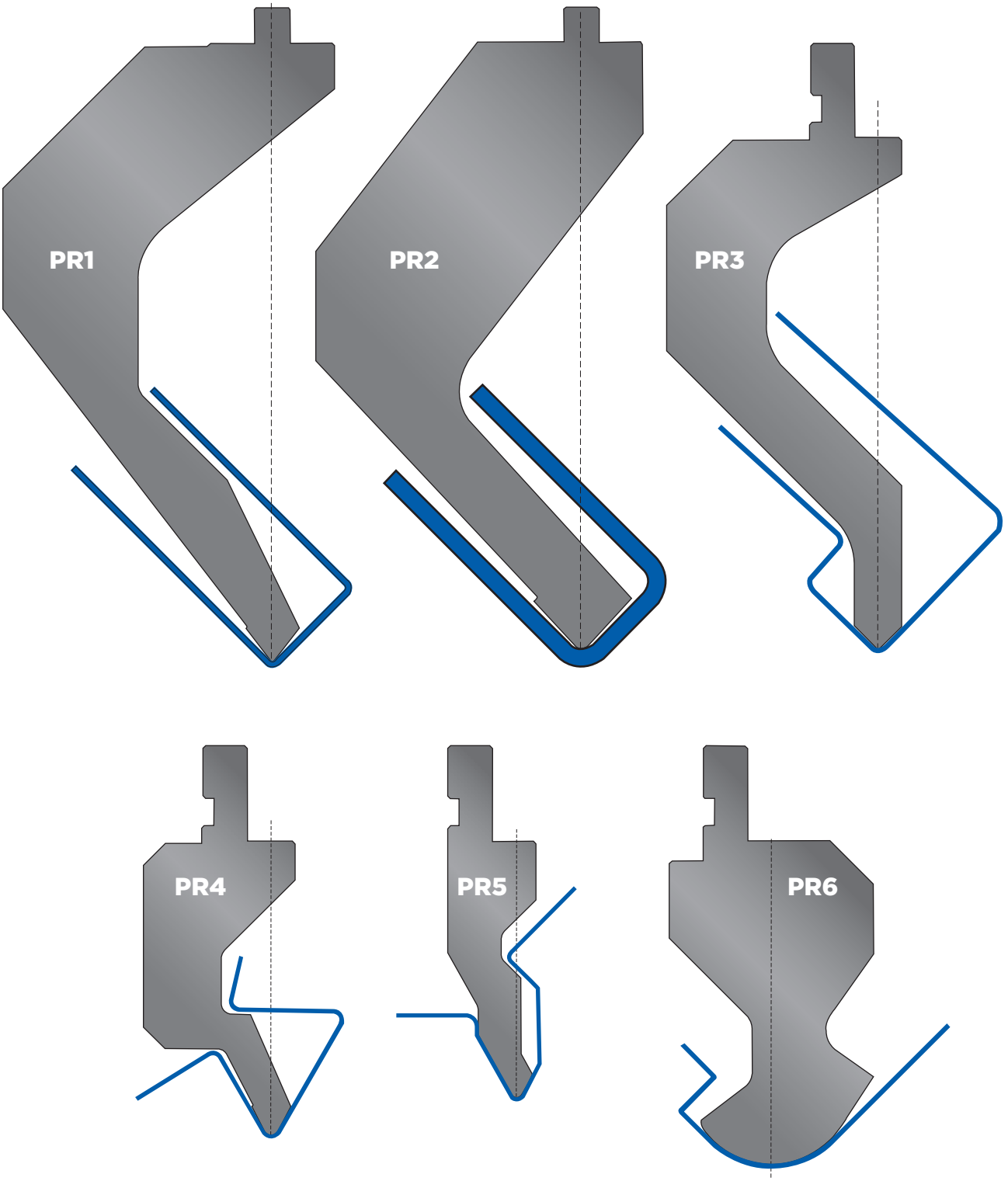


Scan QR Code to Watch the Video

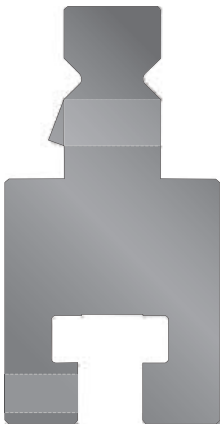
CL5 — DOUBLE DECKER TOOL SET

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

SPECIAL SHAPE PUNCHES

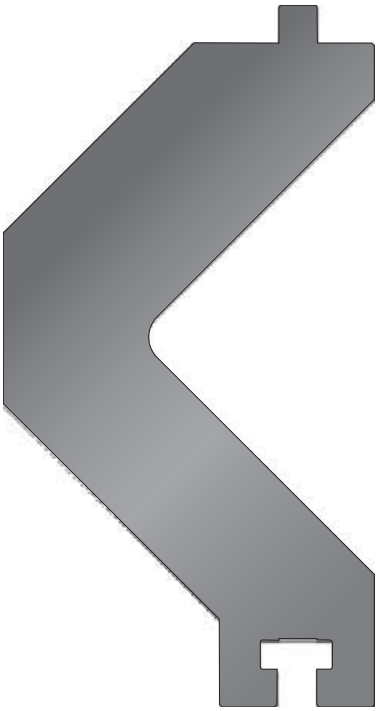


PUNCH HOLDERS

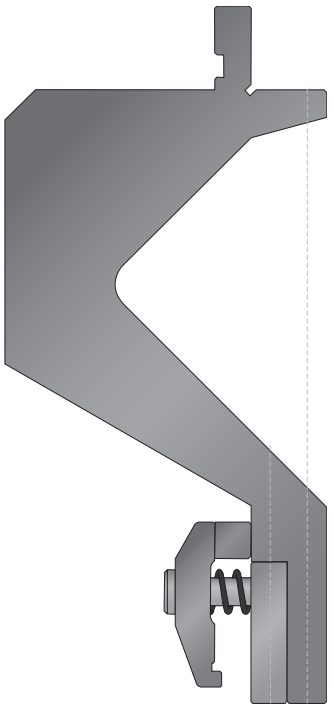


WT — AMERICAN
With Set Screws

AMERICAN SELF-SEAT HOLDER
WT to American with Clamp Plate



AMERICAN DEEP GOOSENECK HOLDER

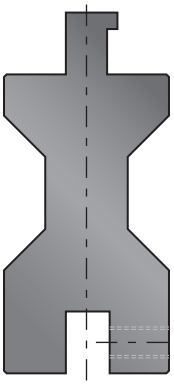


EURO Z1 OR Z2 CLAMPING
Part No. 43002

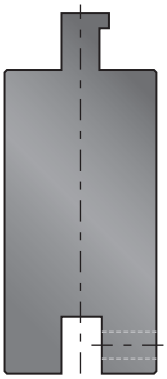
PUNCH HOLDERS

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.

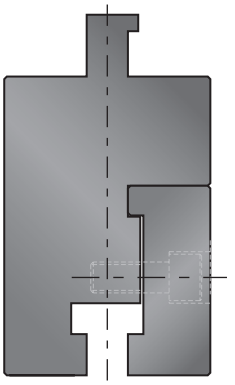
PUNCH HOLDERS



RA1 — DOG BONE



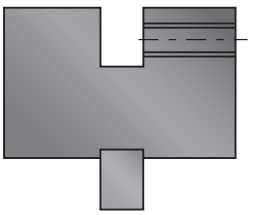
RA2 — SET SCREW



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.

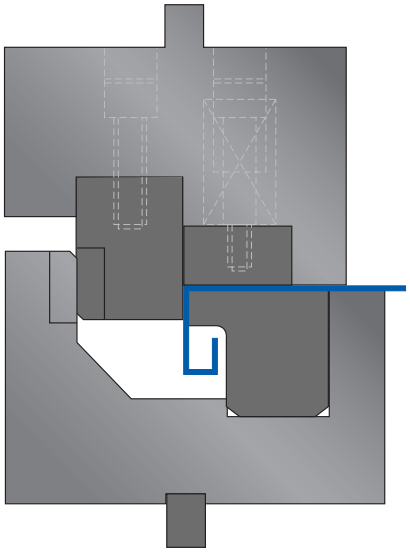
DIE HOLDERS



DIE HOLDERS

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

WIPING AND ROTARY BENDING



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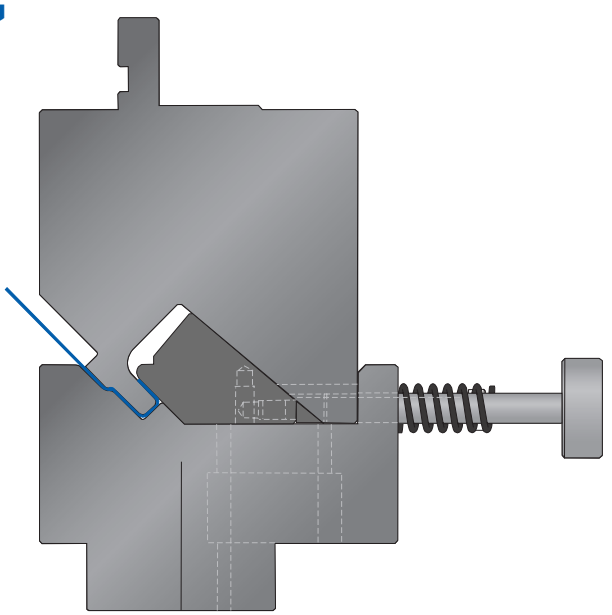
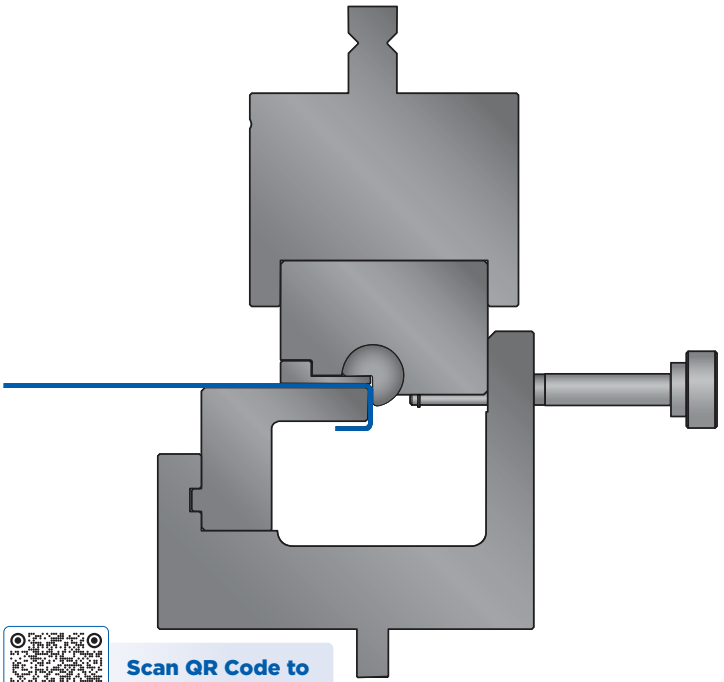


WD1 — WIPE DOWN

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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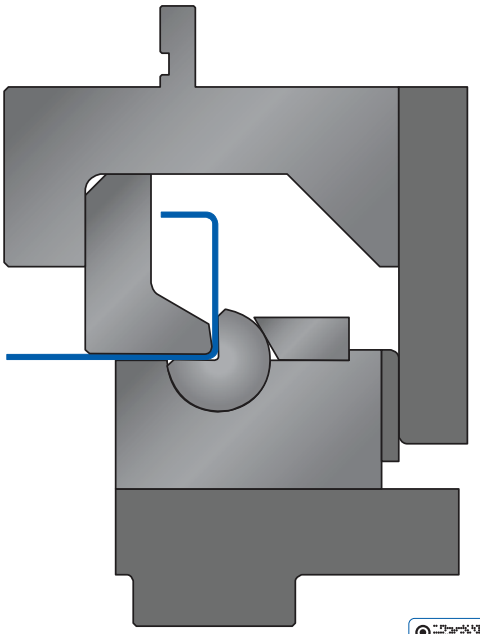
RTD — FORM DOWN



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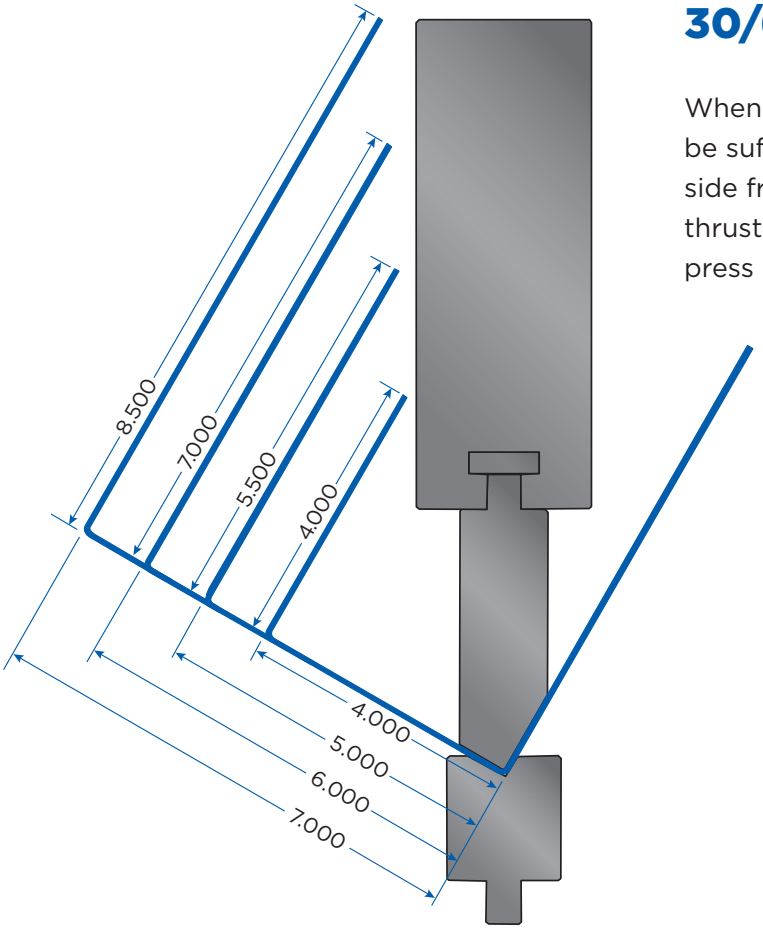
RTU — FORM UP

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

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

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

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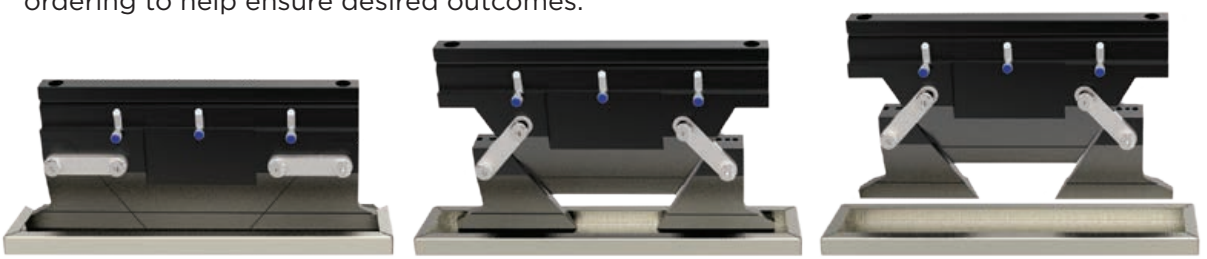


Left and right ear sections shown in illustration.

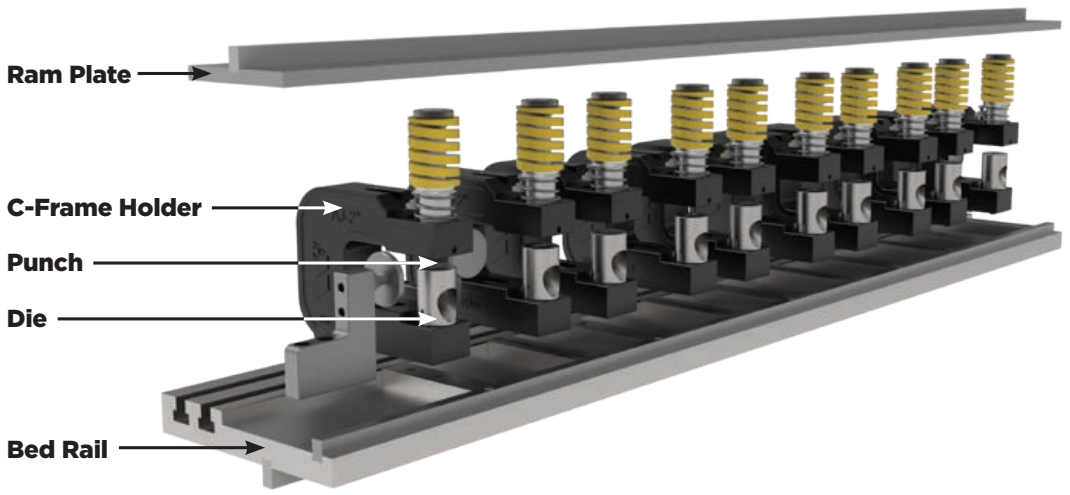
UNITIZED TOOLING

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

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

Scan QR Code to View the Catalog

Tooling shown below mounted on a bed rail.



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

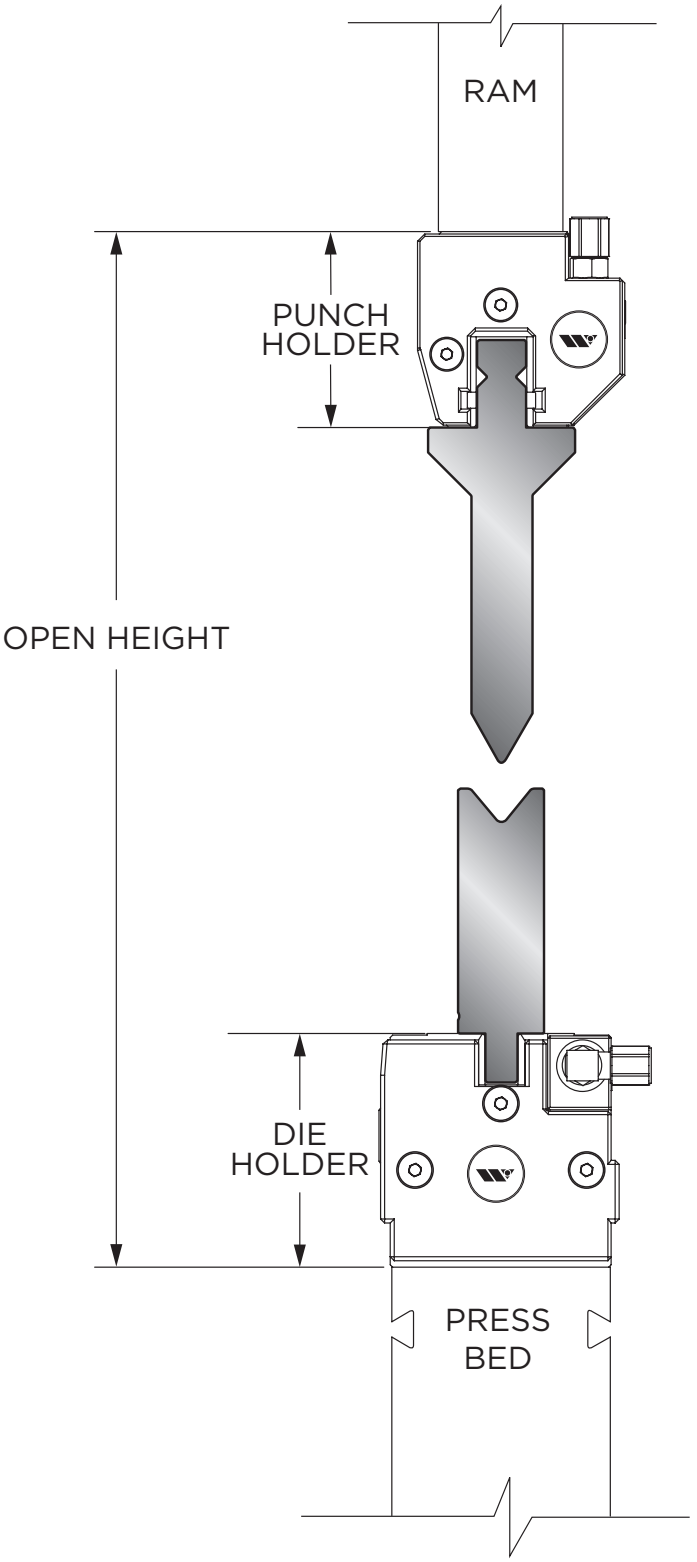
If YES, specify if this is a ☐ Wilson Tool Repeat ☐ Replicate Customer Tool ☐ Redesign

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



TONNAGE ESTIMATES

Making Multiple Bends Formula on a Press Brake

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

MULTIPLY METAL THICKNESS BY FACTOR = TONS PER FT.

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

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

AIR BENDING FORCE CHART

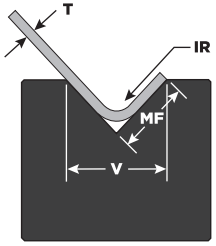
METRIC V-OPENINGS & IMPERIAL TONNAGE

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

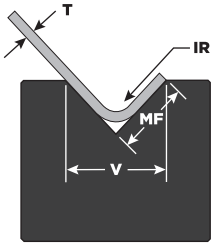
Mexico tel: 001.800.741.2510 doblez@wilsontool.com
Canada tel: 800.268.4180 bending@wilsontoolcanada.com
US Headquarters tel: 800.445.4518 bending@wilsontool.com

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]																		

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	Half Hard Brass, Copper = Tons x 1.1
	Stainless Steel = Tons x 1.5
	High Strength Steel = Tons x 2.75

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	**5103W**	**5104W**	**5105W**	**5106W**
Number of Drawers	3	4	5	6
Cabinet Height (outside dim.)	62″ [1575mm]	62″ [1575mm]	62″ [1575mm]	62″ [1575mm]
Width (left to right – outside dim.)	23″ [585mm]	30″ [762mm]	37″ [940mm]	44″ [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]

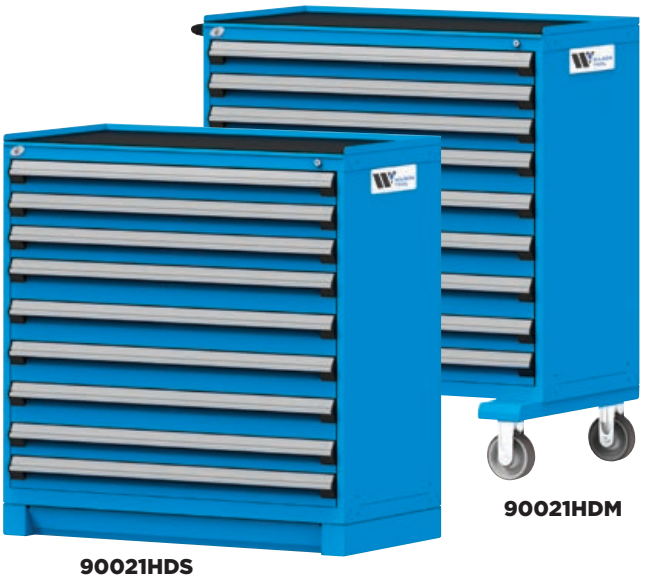
†W = European Style Tooling
*Total length does not include available storage in the top trays.

ACCESSORIES

TOOL STORAGE

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
- 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

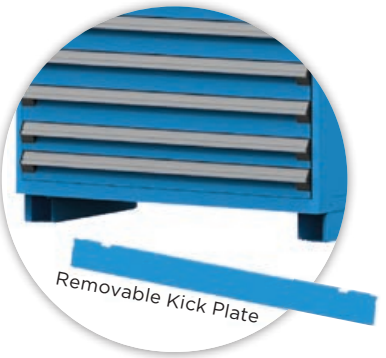


90021HDM

90021HDS

Additional cabinets available — Contact our Tooling Technicians for pricing and lead times.

Part No.	Description	W x D x H	Drawer Sizes
90021HDS	Stationary	48" x 27" x 49"	5 – 2.25" [57.1mm] 4 – 3.25" [82.5mm]
90021HDM	Mobile	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. Allow 15 working days lead time for custom colors.*

TOOL STORAGE & TRANSPORTATION

PRESS BRAKE TOOLING CHANGEOVER CART

- **Maximum Productivity:** Reduce setup time by staging tools and reducing motion; compatible with all styles of press brake tooling.
- **Superior Safety & Stability:** Features a wide-track wheelbase to prevent tip-overs and ergonomic shelving to promote safe lifting practices.
- **Heavy-Duty Construction:** Robotically MIG-welded steel with a 900 lb. caster capacity and a 75 lb. capacity drawer for precision instruments.
- **High Capacity:** Safely transport and organize up to 54 linear feet of tooling in one trip.

Technical Specifications

Feature	Specification
Cart Dimensions	39″ wide x 27″ deep x 38″ tall
Shipping Weight	275 lbs.
Tooling Capacity	54 linear feet; Max. tool length of 36″ [914mm]
Storage Drawer	35″ x 16″ x 3″ with ball bearing slides (75 lb. capacity)
Safety Features	Wide-track anti-tip base; Ergonomic lifting heights
Mobility	Four 6″ heavy-duty casters (900 lb. capacity ea.)
Caster Configuration	2 rigid; 2 swivel with brakes
Construction	Robotically MIG welded 16- & 18-gauge steel
Finish	Industrial grade durable powder coat

Ordering Information

Cat. No.	Tool Style
990956	**Eurpoean** Punch Tang: .500″ [12.7mm]
990958	**American** Punch Tang: .512″ [13mm]
990959	**WT** Punch Tang: .787″ [20mm]

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.

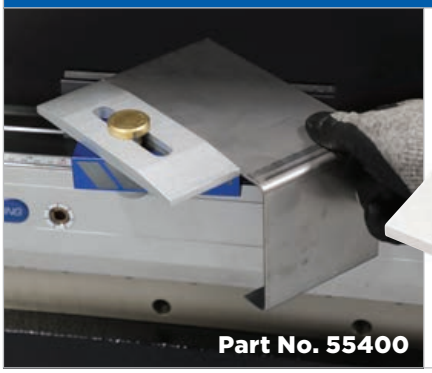
MAGNET SQUARE

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 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

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

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 • Well suited for deeper draw applications • Will not last as long as blue for 90° bends
42531	.030" [.8mm]		
42532	.022" [.56mm]	95A (Blue)	• A more ridged solution • Lasts considerably longer than the white options in many applications • Harder and less elastic than blue • Not suited for deeper draw applications

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

PROTECTIVE FABRIC DRAPE

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

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

DRAPE HOLDER

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

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.

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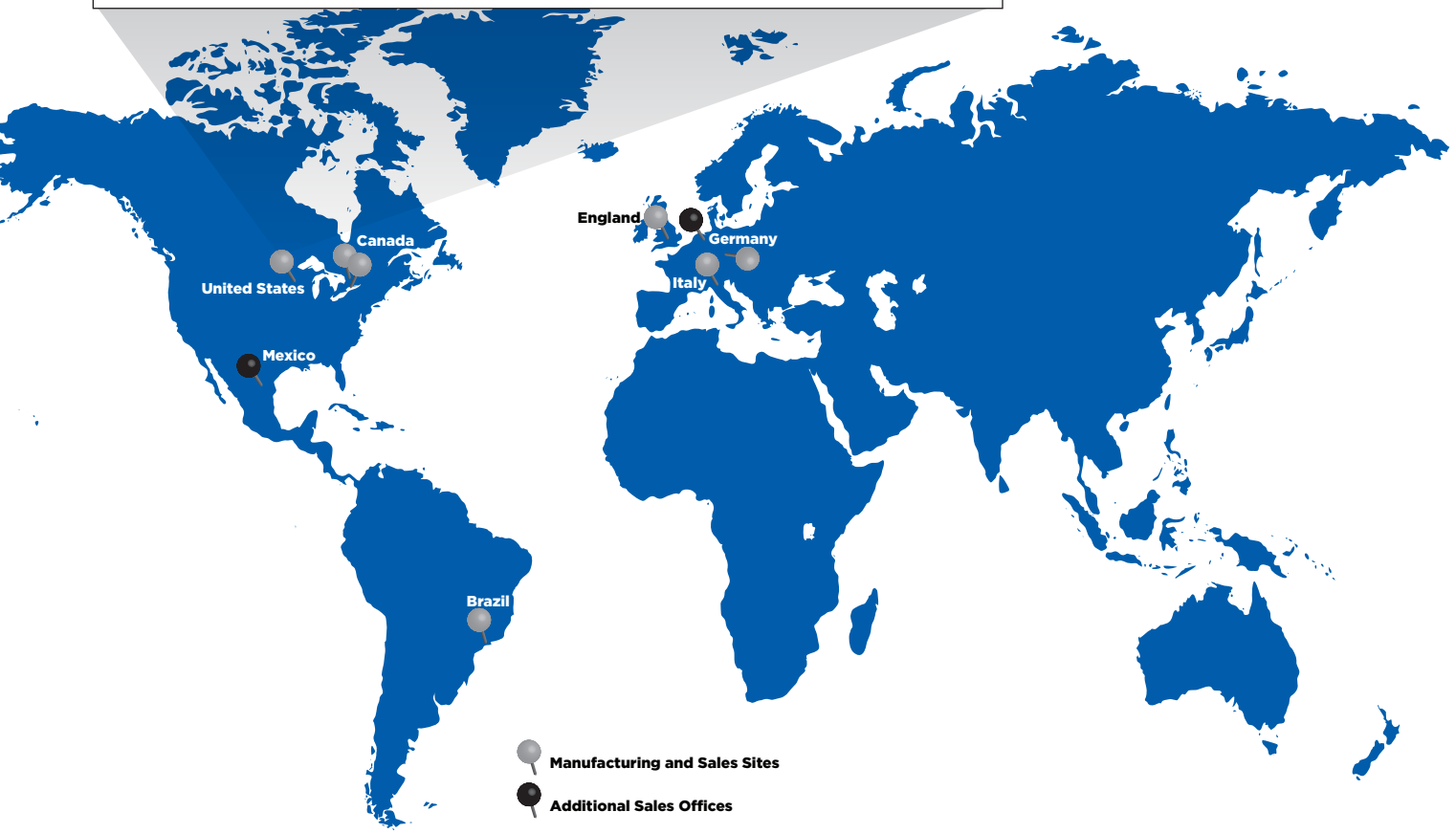

GUARANTEED TO OUTPERFORM

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

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