



THIN STRIPPIT

TURRET TOOLING SOLUTIONS

THIN STRIPPIT TURRET TOOLING SOLUTIONS



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ABOUT WILSON TOOL INTERNATIONAL

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

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

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

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

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



BENDING

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

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



facilities located in the USA and Canada, our delivery times to North American fabricators are the fastest in the industry.

STAMPING



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

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

PUNCHING

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

From the early days of Series 80 to the Wilson Wheel® Family to EXP® technology, our punching division has been the industry-leading innovation driver.

Combined with the most experienced customer support professionals in the industry, Wilson Tool continues to raise the bar. Thick turret, TRUMPF-style, Salvagnini-style, or any other style of punch press you may be using, Wilson Tool offers the most complete line of tooling solutions available today.



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

ACCESSORIES



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



HPX® 1-1/4" STATION

FAB STYLE



PUNCH AND GUIDE ASSEMBLY



EXP® PUNCH HOLDER



EXP® PUNCH



DIE

	CAT. NO.	PRICE
PUNCH AND GUIDE ASSEMBLY		
Round	10661	
Shape	10660	
Optima® Coating	—	
EXP® PUNCH HOLDER		
EXP® Punch Holder only	10627	
SPRING PACK ASSEMBLY		
Spring Pack Assembly only	10659	
PUNCH		
EXP® Round	13916	
EXP® Shape	13917	
Optima® Coating	—	
GUIDE		
Round	158	
Shape	159	
DIE		
Round Slug Hugger**	454	
Round Standard	133	
Shape Slug Hugger® 2*	10373	
Shape Positive	162	
Shape Negative	244	
<i>*Order Slug Hugger® dies punch size plus clearance. Size restrictions apply.</i>		
DIE SHIM		
.010" [0.25mm] Pack of 25	2209	
.030" [0.76mm] Pack of 25	2724	
.060" [1.5mm] Pack of 25	2173	
<i>Additional charges may apply to non-standard features. See pages 65-66.</i>		
REPLACEMENT PARTS		
O-Ring	466	
EXP® Punch Holder Key	10639	
Punch Pin	24097	
EXP® Punch Removal Key	6989	



SEE MORE HPX®

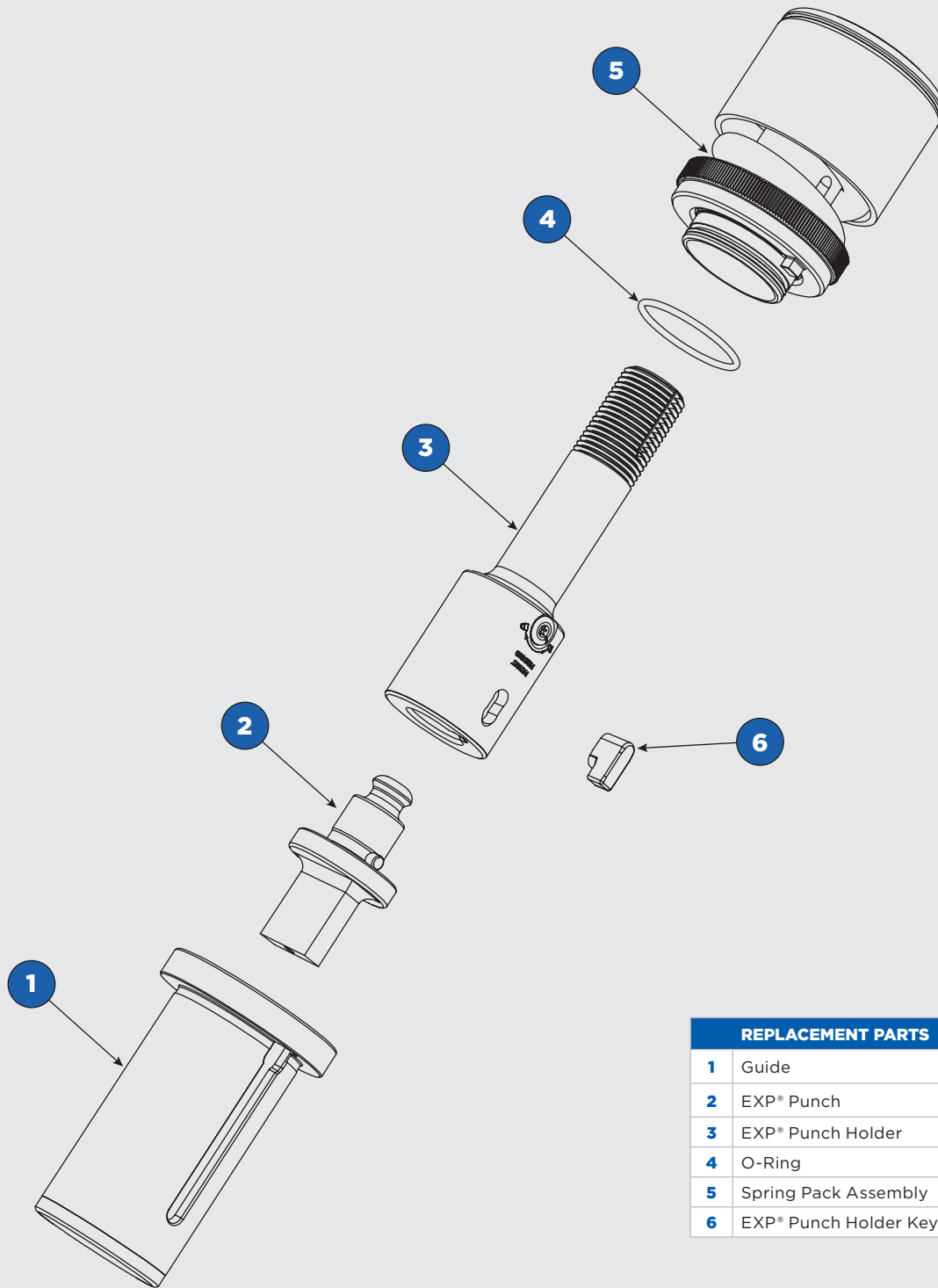


STANDARD SHAPE DIMENSIONS FLYER

STANDARD SHAPES *Non-standard shapes available. See page 54.*



HPX® 1-1/4" STATION REPLACEMENT PARTS



REPLACEMENT PARTS		CAT. NO.
1	Guide	See Opposite Page
2	EXP® Punch	See Opposite Page
3	EXP® Punch Holder	10627
4	O-Ring	985924
5	Spring Pack Assembly	10659
6	EXP® Punch Holder Key	10639

FAB STYLE

HP2 1-1/4" STATION

FAB STYLE



PUNCH AND GUIDE ASSEMBLY



DIE



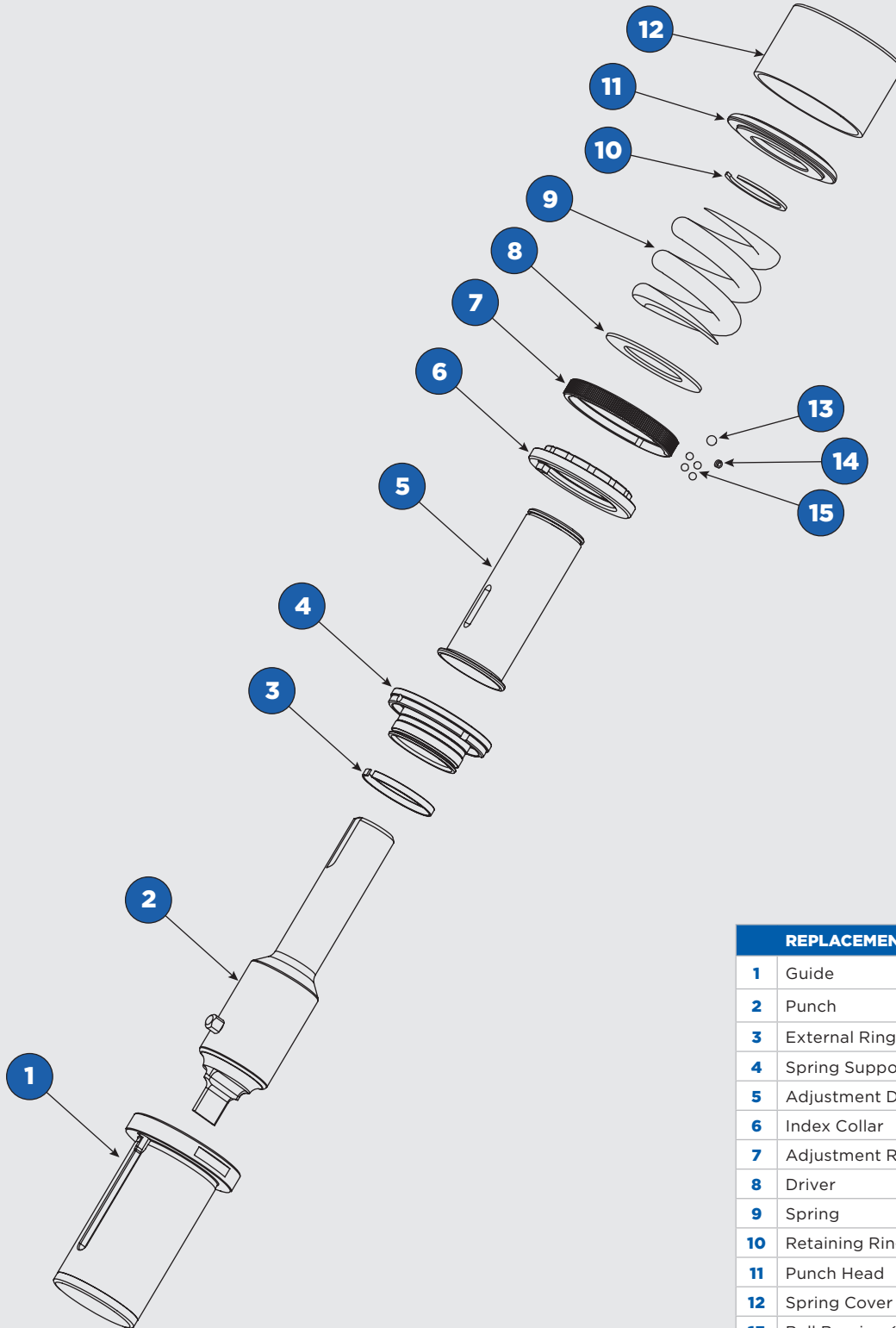
STANDARD SHAPE
DIMENSIONS
FLYER

	CAT. NO.	PRICE
PUNCH AND GUIDE ASSEMBLY		
Round	10662	
Shape	10663	
Optima® Coating	—	
SPRING PACK ASSEMBLY		
Spring Pack Assembly only	10649	
PUNCH		
Pinned Round**	10457	
Shape	161	
Optima® Coating	—	
<i>**HP2 assembly requires a pinned round punch. This is the replacement punch for Quick Adjust Assemblies.</i>		
GUIDE		
Round	158	
Shape	159	
DIE		
Round Slug Hugger**	454	
Round Standard	133	
Shape Slug Hugger® 2*	10373	
Shape Positive	162	
Shape Negative	244	
<i>*Order Slug Hugger® dies punch size plus clearance. Size restrictions apply.</i>		
DIE SHIM		
.010" [0.25mm] Pack of 25	2209	
.030" [0.76mm] Pack of 25	2724	
.060" [1.5mm] Pack of 25	2173	
<i>Additional charges may apply to non-standard features. See pages 65-66.</i>		
REPLACEMENT PARTS		
O-Ring	466	
Dowel Pin	6015	

STANDARD SHAPES Non-standard shapes available. See page 54.



HP2 1-1/4" STATION REPLACEMENT PARTS



REPLACEMENT PARTS		CAT. NO.
1	Guide	See Opposite Page
2	Punch	See Opposite Page
3	External Ring	980934
4	Spring Support	10651
5	Adjustment Driver	10650
6	Index Collar	10653
7	Adjustment Ring	10652
8	Driver	10655
9	Spring	125
10	Retaining Ring	971732
11	Punch Head	10654
12	Spring Cover	10657
13	Ball Bearing (5mm dia.)	972743
14	Spring	972745
15	Ball Bearing (3mm dia.)	972744

FAB STYLE

HP 1-1/4" STATION

FAB STYLE



PUNCH AND GUIDE
ASSEMBLY



DIE



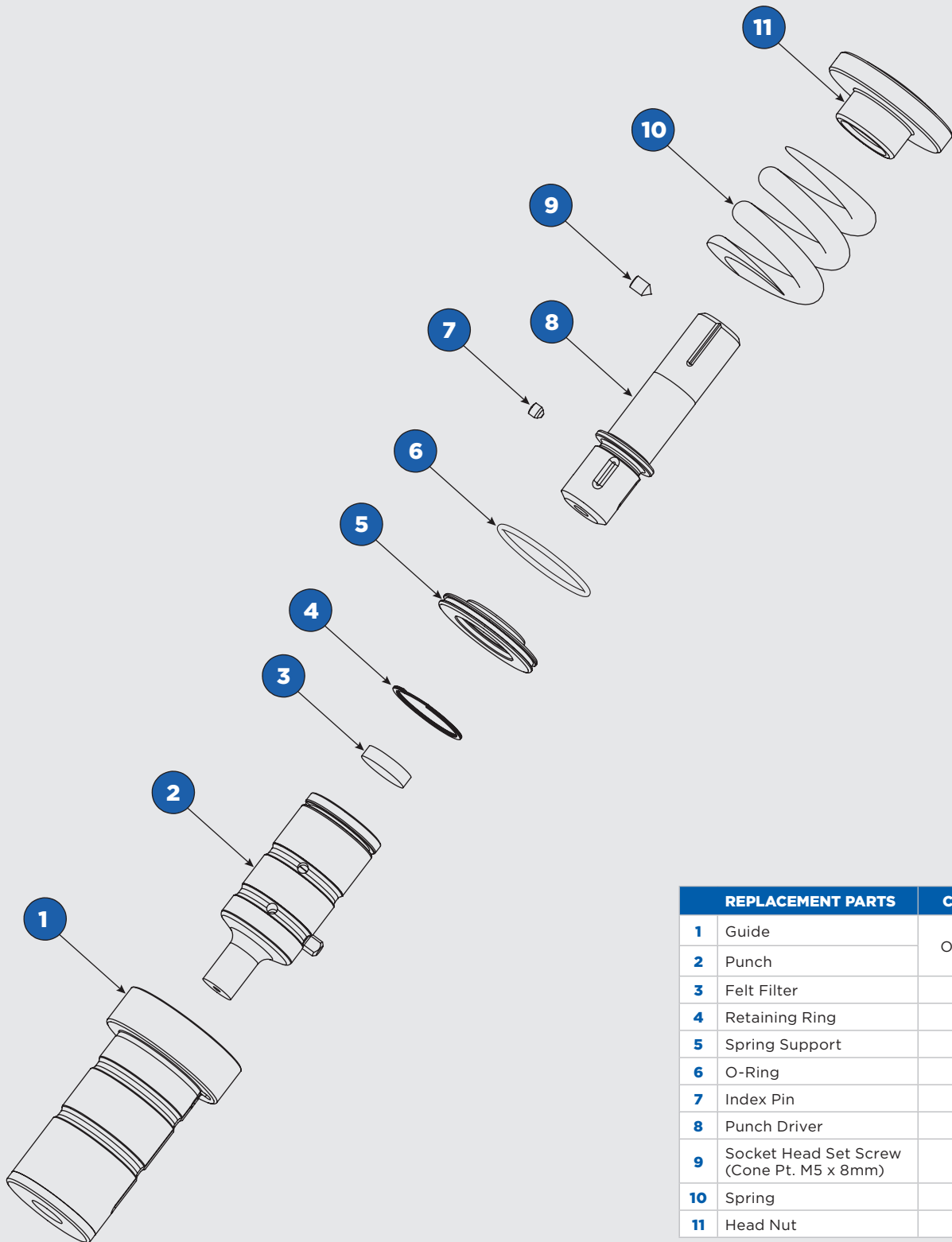
STANDARD SHAPE
DIMENSIONS
FLYER

	CAT. NO.	PRICE
PUNCH AND GUIDE ASSEMBLY		
Round	10143	
Shape	10145	
Optima® Coating	—	
PUNCH		
Round	10137	
Shape	10136	
Optima® Coating	—	
GUIDE		
Round	10144	
Shape	10139	
DIE		
Round Slug Hugger**	454	
Round Standard	133	
Shape Slug Hugger® 2*	10373	
Shape Positive	162	
Shape Negative	244	
<i>*Order Slug Hugger® dies punch size plus clearance. Size restrictions apply.</i>		
DIE SHIM		
.010" [0.25mm] Pack of 25	2209	
.030" [0.76mm] Pack of 25	2724	
.060" [1.5mm] Pack of 25	2173	
<i>Additional charges may apply to non-standard features. See pages 65-66.</i>		

STANDARD SHAPES *Non-standard shapes available. See page 54.*



HP 1-1/4" STATION REPLACEMENT PARTS



	REPLACEMENT PARTS	CAT. NO.
1	Guide	See Opposite Page
2	Punch	
3	Felt Filter	10155
4	Retaining Ring	6015
5	Spring Support	10188
6	O-Ring	6562
7	Index Pin	6874
8	Punch Driver	10141
9	Socket Head Set Screw (Cone Pt. M5 x 8mm)	6268
10	Spring	125
11	Head Nut	10025

FAB STYLE

HP HEAVY DUTY 1-1/4" STATION

FAB STYLE



PUNCH AND GUIDE ASSEMBLY



DIE



STANDARD SHAPE DIMENSIONS FLYER

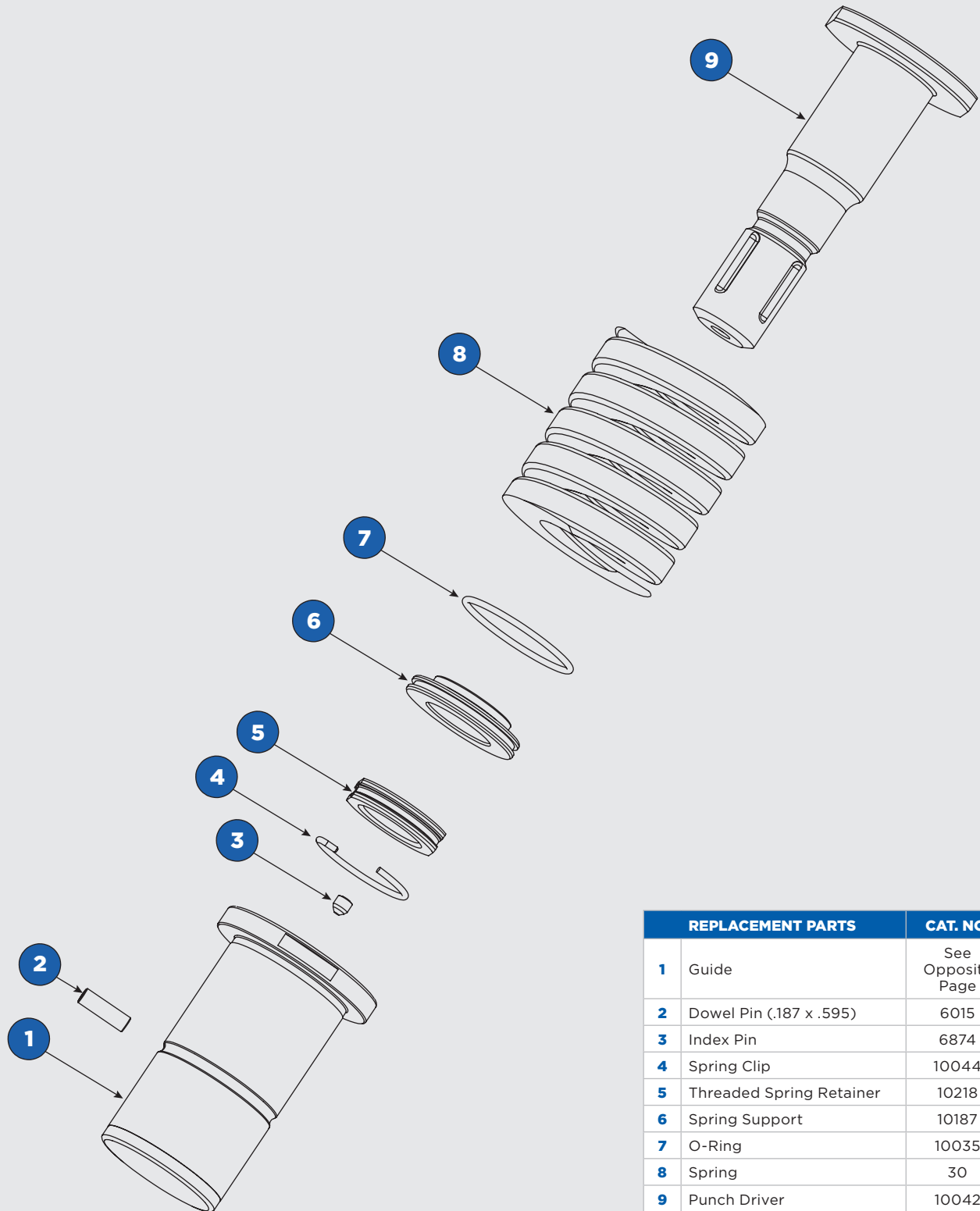
	CAT. NO.	PRICE
PUNCH AND GUIDE ASSEMBLY		
Round	10039	
Shape	10040	
Optima® Coating	—	
PUNCH		
Round	10046	
Shape	10045	
Optima® Coating	—	
GUIDE		
Round	10027	
Shape	10020	
DIE		
Round Slug Hugger**	454	
Round Standard	133	
Shape Slug Hugger* 2*	10373	
Shape Positive	162	
Shape Negative	244	
*Order Slug Hugger® dies punch size plus clearance. Size restrictions apply.		
DIE SHIM		
.010" [0.25mm] Pack of 25	2209	
.030" [0.76mm] Pack of 25	2724	
.060" [1.5mm] Pack of 25	2173	
Additional charges may apply to non-standard features. See pages 65-66.		

MAX. MATERIAL THICKNESS	NOTES
<p>.375" [9.5mm]</p>	<p>HP Heavy Duty: Spherical concave shear & Optima® standard on 1" [25.4mm], 25mm, and 1.250" [31.75mm] diameters.</p> <p>Full Size (1-1/4" Body): Urethane spring assemblies available upon request.</p>

STANDARD SHAPES Non-standard shapes available. See page 54.



HP HEAVY DUTY 1-1/4" STATION REPLACEMENT PARTS



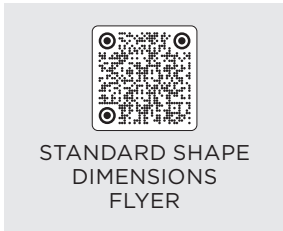
REPLACEMENT PARTS		CAT. NO.
1	Guide	See Opposite Page
2	Dowel Pin (.187 x .595)	6015
3	Index Pin	6874
4	Spring Clip	10044
5	Threaded Spring Retainer	10218
6	Spring Support	10187
7	O-Ring	10035
8	Spring	30
9	Punch Driver	10042

BASIX 1-1/4" STATION

FAB STYLE



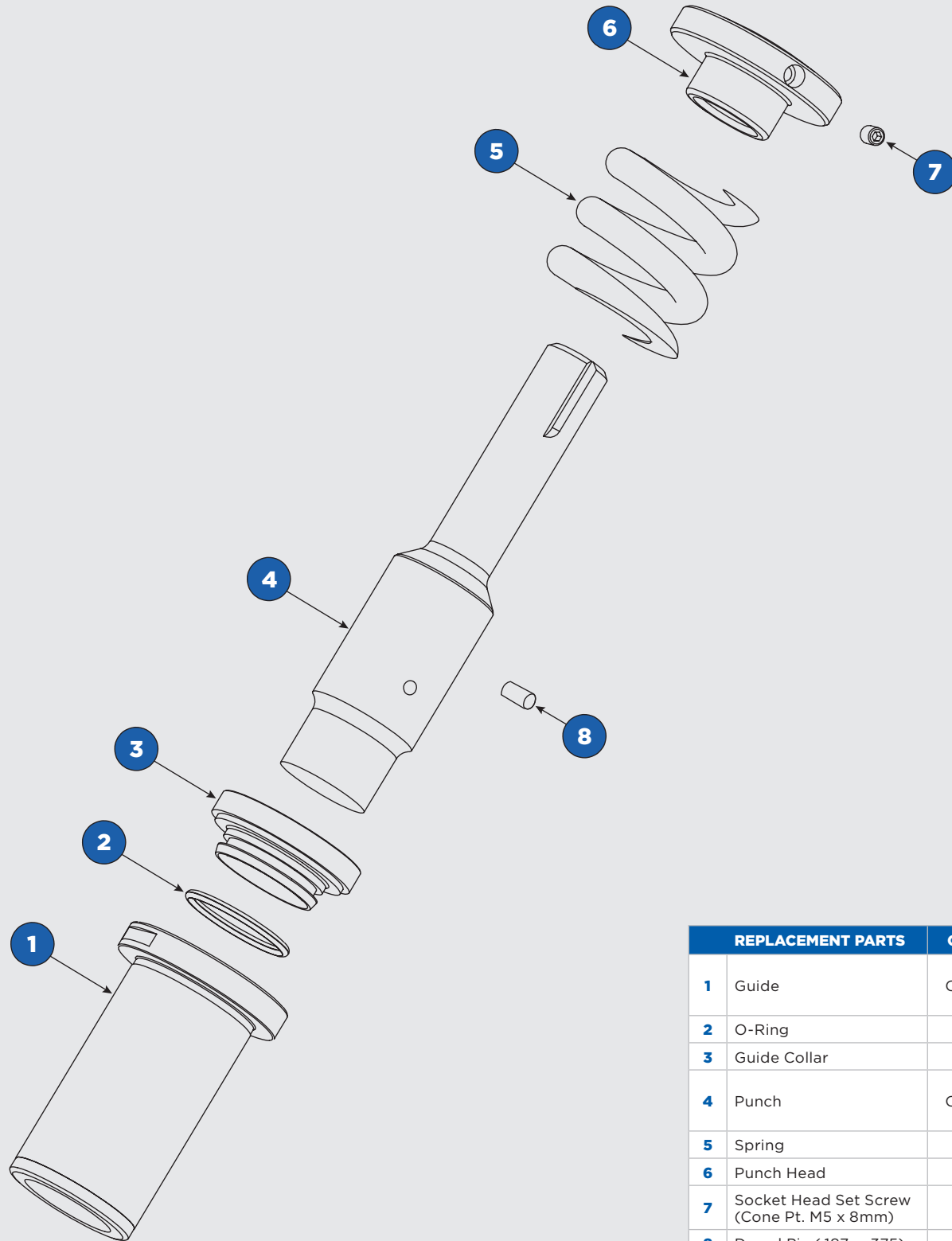
	CAT. NO.	PRICE
PUNCH AND GUIDE ASSEMBLY		
Round	149	
Shape	164	
Optima® Coating	—	
PUNCH		
Round	148	
Shape	161	
Optima® Coating	—	
GUIDE		
Round	147	
Shape	159	
PUNCH SHIM		
1-1/4" single	152	
1-1/4" pack of 25	98	
DIE		
Round Slug Hugger**	454	
Round Standard	133	
Shape Slug Hugger® 2*	10373	
Shape Positive	162	
Shape Negative	244	
<i>*Order Slug Hugger® dies punch size plus clearance. Size restrictions apply.</i>		
DIE SHIM		
.010" [0.25mm] Pack of 25	2209	
.030" [0.76mm] Pack of 25	2724	
.060" [1.5mm] Pack of 25	2173	
<i>Additional charges may apply to non-standard features. See pages 65-66.</i>		



STANDARD SHAPES *Non-standard shapes available. See page 54.*



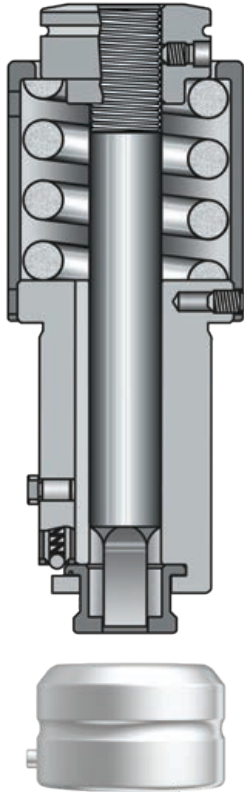
BASIX 1-1/4" STATION REPLACEMENT PARTS



	REPLACEMENT PARTS	CAT. NO.
1	Guide	See Opposite Page
2	O-Ring	466
3	Guide Collar	146
4	Punch	See Opposite Page
5	Spring	125
6	Punch Head	145
7	Socket Head Set Screw (Cone Pt. M5 x 8mm)	6268
8	Dowel Pin (.187 x .375)	2150

FAB STYLE

5/8" DROP IN



FAB STYLE

	CAT. NO.	PRICE
GUIDE ASSEMBLY		
Guide Assembly with .625" [15.88mm] Diameter Closed Round Stripper Plate	476	
PUNCH		
Round	445	
Shape	446	
Optima® Coating	—	
STRIPPER		
Round	478	
Shape (Odd angle shape at required)	479	
DIE		
Round Slug Hugger**	454	
Round Standard	133	
Shape Slug Hugger* 2*	10373	
Shape Positive	162	
Shape Negative	244	
*Order Slug Hugger® dies punch size plus clearance. Size restrictions apply.		
FIT TO STRIPPIT HOLDER		
Punch Head — New Style for Wilson and Strippit	475	
Punch Head — Old Style	444	
Stripper — Round	474	
Stripper — Shape (Odd angle shape at required)	473	
DIE SHIM		
.010" [0.25mm] Pack of 25	2209	
.030" [0.76mm] Pack of 25	2724	
.060" [1.5mm] Pack of 25	2173	
Additional charges may apply to non-standard features. See pages 65-66.		

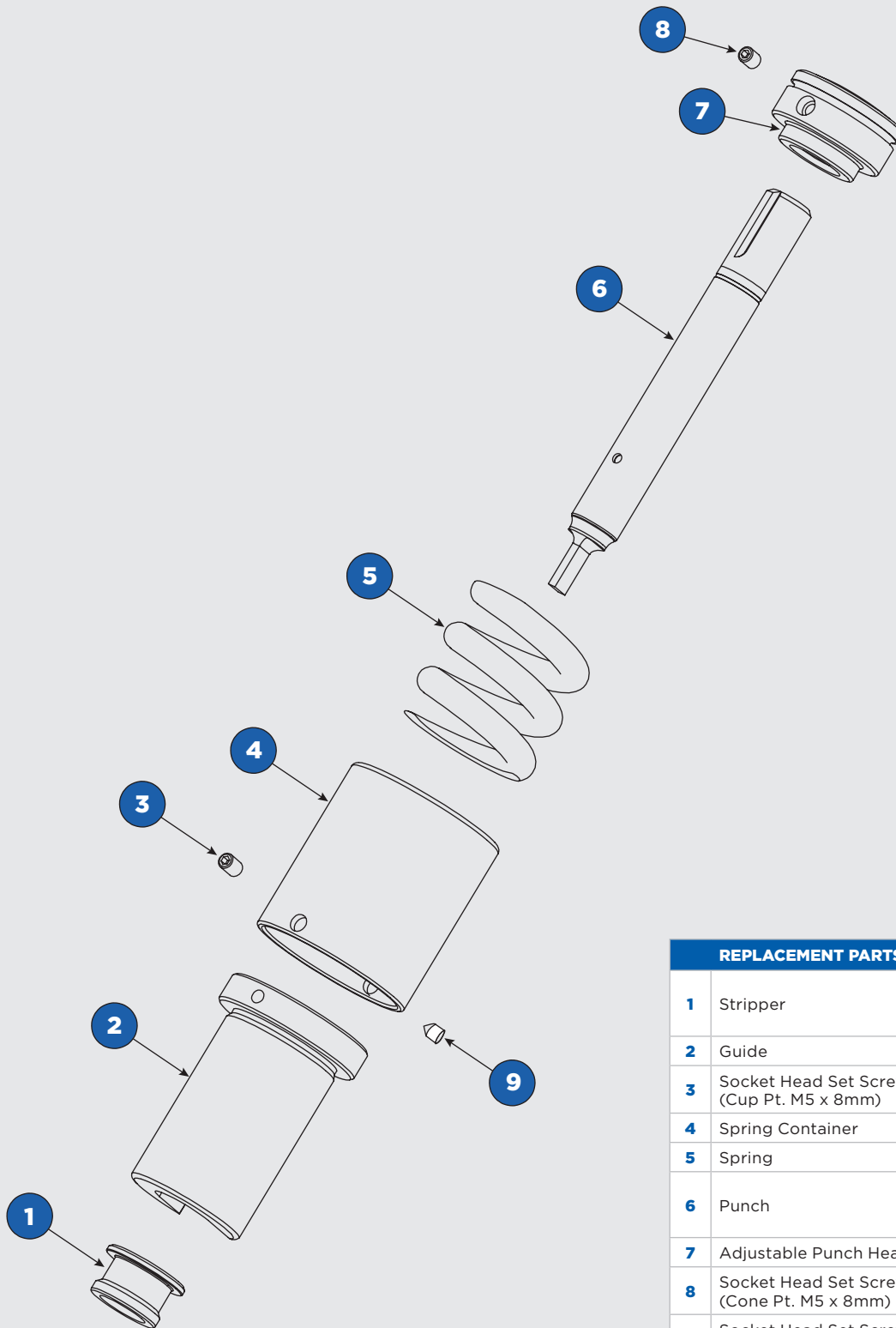


STANDARD SHAPE
DIMENSIONS
FLYER

STANDARD SHAPES Non-standard shapes available. See page 54.

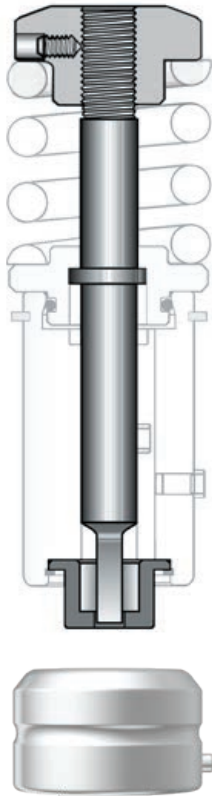


5/8" DROP IN REPLACEMENT PARTS



	REPLACEMENT PARTS	CAT. NO.
1	Stripper	See Opposite Page
2	Guide	477
3	Socket Head Set Screw (Cup Pt. M5 x 8mm)	6372
4	Spring Container	453
5	Spring	125
6	Punch	See Opposite Page
7	Adjustable Punch Head	10220
8	Socket Head Set Screw (Cone Pt. M5 x 8mm)	6268
9	Socket Head Set Screw (Cone Pt. 10-32 x .250)	6072

1/2" SNAP APART



FAB STYLE

	CAT. NO.	PRICE
PUNCH		
Round	195	
Shape	333	
Optima® Coating	—	
STRIPPER		
Round	478	
Shape (Odd angle shape at required)	337	
DIE		
Round Slug Hugger**	454	
Round Standard	133	
Shape Slug Hugger* 2*	10373	
Shape Positive	162	
Shape Negative	244	
*Order Slug Hugger® dies punch size plus clearance. Size restrictions apply.		
DIE SHIM		
.010" [0.25mm] Pack of 25	2209	
.030" [0.76mm] Pack of 25	2724	
.060" [1.5mm] Pack of 25	2173	
Additional charges may apply to non-standard features. See pages 65-66.		

Replacement punch, dies and strippers only.

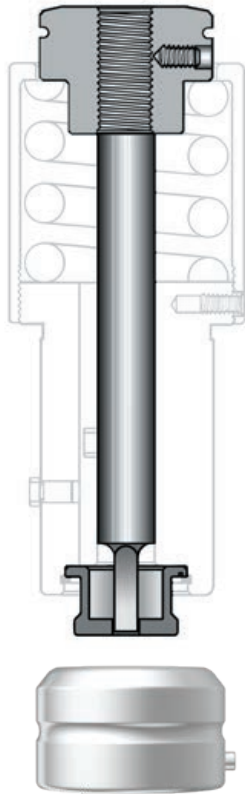


STANDARD SHAPE
DIMENSIONS
FLYER

STANDARD SHAPES *Non-standard shapes available. See page 54.*

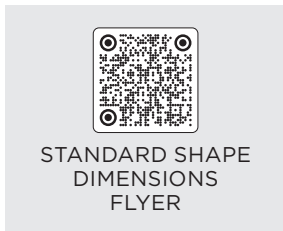


1/2" DROP IN



	CAT. NO.	PRICE
PUNCH		
Round	451	
Shape	450	
Optima® Coating	—	
STRIPPER		
Round	478	
Shape (<i>Odd angle shape at required</i>)	337	
DIE		
Round Slug Hugger**	454	
Round Standard	133	
Shape Slug Hugger* 2*	10373	
Shape Positive	162	
Shape Negative	244	
<i>*Order Slug Hugger® dies punch size plus clearance. Size restrictions apply.</i>		
FIT TO STRIPPIT HOLDER		
Punch Head (New Style for Wilson and Strippit)	448	
Stripper — Round	474	
Stripper — Shape (<i>Odd angle shape at required</i>)	473	
DIE		
.010" [0.25mm] Pack of 25	2209	
.030" [0.76mm] Pack of 25	2724	
.060" [1.5mm] Pack of 25	2173	
<i>Additional charges may apply to non-standard features. See pages 65-66.</i>		

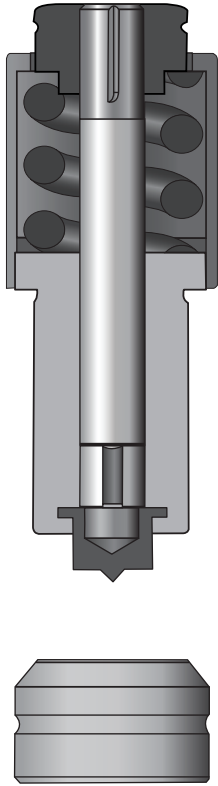
Replacement punch, dies and strippers only.



STANDARD SHAPES *Non-standard shapes available. See page 54.*



CENTER PUNCH



	CAT. NO.	PRICE
FORM-DOWN		
Complete Form-Down Assembly – Die included	10677	
Replacement Center Punch Tip	400	
5/8" Replacement Punch Body	10666	
Blank Die	498	
Light Spring Kit	10668	
FORM-UP		
Complete Form-Up Assembly – Upper and Lower	10214	
Upper Punch Assembly	10214	
Lower Die Assembly	10214	
Replacement Die Insert .375" [9.53mm]	10214	



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

Wearbeater™

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



Nitrex®

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



Optima®

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



Slip-Max®

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



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

● GOOD ▲ BETTER ★ BEST

HP 2" Ⓞ STATION



GUIDE ASSEMBLY



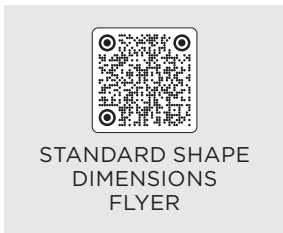
DIE

FAB STYLE

	CAT. NO.	PRICE
GUIDE ASSEMBLY		
Guide Assembly	10530	
<i>Keyed for shapes at 0°, 45°, 90°, 180°, 225° and 270°.</i>		
PUNCH <i>Shipped with no shear unless specified</i>		
Round	10568	
Shape	10567	
Optima® Coating	—	
STRIPPER		
Round	10534	
Shape	10535	
DIE		
Round Slug Hugger**	10545	
Round Standard	10544	
Shape Slug Hugger® 2*	10548	
Shape Positive	10546	
Shape Negative	10547	
<i>*Order Slug Hugger® dies punch size plus clearance. Size restrictions apply.</i>		
DIE SHIM		
.010 [0.25mm] Pack of 10	2210	
.030 [0.76mm] Pack of 10	2726	
.060 [1.5mm] Pack of 10	2174	
<i>Additional charges may apply to non-standard features. See pages 65-66.</i>		

NOTES

Square dies are keyed for shape at 0° and 45°, all other shaped dies are keyed for shape at 0° and 90°.



STANDARD SHAPES *Non-standard shapes available. See page 54.*



HP 2" Ⓞ STATION REPLACEMENT PARTS



	REPLACEMENT PARTS	CAT. NO.
1	Driver Assembly	10574
2	Socket Head Set Screw (Cup Pt. M5 x 6mm)	6329
3	Lock Washer	2117
4	Socket Head Cap Screw (M4 x 16mm)	6435
5	Punch Ejector	6116-1
6	Socket Head Cap Screw (.500-13 x 1.750)	971391
7	Disc Spring	971690
8	Anti-Lock Shim	5412
9	Punch Holder Key	10448
10	Punch Holder	10541
11	Guide Unit Assembly	10531
12	Flex Tubing	989711

FAB STYLE

HP 3-1/2" ⓐ STATION

FAB STYLE



GUIDE ASSEMBLY



DIE



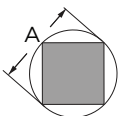
STANDARD SHAPE
DIMENSIONS
FLYER

	CAT. NO.	PRICE
GUIDE ASSEMBLY		
Guide Assembly	10436	
<i>Keyed for shapes at 0°, 45°, 90°, 180°, 225° and 270°.</i>		
PUNCH		
Round		
1.250-1.562" [31.75-39.67mm] Dia.	181	
1.563-2.250" [39.70-57.15mm] Dia.**	183	
2.251-2.875" [57.17-73.03mm] Dia.**	184	
2.876-3.500" [73.05-88.90mm] Dia.**	185	
**Punch Retainer (required for round punches)	182	
Shape		
1.250-1.500" [31.75-38.10mm] Dia.	188	
1.501-2.500" [38.12-63.50mm] Dia.	189	
2.501-3.500" [63.52-88.90mm] Dia.	190	
Optima® Coating	—	
STRIPPER		
Round	186	
Shape	192	
DIE		
Round Slug Hugger**	459	
Round Standard	187	
Shape Slug Hugger* 2*	10381	
Shape Positive	212	
Shape Negative	251	
Shape Slug Hugger* 2* Heavy Duty	10382	
Shape Positive Heavy Duty	213	
Shape Negative Heavy Duty	252	
*Order Slug Hugger® dies punch size plus clearance. Size restrictions apply.		
DIE SHIM		
.010 [0.25mm] Pack of 5	2211	
.030 [0.76mm] Pack of 5	2728	
.060 [1.5mm] Pack of 5	2175	
Additional charges may apply to non-standard features. See pages 65-66.		

NOTES

A Dimension

3.500" [88.9mm]

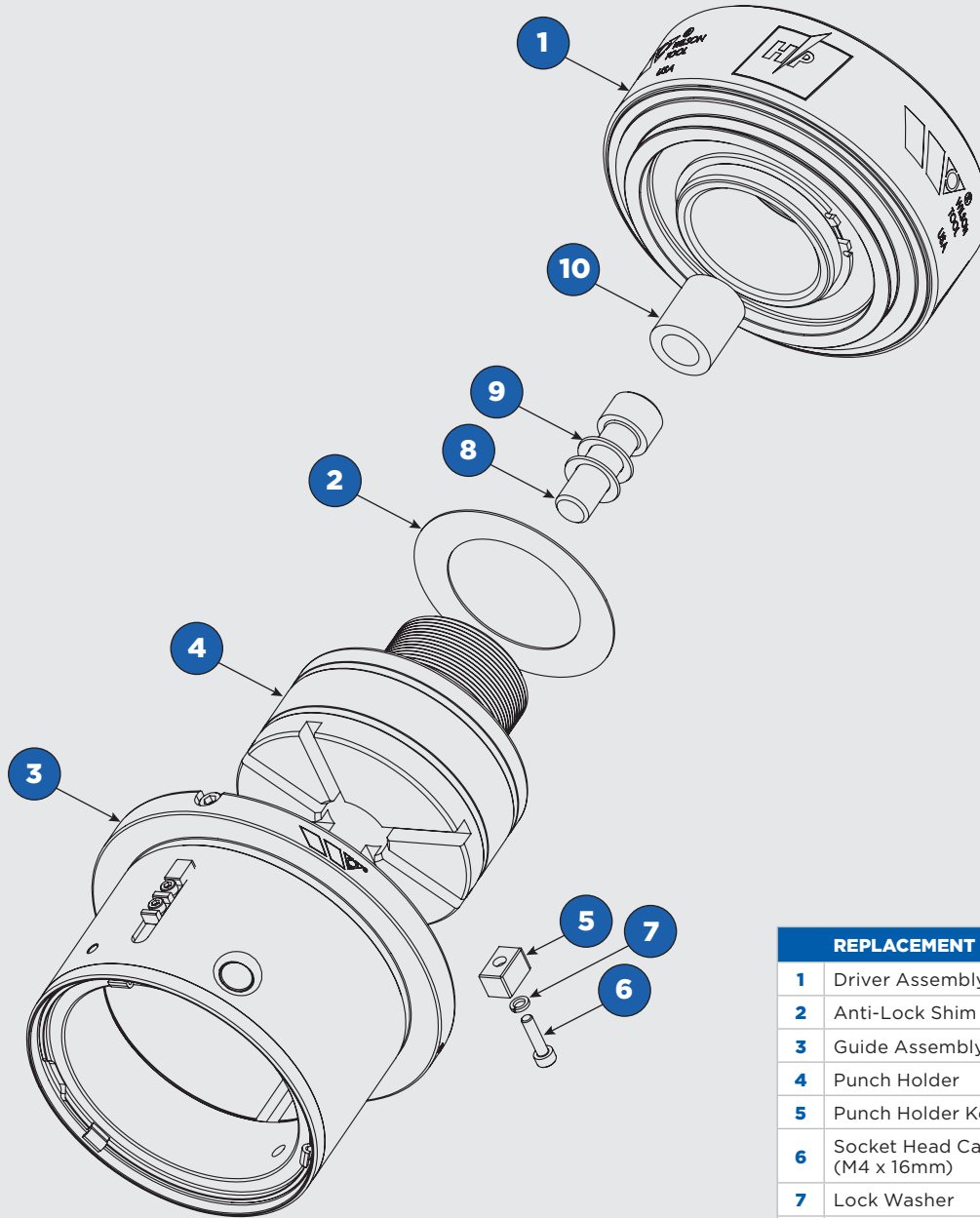


- 1/32" [.79mm] Rooftop shear is given to all punches with A Dimension greater than 2.000" [50.8] and width greater than .250" [6.35mm] at no extra charge. All punches .250" [6.35mm] and under in width will be shipped with no shear unless specified.
- Square dies are keyed for shape at 0° and 45°, all other shaped dies are keyed for shape at 0° and 90°.

STANDARD SHAPES *Non-standard shapes available. See page 54.*



HP 3-1/2" Ⓟ STATION REPLACEMENT PARTS



	REPLACEMENT PARTS	CAT. NO.
1	Driver Assembly	10571
2	Anti-Lock Shim	5413
3	Guide Assembly	10443
4	Punch Holder	10447
5	Punch Holder Key	10448
6	Socket Head Cap Screw (M4 x 16mm)	6435
7	Lock Washer	2117
8	Socket Head Cap Screw (.500-13 x 1.500)	6606
9	Disc Spring	971690
10	Flex Tubing	989711

FAB STYLE

HP DURA-BLADE® SLITTING TOOL

FAB STYLE



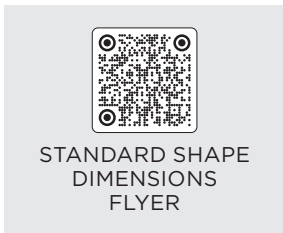
GUIDE ASSEMBLY



DIE

	CAT. NO.	PRICE
GUIDE ASSEMBLY		
Guide Assembly	10516	
<i>Keyed for shapes at 0°, 45° and 90°.</i>		
PUNCH		
Blade	10520	
Optima® Coating	—	
STRIPPER		
Shape	367	
DIE		
Shape Slug Hugger® 2*	10381	
Shape Positive	212	
Shape Negative	251	
Shape Slug Hugger® 2* Heavy Duty	10382	
Shape Positive Heavy Duty	213	
Shape Negative Heavy Duty	252	
<i>*Order Slug Hugger® dies punch size plus clearance. Size restrictions apply.</i>		
DIE SHIM		
.010 [0.25mm] Pack of 5	2211	
.030 [0.76mm] Pack of 5	2728	
.060 [1.5mm] Pack of 5	2175	
<i>Additional charges may apply to non-standard features. See pages 65-66.</i>		

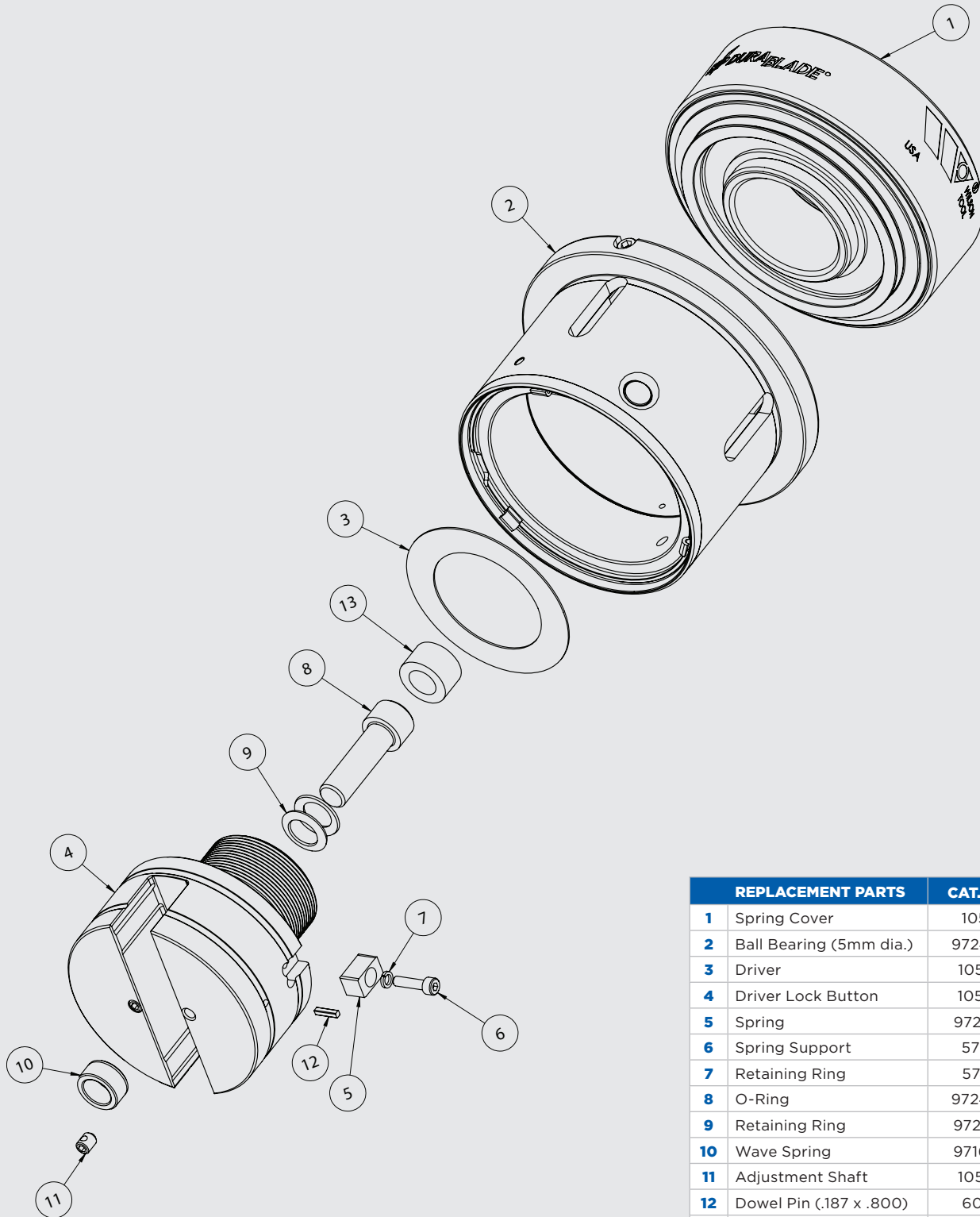
NOTES		
A Dimension 3.500" [88.9mm]		Max. Width for Blade Insert .750" [19.05mm]



STANDARD SHAPES *Non-standard shapes available. See page 54.*



HP DURA-BLADE® SLITTING TOOL REPLACEMENT PARTS



REPLACEMENT PARTS	CAT. NO.
1 Spring Cover	10511
2 Ball Bearing (5mm dia.)	972420
3 Driver	10577
4 Driver Lock Button	10539
5 Spring	972615
6 Spring Support	5738
7 Retaining Ring	5747
8 O-Ring	972430
9 Retaining Ring	972441
10 Wave Spring	971692
11 Adjustment Shaft	10576
12 Dowel Pin (.187 x .800)	6016
13 Punch Holder	10517

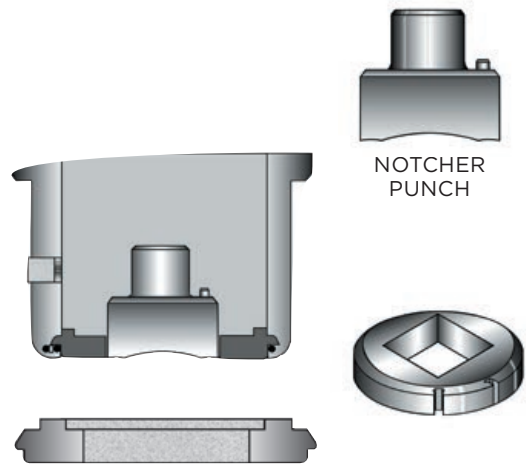
3-1/2" STATION NOTCHER

(For Series 80 Plus and Series 90, and HP Guide Assemblies)

	CAT. NO.	PRICE
PUNCH <i>Optima® coating is standard on all notcher punches.</i>		
2" [50.8mm] or 50mm square	449	
STRIPPER PLATE		
Notcher Stripper Plate	367	
DIE		
Shape Slug Hugger® 2*	10381	
Shape Positive	212	
Shape Negative	251	

*Order Slug Hugger® dies punch size plus clearance.
Size restrictions apply.

NOTES
<ul style="list-style-type: none"> • Square dies are keyed for shape at 0° and 45°. • Includes 1/16" [1.6mm] double concave shear.



NOTCHER PUNCH

FAB STYLE

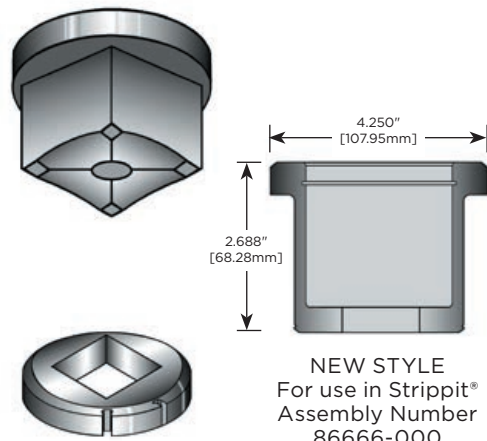
UNIVERSAL NOTCHER STATION

(For Strippit® Universal Notch Guide Assemblies)

	CAT. NO.	PRICE
PUNCH <i>Optima® coating is standard on all notcher punches.</i>		
2" [50.8mm] or 50mm square	449	
Round	238	
Standard Square		
1.000" [25.4mm]		
1.500" [38.10mm]	215	
2.000" [50.80mm]		
50mm Square		
Non-standard Square	239	
STRIPPING GUIDE		
Round	278	
Shape	279	
DIE		
Round Slug Hugger® 2*	10597	
Round Standard	187	
Shape Slug Hugger® 2*	10381	
Shape Positive	212	
Shape Negative	251	

*Order Slug Hugger® dies punch size plus clearance.
Size restrictions apply.

NOTES
<ul style="list-style-type: none"> • Additional charges flat punch. • All square dies are keyed for shape at 0° and 45°.



NEW STYLE
For use in Strippit®
Assembly Number
86666-000

SPECIALS

YOU NEED BETTER SOLUTIONS, FASTER!

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

Scan QR Code to
Access Our Templates
for Punching Specials



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

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

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

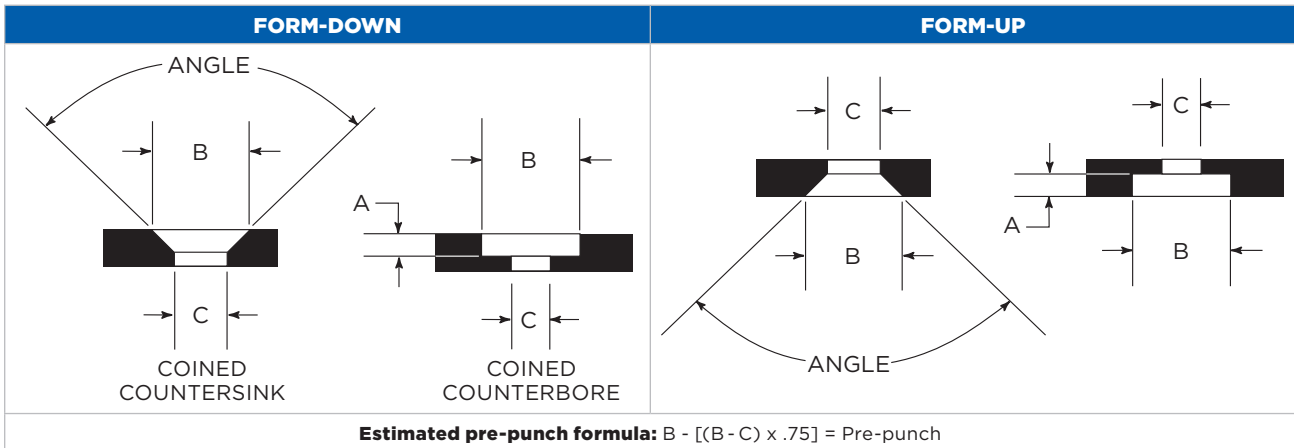
COINING TOOLS — FORM-DOWN / FORM-UP



Scan QR Code
for more
Coining and
Countersinks



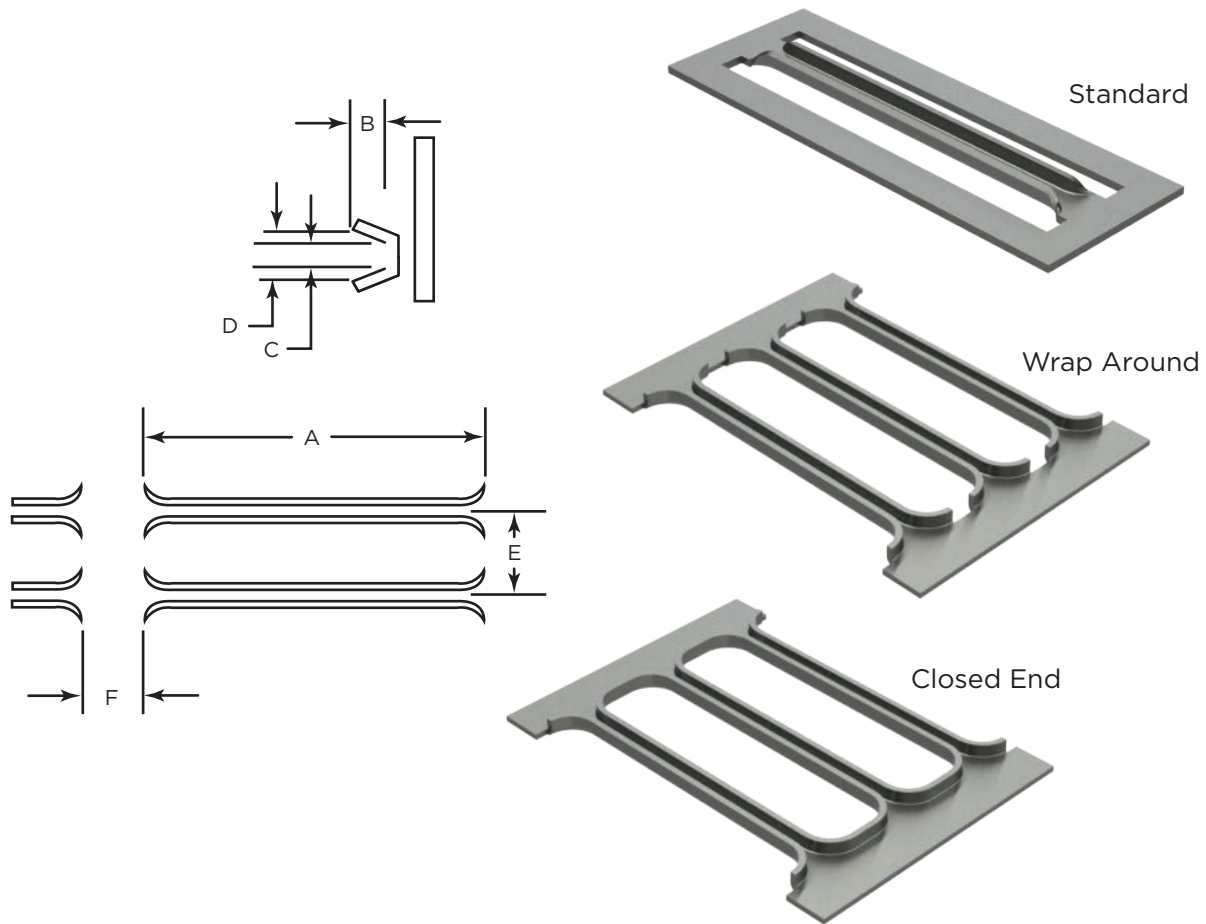
SPECIALS



PUNCHING
SPECIALS
TEMPLATES

BENEFITS	CONSIDERATIONS	INFO NEEDED
<ul style="list-style-type: none"> Eliminate the costly, time-consuming secondary operation of drilling countersinks. The interchangeable tip design allows you to change the size of your coin easily and inexpensively while also lowering tooling costs and inventory. Often, you can pierce and coin in one hit, but a pre-punched hole helps reduce the burr for a cleaner looking part. For fast and easy adjustments, an E-Z Set punch head is recommended. 	<ul style="list-style-type: none"> Wilson Tool provides an estimated pre-punch for coining tools — a pre punched hole is strongly recommended. Consult our Tooling Technicians on size and tonnage restrictions. Special applications may affect pricing. 	<ul style="list-style-type: none"> Machine Model Material thickness and type Angle, coin diameter, thru-hole size With or without pilot Form-up or form-down

CARD GUIDE — FORM-UP

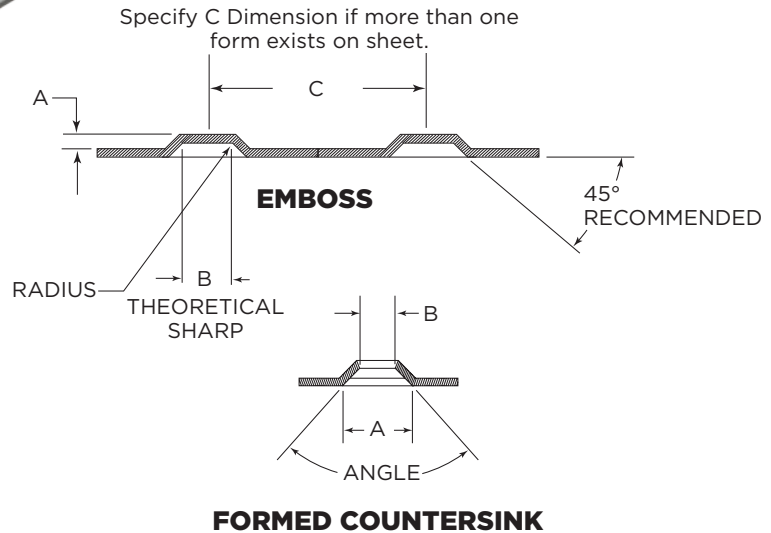
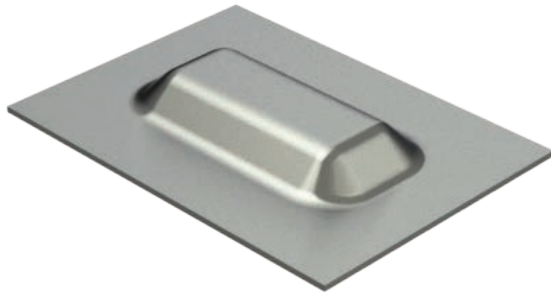


PUNCHING
SPECIALS
TEMPLATES

BENEFITS	CONSIDERATIONS	INFO NEEDED
<ul style="list-style-type: none"> Securely holds, guides, and protects printed circuit boards (PCBs) within any chassis, rack, or system. Accommodates both standard and specialized lead-in shapes, simplifying your sheet metal forming process and streamlining assembly. Universal holder offers fast and easy length adjustments with the spring-loaded adjusting plunger. The form is internally stripped for best results. To change Card Guide size, only the punch tip, ejectors and die assembly are required. Wilson Tool will estimate the web of material to be formed on all Card Guides. Special lead-ins available Developed pre-punch shape and size for special card guides available. ABS compatible, minimizing wear and maintenance. 	<ul style="list-style-type: none"> Form heights of less than two times the material thickness are not recommended because the web may twist (one side will form higher than the other). For proper design, closest center-to-center and narrowest pre-punch are required. Special applications may affect pricing. 	<ul style="list-style-type: none"> Machine model Material thickness and type Drawing of desired card guide, center-to-center location and narrowest pre-punch Pre-punch shape: rectangle, obround, or rectangle with radius corners Length of pre-punch if material is less than .050" [1.27mm]

SPECIALS

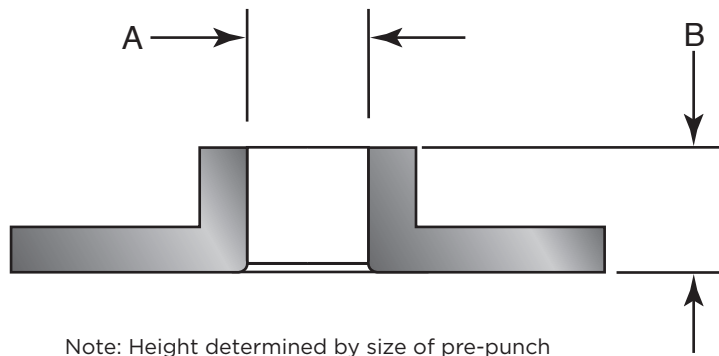
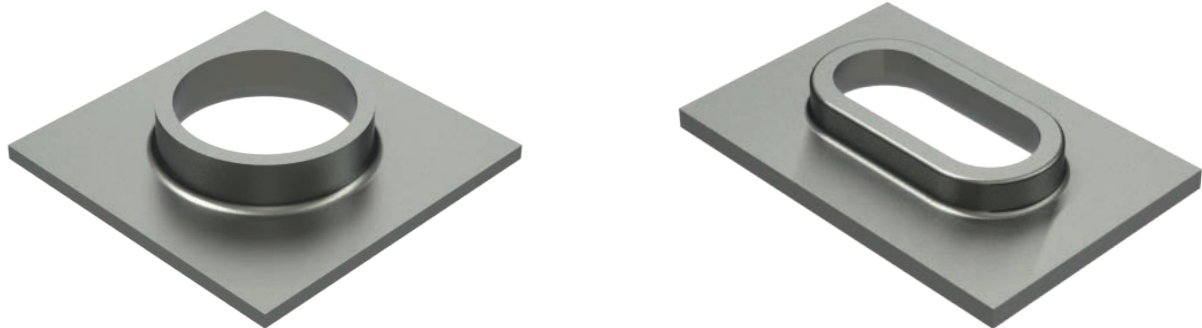
EMBOSS — FORM-DOWN / FORM-UP



PUNCHING
SPECIALS
TEMPLATES

BENEFITS	CONSIDERATIONS	INFO NEEDED
<ul style="list-style-type: none"> • Useful for stand-offs, spacers, large countersinks and locks for nuts. • 0° and 90° standard keying on shape forms. Additional keying is available. • Small Station tool is a full body design to give maximum bearing area to sheet. For fast and easy adjustments, an E-Z Set punch head is recommended. • Large Station tools feature a cost-effective punch, stripper, and die design that fits your existing holder assembly, allowing for easy conversion to different sizes without purchasing a new holder. Run in an HP holder to make length adjustments fast and easy, reducing expensive down time. • Engineered to meet you unique requirements to ensure part quality and consistent form. 	<ul style="list-style-type: none"> • Large station forming tools must be run with a light spring in the upper unit. • Keep forming tools as far from clamps and pierced holes as possible to reduce the risk of sheet distortion. • A witness ring mark around the form indicates there is too much spring pressure in the upper unit or the tool is stroking too deep. • A post delay should be programmed to give the tool time to strip. • For maximum size in each station, please consult with our Tooling Technicians. • Never punch thicker material than what the tool was designed for. • Special applications may affect pricing. 	<ul style="list-style-type: none"> • Machine model • Material thickness and type • Full dimensioning (height, dia. or shape, angle, radius, thru-hole, etc.) • Drawing (if possible) • Dimensions preferred to a theoretical sharp • Style of large station guide assembly

EXTRUSION — FORM-DOWN / FORM-UP



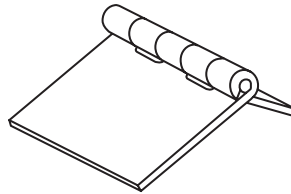
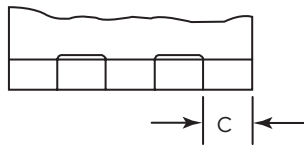
Note: Height determined by size of pre-punch



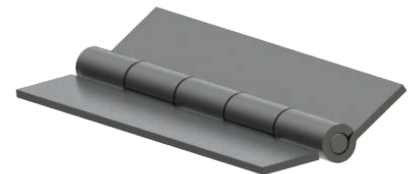
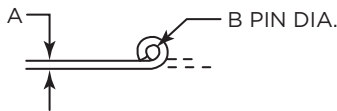
PUNCHING
SPECIALS
TEMPLATES

BENEFITS	CONSIDERATIONS	INFO NEEDED
<ul style="list-style-type: none"> • Used in a broad spectrum of applications including self-tapping screws, cooling tube holders, air flow and tread plate. • Small Station <ul style="list-style-type: none"> - Extrusions with I.D. $\leq .375"$ [9.53mm] are made insert style for fast, easy, economical replacement. - Form-down extrusions are self-stripping. - For fast and easy adjustments, an E-Z Set punch head is recommended. • Large Station <ul style="list-style-type: none"> - Extrusions with I.D. $>.500"$ [12.7mm] are a punch tip, ejector and die assembly running in a universal holder providing cost savings and flexibility. - Internal self-stripping design for consistent, trouble-free operation. - Fast and easy length adjustments can be made with the adjusting spring plunger, saving costly set-up time. • Lower unit coating options are available for enhanced durability, longer life and easier stripping. • ABS compatible, minimizing wear and maintenance. 	<ul style="list-style-type: none"> • Slow machine speed or program in a post delay to give the tool time to strip. • Extrusions must be pre-punched. • Extrusions are made for specific material thickness and type. • Punch, stripper and die assembly designs on extrusions with I.D. $< .500"$ [12.7mm] require reduced spring pressure in upper unit. • Consult with our Tooling Technicians when extruding stainless steel. • Special applications may affect pricing. 	<ul style="list-style-type: none"> • Machine model • Material thickness and type • I.D. and height or screw size and type • Tolerance of I.D. • Form-up or form-down • Specify center-to-center if more than one extrusion exists on the sheet

HINGE TOOL — FORM-UP



Scan QR Code to See Hinge Tool in Action



Standard Fully Curled Hinge

One-Hit Half Knuckle Hinge

Offset Fully Curled Hinge

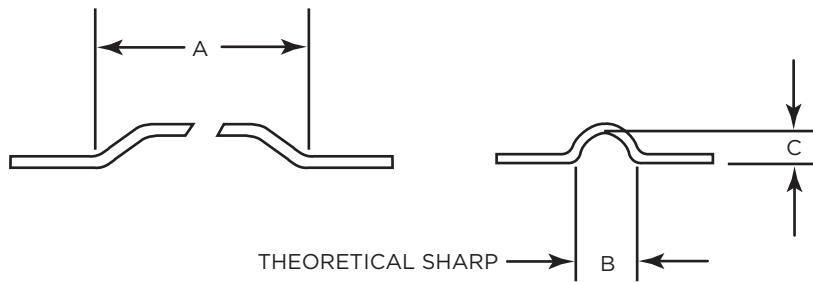
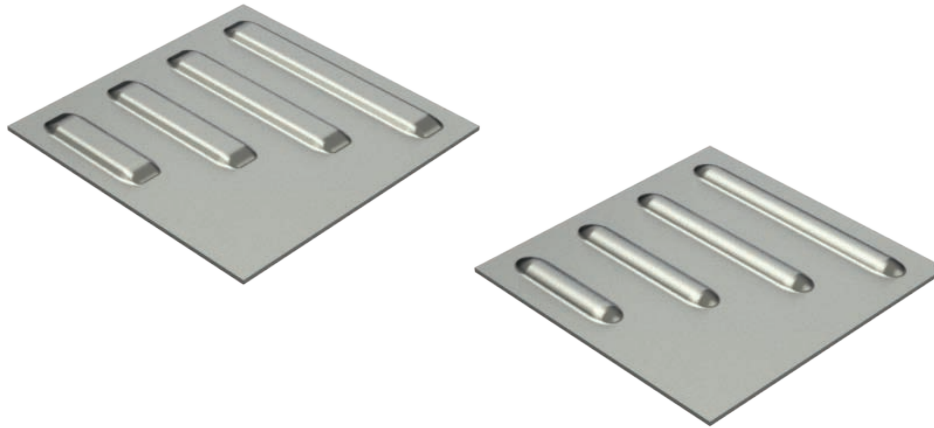
SPECIALS



PUNCHING SPECIALS TEMPLATES

BENEFITS	CONSIDERATIONS	INFO NEEDED
<ul style="list-style-type: none"> Fabricate panels with integrated hinges, eliminating the need for costly hardware, fitting, and line-up assembly. A fully curled knuckle is achieved with two sets of tools. The first tool takes two hits and the second tool one hit. Hinges can be produced on the edge or in the middle of the sheet. Simply pre-punch the knuckle size and run the hinge tools as instructed. Operating instructions with developed dimensions for easy programming are included with tool(s). For fast and easy adjustments on small station tools, an E-Z Set punch head is recommended. 	<ul style="list-style-type: none"> Design parameters change when using stainless steel. Consult our Tooling Technicians. Maximum material and pin size may vary according to machine. Max. material thickness: <ul style="list-style-type: none"> – <u>Stainless Steel</u>: 18 gauge [1.2mm] – <u>Mild Steel</u>: 14 gauge [2mm] – <u>Aluminum</u>: .080" [2mm] Offset hinge tools are available. Consult our Tooling Technicians. Special applications may affect pricing. Large stations are ABS compatible. 	<ul style="list-style-type: none"> Machine model Material thickness and type Drawing of application required Hole ID and tolerance Knuckle size Location of hinge on sheet — edge or middle

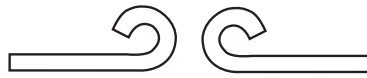
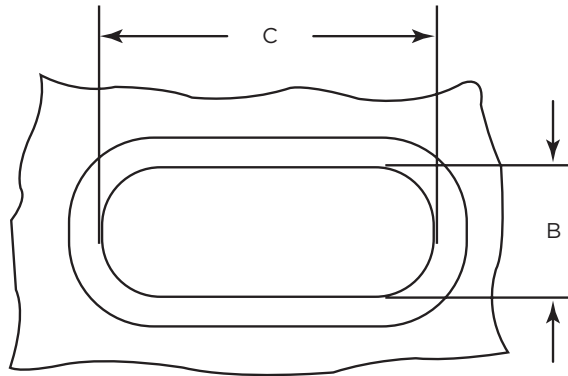
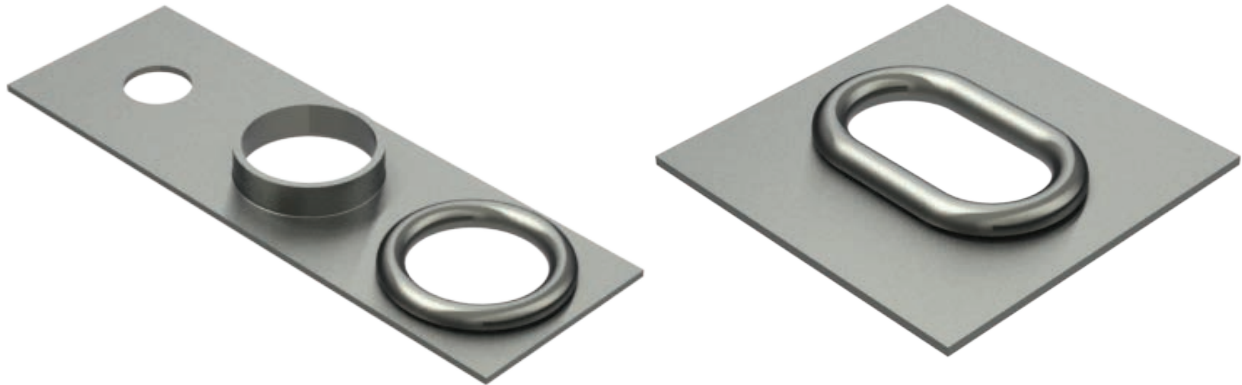
PROGRESSIVE RIB – FORM-UP



PUNCHING
SPECIALS
TEMPLATES

BENEFITS	CONSIDERATIONS	INFO NEEDED
<ul style="list-style-type: none"> • Produces quality stiffening ribs on your turret. • Programmable to any length. • Increase rib quality by decreasing increment moves to .020 - .080" [0.5 - 2mm]. • When changing material thickness, only a new upper punch or punch tip is required. • Large station progressive ribs run in a universal holder for cost savings and flexibility. • For fast and easy adjustments on small station tools, an E-Z Set punch head is recommended. • ABS compatible, minimizing wear and maintenance. 	<ul style="list-style-type: none"> • For best results, inside radius should be equal to or greater than the height. • Slight deformation will occur on first hit. • Max. material thickness: <ul style="list-style-type: none"> - <u>Mild Steel/Aluminum</u>: .105" [2.7mm] - <u>Stainless Steel</u>: .090" [2.3mm] • Ends of rib blend down to sheet (not a distinct radius). • Max. recommended "C" dimension is 3.5 times the material thickness. • Special applications may affect pricing. 	<ul style="list-style-type: none"> • Machine model • Material thickness and type • B and C dimensions

ROLLOVER/CURLING TOOL



ROLLOVER



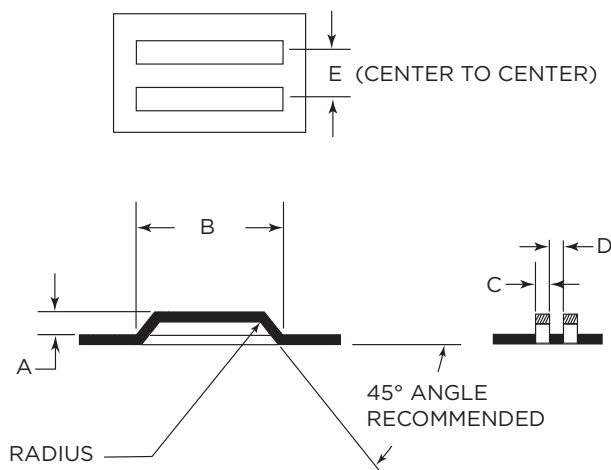
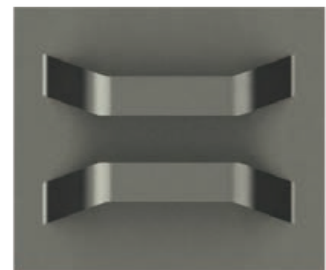
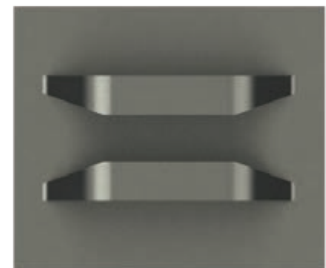
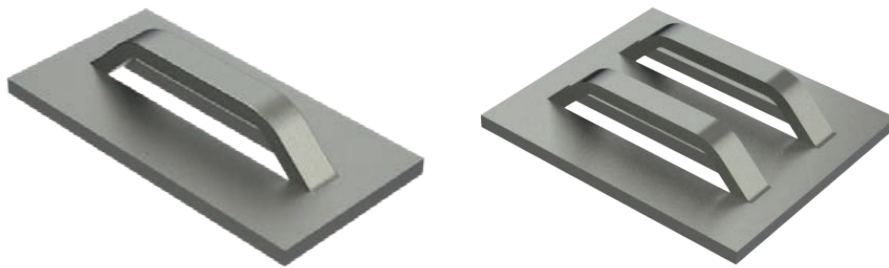
HEMMING



PUNCHING
SPECIALS
TEMPLATES

BENEFITS	CONSIDERATIONS	INFO NEEDED
<ul style="list-style-type: none"> • For use in many applications including hand holds, wire feeds and grommets • Reduces costly secondary operations and handling. • Rollover and Hemming applications require three steps: <ul style="list-style-type: none"> <u>Step 1</u> Pre-punch (developed by Wilson Tool free of charge) <u>Step 2</u> Form-up extrusion <u>Step 3</u> Rollover or Flare & Flatten • For fast and easy adjustments on small station tools, an E-Z Set punch head is recommended. 	<ul style="list-style-type: none"> • Designed for specific material thickness and type. • Consult our Tooling Technicians about size and material thickness limitations. • Tearing may occur in widths or diameters less than .625" [16mm]. • See form-up extrusion catalog page for information of Step 2. • Height in the extrusion operation controls how much curl can be achieved in Step 3. • Special applications and tight tolerance may affect pricing. 	<ul style="list-style-type: none"> • Machine model • Material thickness and type • Diameter or length and width (opening) • Tolerance of opening • Application (hand hold, wire feed, etc.) • Style of large station guide assembly

BRIDGE LANCE & FORM – FORM-UP

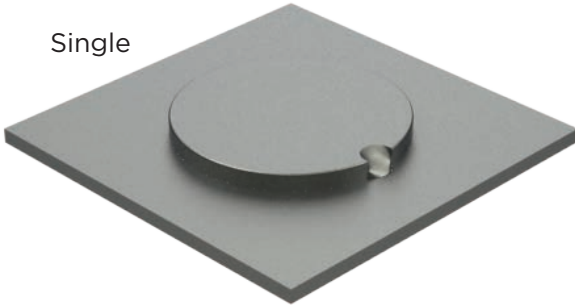


PUNCHING
SPECIALS
TEMPLATES

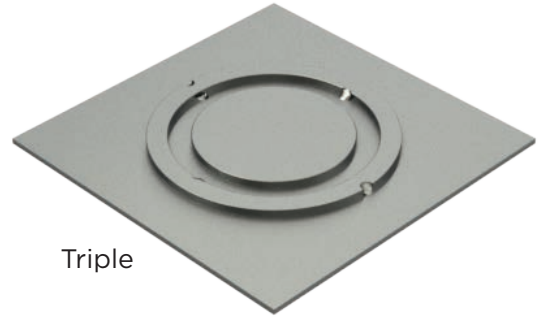
BENEFITS	CONSIDERATIONS	INFO NEEDED
<ul style="list-style-type: none"> Used for shear stops (higher form makes it easier to pick up gauging), card guides, locators, dividers, ventilation and wire tie downs. Designed to have a positive form, for high-quality and consistent parts. Tools can be designed for form-down operations upon request. Optional lead-ins are available on Double Bridge. Consult with a Tooling Technician. Large station holder assembly design provides cost saving replaceable punch tip and ejector. For fast and easy adjustments on small station tools, an E-Z Set punch head is recommended. Coating options available for extended tool life on widths greater than .098" [2.5mm]. Large stations are ABS compatible, minimizing wear and maintenance. 	<ul style="list-style-type: none"> Designed for one specific material thickness. Thinner material may be used, but the form will change. Never punch material thicker than what the tool was designed for. For strongest form, bridge width should be 1.5 times the material thickness in mild steel and aluminum, and 2 times the material thickness in stainless steel. Widths less than .070" [1.78mm] will alter price. Consult a Tooling Technician. Form-down is not recommended in N.C. machines. 	<ul style="list-style-type: none"> Machine model Material thickness and type Length, width, height and center to center Drawing of pattern for relief Top, side and end views

EKO — ELECTRICAL KNOCKOUT

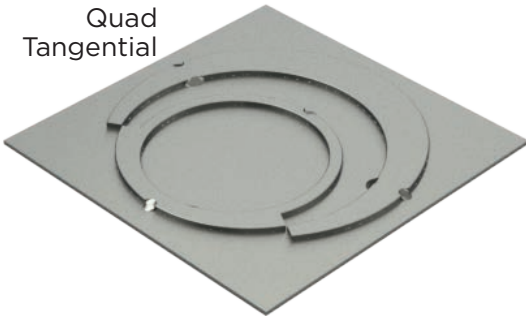
Single



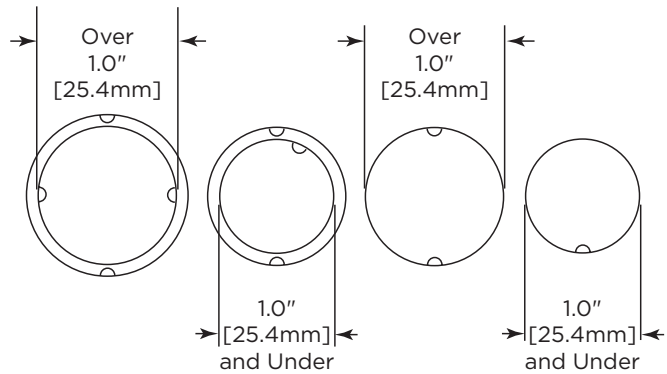
Triple



Quad
Tangential



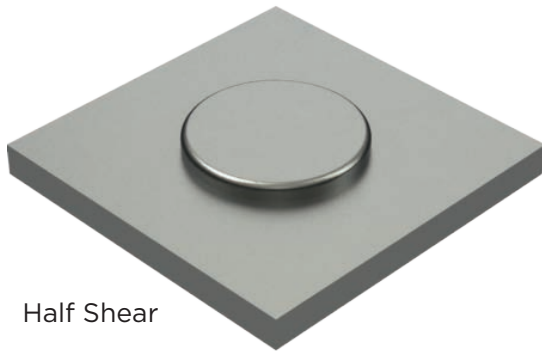
Standard Wilson Tool Tab Location



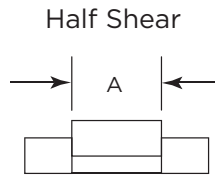
PUNCHING
SPECIALS
TEMPLATES

BENEFITS	CONSIDERATIONS	INFO NEEDED
<ul style="list-style-type: none"> Used to create connection points for cable pathways Available in standard and special shapes for: <ul style="list-style-type: none"> Single Double, Triple or Quad (concentric or tangential) Designed with full striping in both upper and lower units to produce good quality, reliable knockouts every time. Most EKO's can be used in a small range of material thicknesses (ex: 16-14 ga./1.5-2mm). Purchase only punch tip(s), ejector, and die assembly when changing sizes. Large station tool is designed as a punch tip, ejector and die assembly, and runs in a universal holder. For fast and easy adjustments on small station tools, an E-Z Set punch head is recommended. Coating options available for extended tool life. ABS compatible, minimizing wear and maintenance. 	<ul style="list-style-type: none"> Slow machine speed or program in post delay to give the tool time to strip. Consult with our Tooling Technicians for material thickness range when exceeding 14-gauge [2mm]. Special applications may affect pricing. <p>STOCK SIZES</p> <p>For 16 ga. Mild Steel:</p> <ul style="list-style-type: none"> Single EKO = .875" [22.22mm] or 1.125" [28.57mm] Double EKO = .875 x 1.125" [22.22 x 28.57mm] 	<ul style="list-style-type: none"> Machine model Material thickness and type Actual diameter (not conduit size) Form-up or Form-down Specify Standards or Special tab location and size Specify center-to-center if more than one knockout exists on the sheet

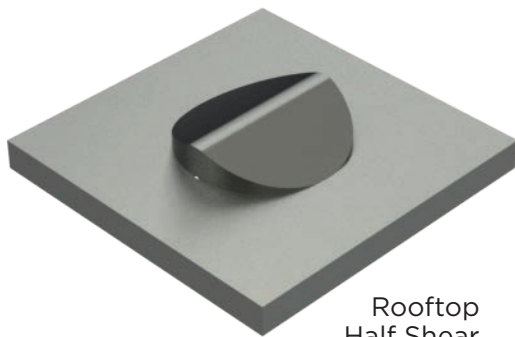
HALF SHEAR | ROOFTOP HALF SHEAR



Half Shear

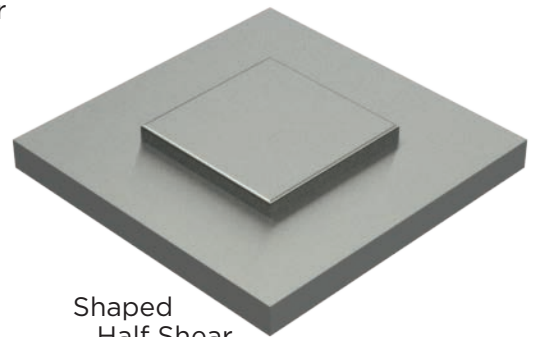
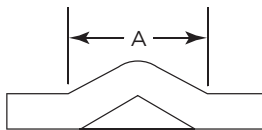
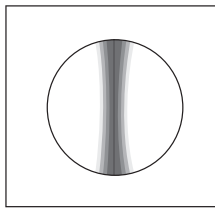


Half Shear



Rooftop Half Shear

Rooftop Half Shear



Shaped Half Shear

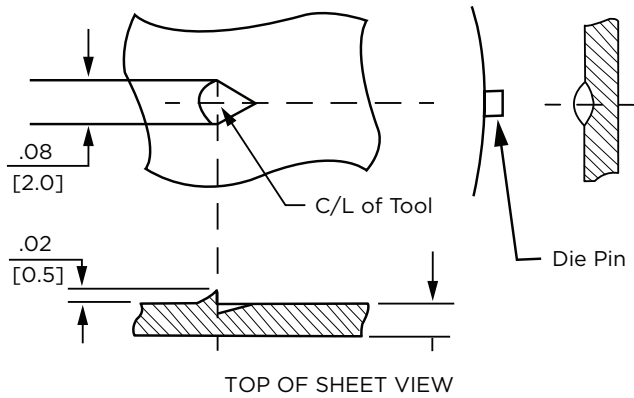


PUNCHING SPECIALS TEMPLATES

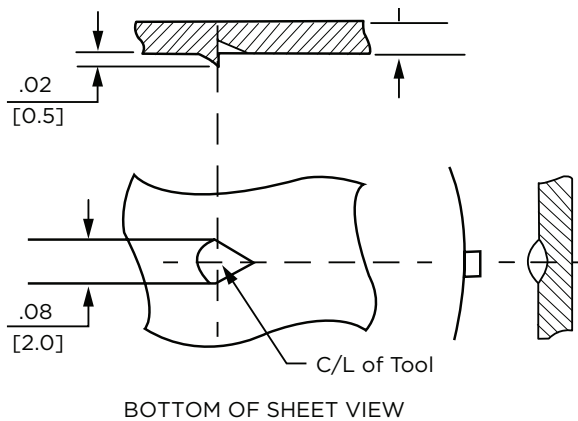
BENEFITS	CONSIDERATIONS	INFO NEEDED								
<ul style="list-style-type: none"> • Easy-to-use tool allows you to put in shear buttons and spot-welding locators to the accuracy of your punch press. • Round half shears make excellent locators for angular shearing. • Replaceable insert design up to .375" [9.53mm] diameter in lower unit of 1-1/4" (B) station half shear. • Form-up half-shears are available in stock sizes. • Half shears can be used on an .125" [3.17 mm] range of material. • Rooftop half-shear provide greater height protrusion from the metal which aids in picking up the locator on the sheet. • Form-down and large station half-shears are available. Consult with a Tooling Technician. • For fast and easy adjustments on small station tools, an E-Z Set punch head is recommended. 	<ul style="list-style-type: none"> • Half shears work best in thicker material. • A holding tab similar to an electrical knockout may be required on thin material. • Rooftop half shears have approximately a 3-gauge material thickness range. • Minimum recommended rooftop half shear is .250" [6.35mm] diameter. The most common size is .400" [10.1mm] diameter. • Never punch material thicker than what either tool was designed for. • Special applications may affect pricing. 	<ul style="list-style-type: none"> • Machine model • Material thickness and type (or range) • Diameter or shape (on top of sheet) • Specify center-to-center if more than one half shear exists on the sheet • Form-up or Form-down 								
		<p>STOCK SIZES</p> <p>For up to 1/8" [3.17mm] max. material thickness:</p> <table border="0"> <tr> <td>• .125"</td> <td>• 3mm</td> </tr> <tr> <td>• .200"</td> <td>• 4mm</td> </tr> <tr> <td>• .250"</td> <td>• 5mm</td> </tr> <tr> <td></td> <td>• 6mm</td> </tr> </table>	• .125"	• 3mm	• .200"	• 4mm	• .250"	• 5mm		• 6mm
• .125"	• 3mm									
• .200"	• 4mm									
• .250"	• 5mm									
	• 6mm									

SCRATCH TOOL

Top of Sheet



Bottom of Sheet



BENEFITS

- Use for spot welding locators, locators for angular shearing and shear stops.
- Height of the stop is .020 - .030" [.5 - .8mm]
- Designed with relief for .500" [12.7mm] center to center

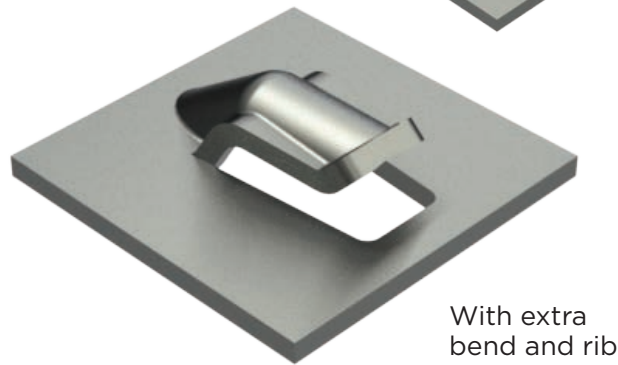
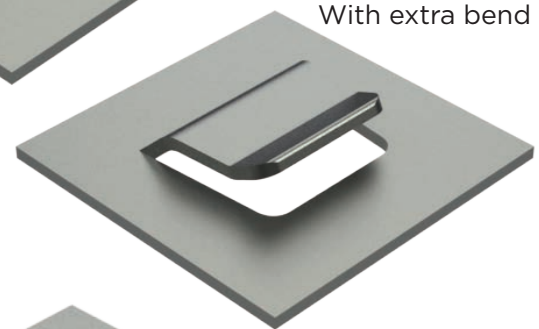
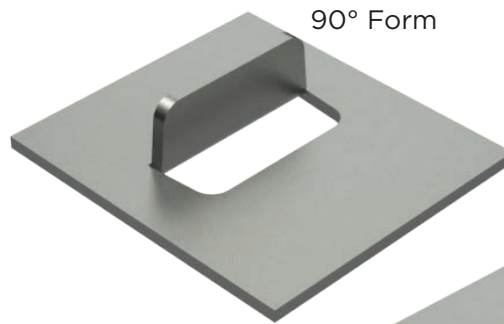
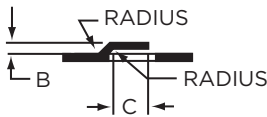
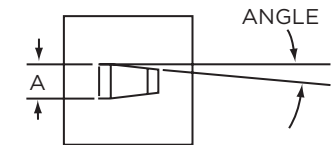
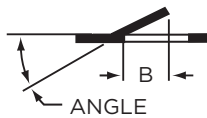
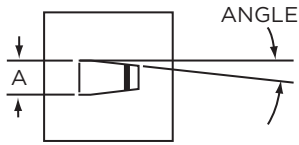
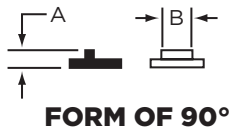
CONSIDERATIONS

- Punches a range of material from .036" - .125" [.91mm - 3.18mm]
- Can be used in an Auto Index station

INFO NEEDED

- Machine model
- Material thickness and type or range
- Specify top or bottom of the sheet scratch

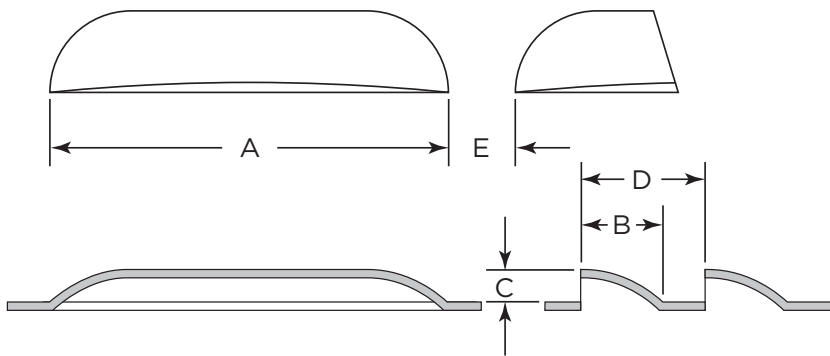
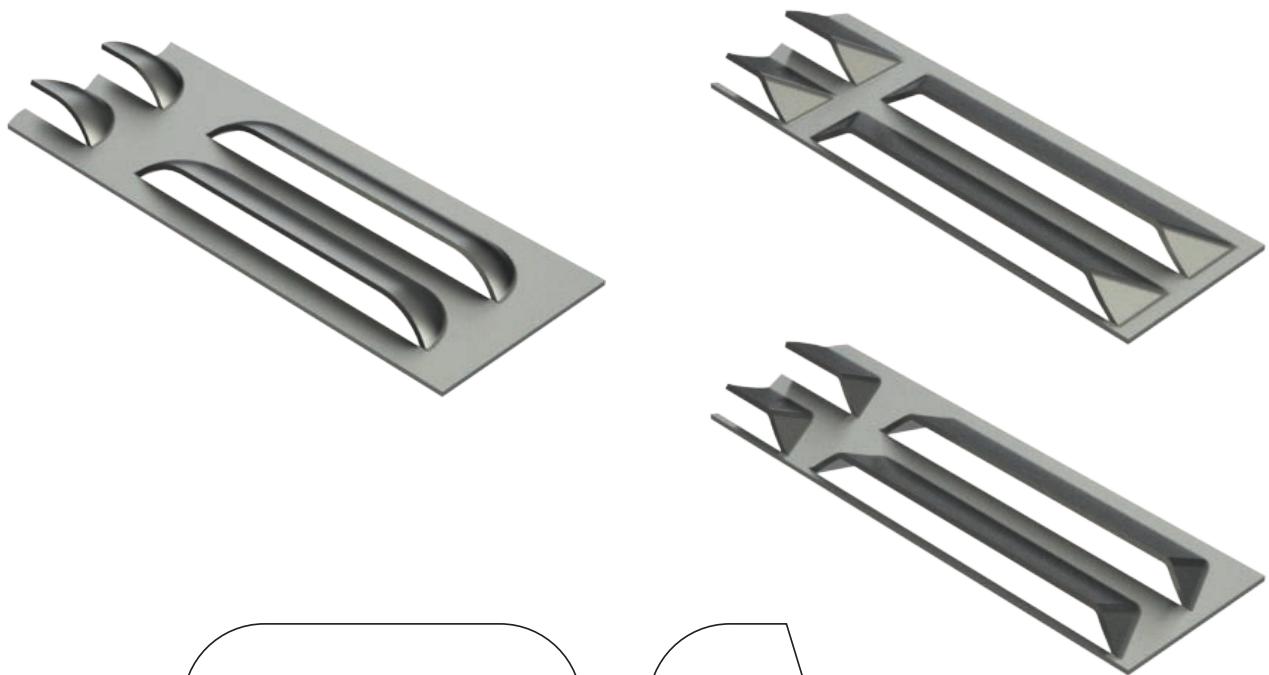
LANCE & FORMS



PUNCHING SPECIALS TEMPLATES

BENEFITS	CONSIDERATIONS	INFO NEEDED
<ul style="list-style-type: none"> Used in various applications including air flow, decoration, card guides, location markers, shear tabs, wire harnesses and clip attachments. Self-stripping and positive form design on lance and forms less than 90° assures consistent, trouble-free operation. Large station lance and forms are made from our complete holder design, eliminating the need for spring changes, assembly and disassembly. Large station tools are ordered as a replaceable tip and ejector design provides cost savings and flexibility and run in a universal holder. Coating options available for extended tool life. For fast and easy adjustments on small station tools, an E-Z Set punch head is recommended. 	<ul style="list-style-type: none"> Lance and forms of 90° must form a minimum of two material thicknesses overall. Forms of 90° may need to be pre-punched around tab when punching aluminum or thin material. A taper of 5° per side should be added to aid in stripping large station lance and forms other than 90°. Lance and forms are made for a particular material thickness. Never run thicker material or damage will occur. Special applications may affect pricing. 	<ul style="list-style-type: none"> Machine model Material thickness and type Complete drawings of the lance and form showing length, width, height, angles, and other forms (if any) near lance so proper relief can be built into the tool Style of large station guide assembly - for lance and forms of 90° only Form-up or Form-down

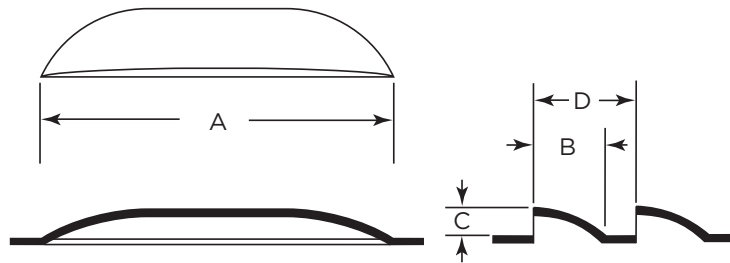
LOUVERS



PUNCHING
SPECIALS
TEMPLATES

BENEFITS	CONSIDERATIONS	INFO NEEDED
<ul style="list-style-type: none"> • Used in a variety of industry applications that require airflow, electrical enclosures, HVAC and food service equipment. • Stock sized louvers are available. • Large station louvers run in a universal holder design which includes spring loaded adjusting plunger for quick and easy length adjustments. • Lower costs with replaceable inserts that can be converted to different size Louvers. • Single hit Louvers can be placed back-to-back (no web between Louvers). • Keying at 0°, 90°, 180°, 270° is standard. • Coating options available for extended tool life. • ABS compatible, minimizing wear and maintenance. 	<ul style="list-style-type: none"> • Max. louver width on standard design is .750" [19mm] (special wide louvers are available). • The "drawing back" of material is more noticeable on higher forms. • Max. material thickness for mild steel in our standard design is .125" [3.17mm]. Consult with a Tooling Technician for thicker material. • A specially designed forming insert is required when using stainless steel. • Consult with a Tooling Technician for non-standard sizes, 1-1/4" (B) and 2" (C) station. 	<ul style="list-style-type: none"> • Machine model • Material thickness and type • A, B, C, D and E dimensions

PROGRESSIVE LOUVERS — FORM-UP



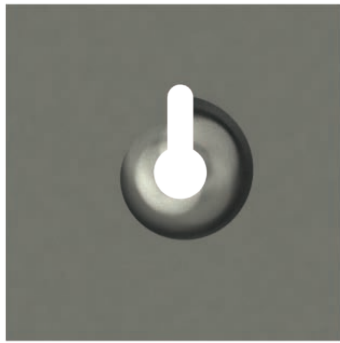
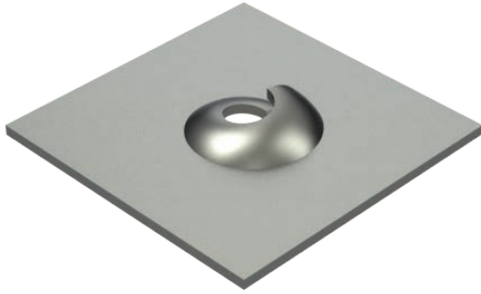
'A' dimension is programmable to any length.
Form length on first full hit is approximately 2-1/4" [57mm] long.



PUNCHING
SPECIALS
TEMPLATES

BENEFITS	CONSIDERATIONS	INFO NEEDED
<ul style="list-style-type: none"> • Large station louvers run in a universal holder design which includes spring loaded adjusting plunger for quick and easy length adjustments. • Lower costs with replaceable inserts that can be converted to different size Louvers. • No restrictions on the length of the louver. Simply program in any length. • Keying at 0°, 90°, 180°, 270° is standard. • Limited sheet feed direction. Instructions provided with tooling. • Coating options available for extended tool life. • ABS compatible, minimizing wear and maintenance. 	<ul style="list-style-type: none"> • Max. louver width on standard design is .750" [19mm] (special wide louvers are available). • The "drawing back" of material is more noticeable on higher forms. • Max. material thickness in mild steel and aluminum is .125" [3.17mm] and .090" [2.3mm] for stainless steel. • A specially designed forming insert is required when using stainless steel. • Progressive louvers are made for a specific material thickness. A separate pocket insert is required for each material thickness. • Consult with a Tooling Technician for non-standard sizes. 	<ul style="list-style-type: none"> • Machine model • Material thickness and type • B, C and D dimensions • Electronic file or dimensional drawing

THREAD FORM



SPECIALS

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

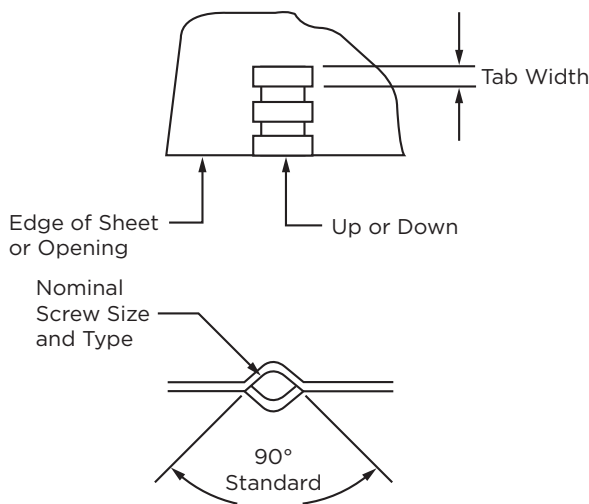
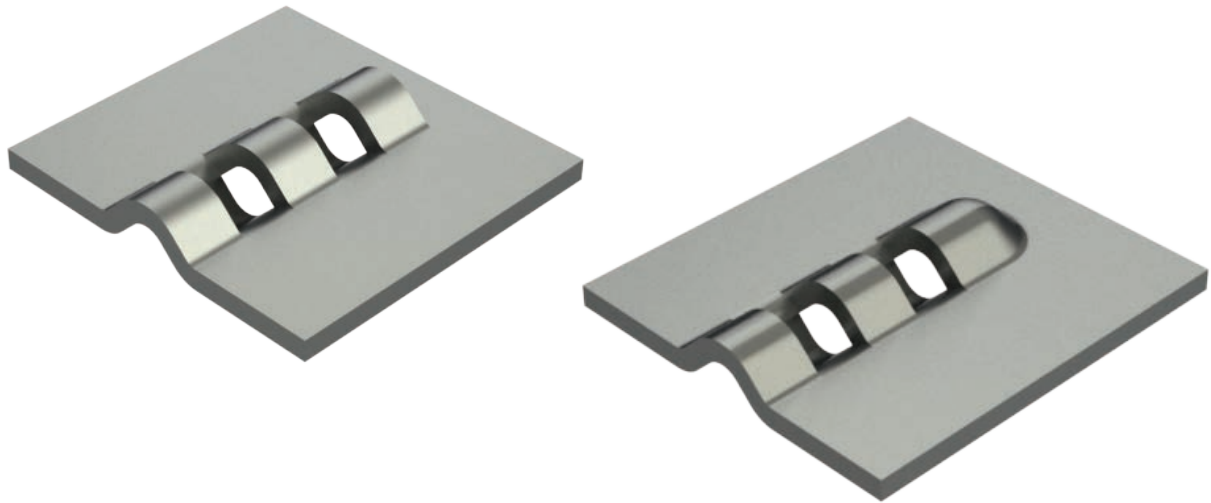
THREAD FORM						
THREAD SIZE	6 - 18 8 - 15 10 - 12	12 - 11 14 - 10 20 - 9	6 - 20 8 - 18 10 - 16	12 - 14 1/4 - 14 5/16 - 12	6 - 32 8 - 32 10 - 24	10 - 32 1/4 - 20 5/16 - 12
SCREW TYPE	 A		 B	 AB	 C (Machine Screws)	



PUNCHING SPECIALS TEMPLATES

BENEFITS	CONSIDERATIONS	INFO NEEDED
<ul style="list-style-type: none"> A great solution for threading thin material that eliminates secondary operations and costly supplemental hardware. Pre-punch information provided. For fast and easy adjustments on small station tools, an E-Z Set punch head is recommended. To use with material thinner than what tool was designed for, adjust length of the tool for the different material. (Never run material thicker than what the tool was designed for.) Non-standard thread forms available. Consult with a Tooling Technician Sheet feed direction provided on form-down thread forms. Coating options available for extended tool life. 	<ul style="list-style-type: none"> Operations to produce a Thread Form: Pre-punch and Thread Form. Keyhole pre-punch recommended for stainless and for #10 and M-5 screw size or smaller for all materials. (keyhole pre-punch provides the necessary clearance to engage screws, as well as to extend tool life.) Consult with a Tooling Technician for size and material thickness restrictions. Sample screw may be required on non-standard sizes for proper fit. Special applications may affect pricing. 	<ul style="list-style-type: none"> Machine Model Material thickness and type Thread size and type Electronic file or dimensional drawing

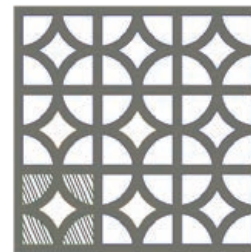
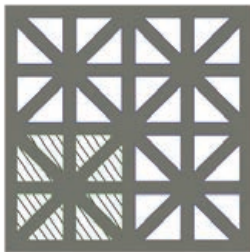
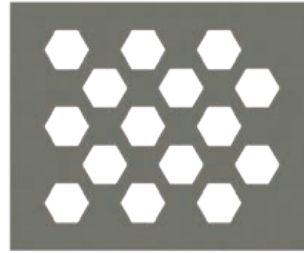
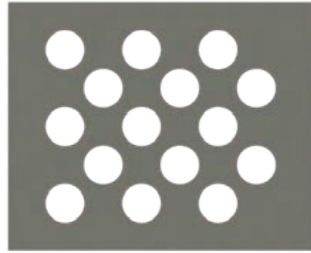
THREAD LOOP



PUNCHING
SPECIALS
TEMPLATES

BENEFITS	CONSIDERATIONS	INFO NEEDED
<ul style="list-style-type: none"> • A great solution for eliminating secondary operations and supplemental hardware when a threaded hole is required. • The Wilson Tool design gives a positive form, which ensures a high-quality part. • For fast and easy adjustments on small station tools, an E-Z Set punch head is recommended. • Coating options available for extended tool life. 	<ul style="list-style-type: none"> • Tool is made for one specific material thickness. Never punch material thicker than what the tool was designed for. • Widths less than .070" [1.78mm] will alter price. Consult with a Tooling Technician. • Special applications may affect pricing. 	<ul style="list-style-type: none"> • Machine model • Material thickness and type • Number of thread loop tabs • Width of tab • Diameter of opening or screw size and type • Drawing if possible

CLUSTER TOOL



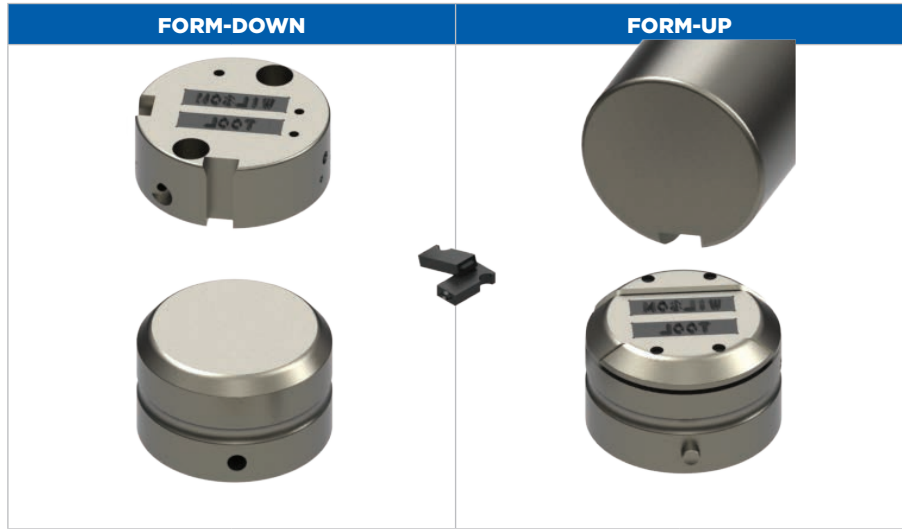
SPECIALS



PUNCHING
SPECIALS
TEMPLATES

BENEFITS	CONSIDERATIONS	INFO NEEDED										
<ul style="list-style-type: none"> The most cost-effective method to manufacture perforations or other repetitive applications. Saves on machine punching time and tool maintenance time. The best choice when punching a pattern of holes that require extremely close center-to-center tolerances. Different design styles are available to suit your specific cost and manufacturing needs. The replaceable insert design (Style B) provides additional cost savings with a replaceable punch tip. Finished parts produced with each hit when your cluster tool is made to progressively pierce and blank, or pierce, form and blank. Coating options available for extended tool life. Slug Hugger® 2 dies are available for most applications. 	<ul style="list-style-type: none"> To warranty the die, round holes must have a web between holes of .125" [3.17mm] or two (2) times the material thickness, whichever is greater. Long and narrow shapes must have a web between holes: <table border="1" data-bbox="699 1486 1161 1644"> <thead> <tr> <th>SHAPE LENGTH</th> <th>MINIMUM WEB</th> </tr> </thead> <tbody> <tr> <td>≤ .500" [12.7mm]</td> <td>.125" [3.17mm]</td> </tr> <tr> <td>.501-1.0" [12.7-25.4mm]</td> <td>.187" [4.75mm]</td> </tr> <tr> <td>1.001-2.0" [25.42-50.8mm]</td> <td>.25" [6.35mm]</td> </tr> <tr> <td>≥ 2.001" [50.82mm]</td> <td>.312" [7.92mm]</td> </tr> </tbody> </table> Material thickness, type and pattern may alter minimum web requirements. Consult with a Tooling Technician. Because of the variety of hole patterns, number and size of holes, and styles of tools, contact a Tooling Technician for more information. Special applications may affect pricing. 	SHAPE LENGTH	MINIMUM WEB	≤ .500" [12.7mm]	.125" [3.17mm]	.501-1.0" [12.7-25.4mm]	.187" [4.75mm]	1.001-2.0" [25.42-50.8mm]	.25" [6.35mm]	≥ 2.001" [50.82mm]	.312" [7.92mm]	<ul style="list-style-type: none"> Machine model Material type and thickness or range Number of hole clusters Straight or staggered pattern Center-to-center dimensions Replaceable (B) or Solid (C) style desired Style of large station guide assembly
SHAPE LENGTH	MINIMUM WEB											
≤ .500" [12.7mm]	.125" [3.17mm]											
.501-1.0" [12.7-25.4mm]	.187" [4.75mm]											
1.001-2.0" [25.42-50.8mm]	.25" [6.35mm]											
≥ 2.001" [50.82mm]	.312" [7.92mm]											

LETTER STAMP



STATION SIZE			
B 1-1/4"	D 3-1/2"	B 1-1/4"	D 3-1/2"

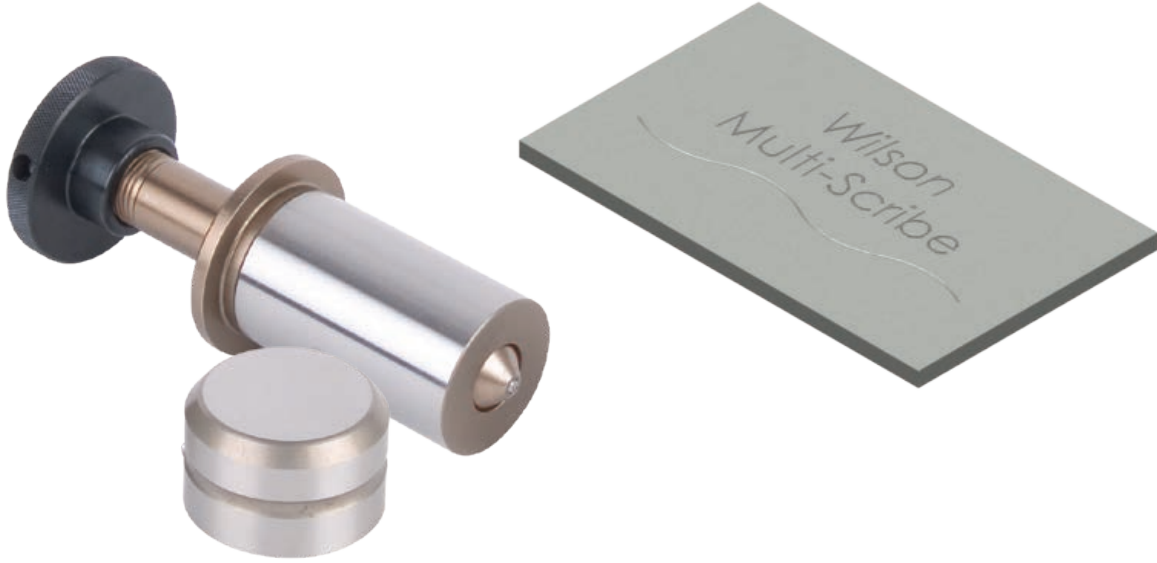
Character Size	MAXIMUM NUMBER OF CHARACTERS PER ROW FOR 1- OR 2-ROW STAMP			
1/16" [1.57mm]	22	48	20	53
3/32" [2.36mm]	14	32	14	35
1/8" [3.17mm]	10	24	10	26
3/16" [4.75mm]	7	16	7*	17
1/4" [6.35mm]	5	12	5*	13
3/8" [9.52mm]	3*	8*	3*	8*

*Available in 1-row configuration only

SPECIALS

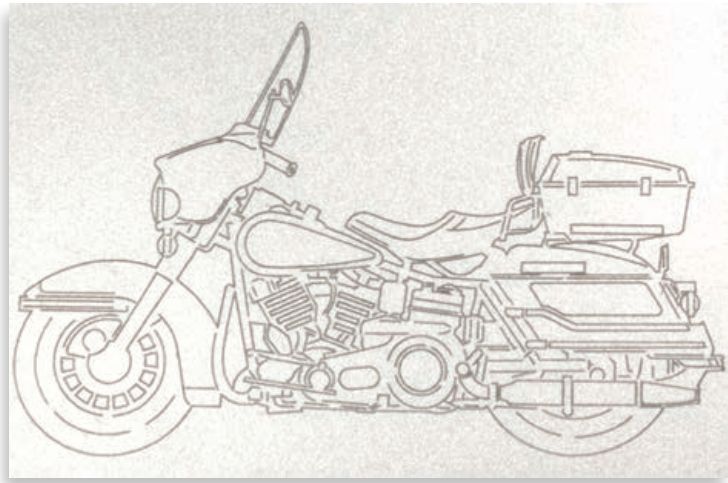
BENEFITS	CONSIDERATIONS	INFO NEEDED
<ul style="list-style-type: none"> Stamping while in the machine eliminates secondary handling costs and ensures consistent marking. Cost-saving replaceable insert design allows for versatility as well as quick and easy replacement. Change character size and number of rows simply by changing the punch tip and characters. Adjustable to stamp an 1/8" [3mm] range of material. Form down logos available in coined or embossed styles. Consult with a Tooling Technician for more information. Reference chart for stock sizes. For fast and easy adjustments on small station tools, an E-Z Set punch head is recommended. 	<ul style="list-style-type: none"> Characters not included in set price. For form-up applications, faster character wear will occur in stainless steel and more sheet marking will occur in aluminum if the die is not made self-stripping. Consult with a Tooling Technician for maximum number of characters with multiple rows. Special applications may affect pricing. 	<ul style="list-style-type: none"> Machine model Material thickness and type Character size, number of rows, number of characters per row Station size and style of tooling Style of large station guide assembly Form-up or Form-down

WILSON MULTI-SCRIBE®



KIT CONTENTS

- 1 - Punch & Die Assembly
Assembled with 120° diamond and red medium pressure spring
- 1 - Yellow Light Spring
- 1 - Green Heavy Spring
- 1 - 150° Diamond Insert
- 1 - 90° Carbide Insert
- 1 - 3mm Hex Wrench
- 1 - Set of User Instructions



BENEFITS

- Use for sheet "scribing" or dot-matrix marking.
- Works on a range of materials.
- Variable scribe depth.
- Design allows for consistent mark depth.
- Long lasting diamond tip.
- Won't deform the material or mark the underside of the sheet.

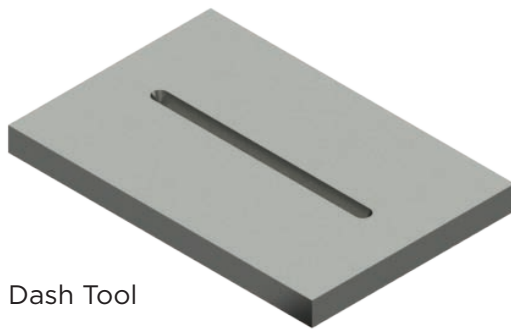
CONSIDERATIONS

- Machines with a programmable hydraulic ram can use both the "scribe" feature and the "dot matrix" feature of this tool.
- Machines with a mechanical ram can only use the "dot matrix" feature.

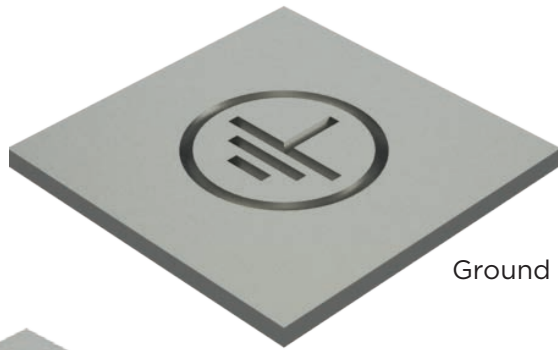
INFO NEEDED

- Machine model
- Material thickness and type

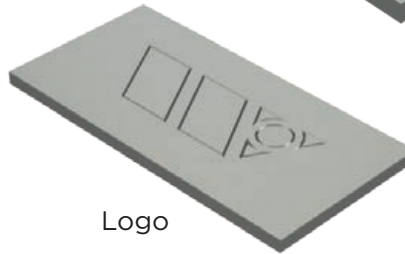
STAMPING



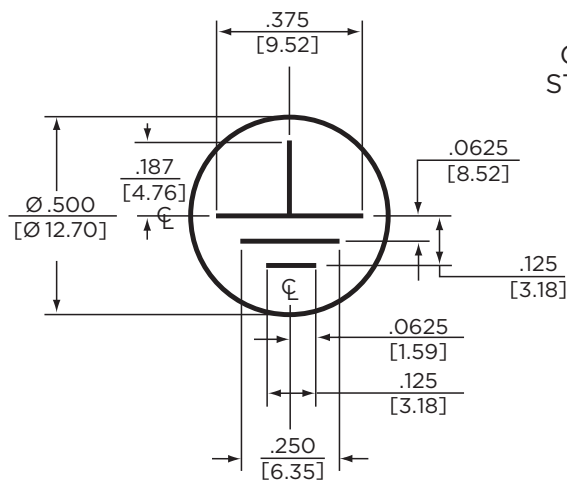
Dash Tool



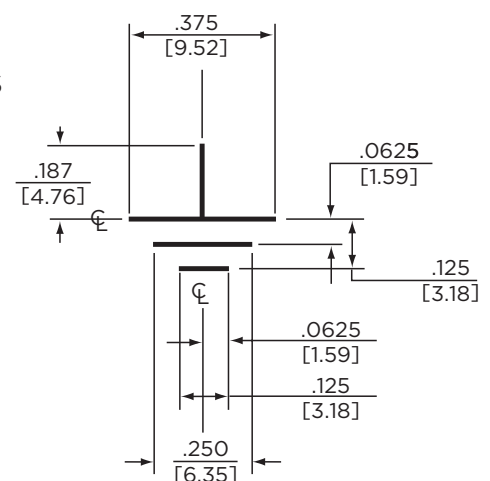
Ground Symbol



Logo



GROUND SYMBOL STOCK DIMENSIONS



BENEFITS	CONSIDERATIONS	INFO NEEDED
<ul style="list-style-type: none"> Dash tools can be used in various applications, such as creating numbers or letters, coining a "V" groove on bend lines to aid in the bending of the sheet, and locators on a sheet. Ground symbols, widely used in the electrical, are available as a stock item with or without the circle. Both dash tool and ground symbol are available in form-up or form-down. Form-up is designed self-stripping to prevent sheet marking and tool wear on both dash tool and ground symbol. Logos and other special stamps also can be manufactured. Consult a Tooling Technician for additional details. For fast and easy adjustments on small station tools, an E-Z Set punch head is recommended. 	<ul style="list-style-type: none"> Thin material may polish on back side of sheet when stamped. Dash tool must be run in the Auto Index station when creating numbers or letters. Special applications may affect pricing. 	<ul style="list-style-type: none"> Machine model Maximum material thickness and type Length of dash Size of ground symbol (stock or non-stock) Form-up or form-down For Auto Index station or standard Style of large station guide assembly

ZIP-TECH



Scan QR Code to See
More Connective Forms



BENEFITS

- Fabricates snaps to join metal parts together.
- Different types of materials of the same thickness can be joined together.
- Eliminate time consuming and labor-intensive welding and grinding operations, spot welding or other fastening methods.

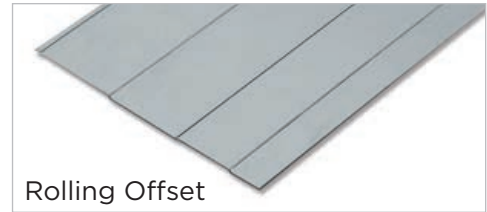
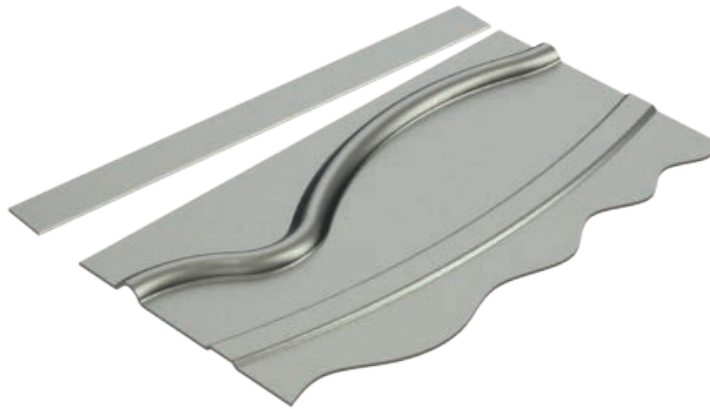
CONSIDERATIONS

- Zip-Tech lance is achieved in three operations:
 - Step 1 Pre-punch: Round hole
 - Step 2 Pre-punch: T-shape hole
 - Step 3 Zip-Tech Lance and Form

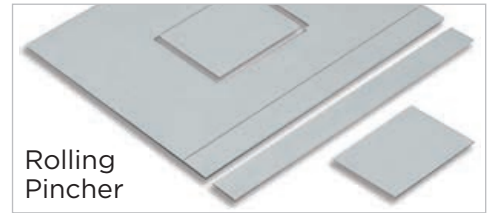
INFO NEEDED

- Machine Model
- Material thickness and type
- Auto Index stations available

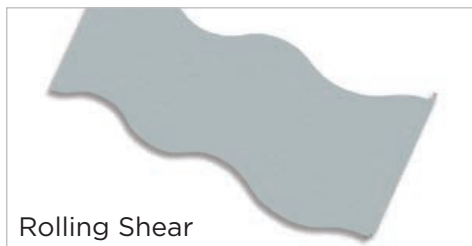
WILSON WHEEL® FAMILY



Rolling Offset



Rolling Pincher



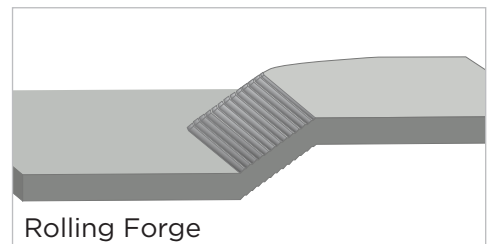
Rolling Shear



Rolling Flare



Rolling Rib



Rolling Forge

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



SPECIALS

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

E-Z SET PUNCH HEAD



CAT. NO.	
E-Z SET PUNCH HEAD	
1-1/4" B-Station*	10037
ACCESSORIES	
Guide Collar*	10056
Disc Springs* (Qty. 12)	10057
Coil Spring*	6574

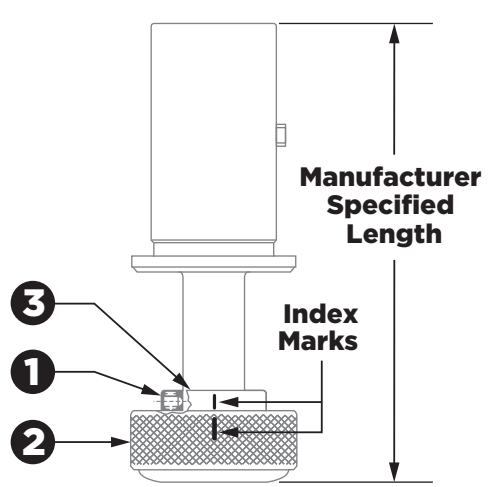
**Required on forming or coining tools that are designed as a punch and guide assembly.*

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



SPECIALS

E-Z SET PUNCH HEAD INSTRUCTIONS	
Step 1	Align the index marks on the two pieces of the E-Z Set punch head. (Details 2 and 3)
Step 2	Holding the two pieces together, install the punch head onto the punch shank by turning the head clockwise to the manufacturer's specified length.
Step 3	Tighten the two 5mm set screws (Detail 1).
Step 4	To increase the length (DO NOT loosen the set screws), just lift the outer ring (Detail 2) and turn counter clockwise. Each click provides a .0026" [0.066mm] incremental change in the tool length. The maximum length adjustment is approximately .125" [3.18mm]. When the limit is reached, the head will rotate freely for approximately one quarter turn.
Step 5	On forming tools made for more than one material thickness, set the manufacturer's specified length to the thicker material and adjust for the thinner material.
Step 6	Resetting the head for further adjustment is NOT RECOMMENDED because of reduced thread engagement. DAMAGE MAY OCCUR.



BENEFITS
<p>The E-Z Set punch head provides quick turn-of-the-wrist adjustment. You can achieve just the right mark or form when using the punch head on 1-1/4" B station stamping and forming tools. Trial and error is streamlined. Costly machine down time for tool adjustment is converted into productive machine up time.</p> <p>Each adjustment click provides a .0026" [0.066mm] incremental change in the tool length. The maximum adjustment is approximately .125" [3.18mm]. A simple lift and turn of the adjustable head is all that is required. Fine length adjustments can now be made without removing the tool from the turret. You will see instant payback based on reduced machine down time.</p>

WILSON TOOL INTERNATIONAL'S SLUG HUGGER® 2 ELIMINATES COSTLY SLUG PULLING

Manufacturers simply cannot afford frequent press downtime. The Slug Hugger® 2 die design from Wilson Tool International helps eliminate the very costly problem of slug pulling — a major contributor to extra downtime.

The Slug Pulling Solution

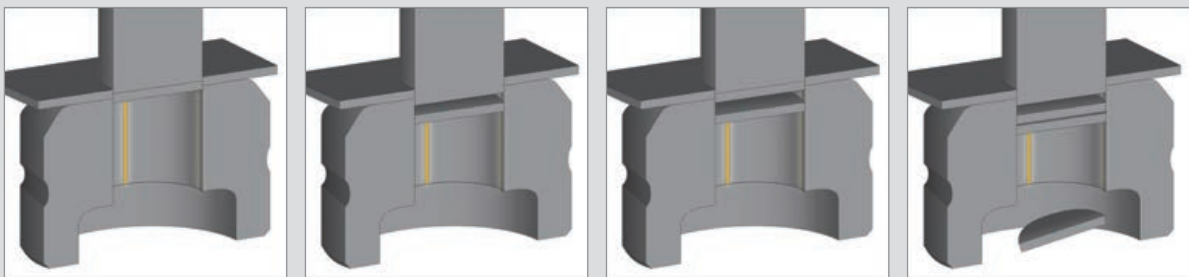
- Reduce scrapped parts, costly downtime, and possible press and tooling damage from slug pulling.
- Unique design helps eliminate unnecessary back-pressure on small punch tips by preventing packed slugs.
- Works on most material types and thicknesses including aluminum and stainless steel.
- Available for all tooling styles.



SLUG PULLING

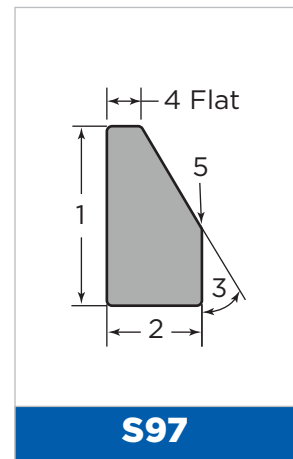
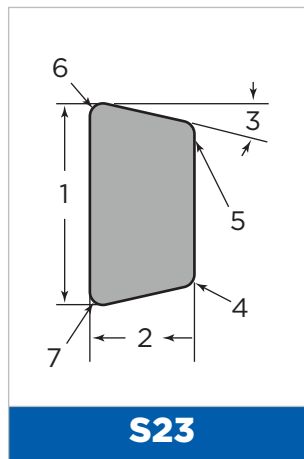
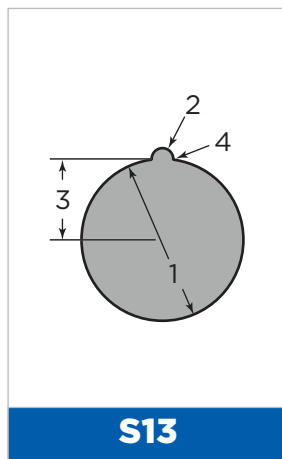
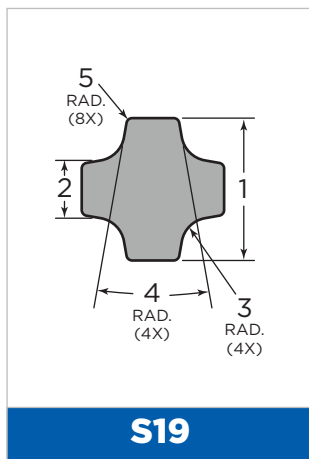
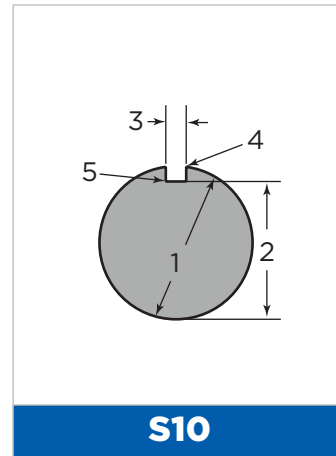
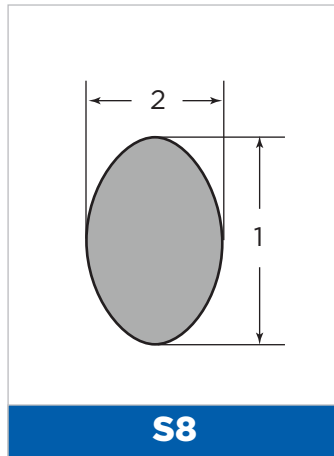
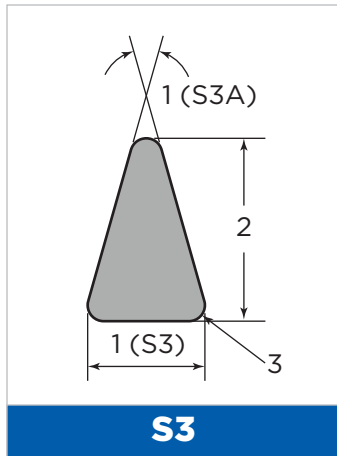
How Does it Work?

The Slug Hugger® 2 grabs the slug just below the cutting surface of the die and retains it during the stripping process. Precision “nips” hold slugs in the die and when capacity is reached, one slug per hit is released through the relief.



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

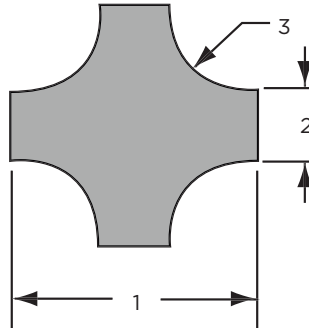
SPECIAL SHAPES



NOTE: Additional shapes available. Special considerations may alter price and lead time.

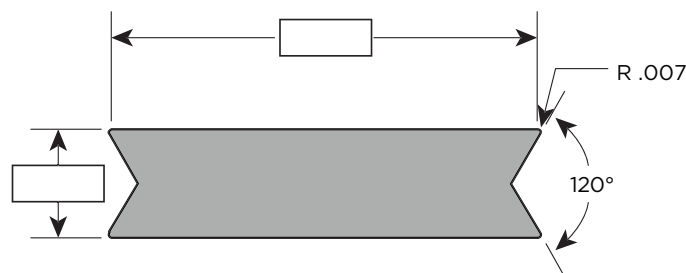
4-WAY RADIUS TOOLS

STANDARD SIZES



4-WAY RADIUS TOOLS – STANDARD SIZES			
RADIUS inch [mm]	DIM. 1 inch [mm]	DIM. 2 inch [mm]	DIM. 3 inch [mm]
.062 [1.58]	.500 [12.7]	.250 [6.35]	.062 [1.58]
.094 [2.39]	.625 [15.87]	.250 [6.35]	.094 [2.39]
.125 [3.18]	.625 [15.87]	.250 [6.35]	.125 [3.18]
.156 [3.96]	.750 [19.05]	.250 [6.35]	.156 [3.96]
.188 [4.78]	.750 [19.05]	.250 [6.35]	.188 [4.78]
.250 [6.35]	.875 [22.22]	.250 [6.35]	.250 [6.35]
.312 [7.93]	1.000 [25.4]	.250 [6.35]	.312 [7.93]
.375 [9.53]	1.125 [28.57]	.250 [6.35]	.375 [9.53]
.500 [12.7]	1.250 [31.75] Ø	.250 [6.35]	.500 [12.7]

INVERTED DIAMOND



HAND TOOLS

MAGNET SQUARE



- ON/OFF work holding magnet 150 lb. [70 kg] of hold force.
 - Size: [30mm] Square
- Catalog No. 974150**

EXP® PUNCH REMOVAL KEY



For use with EXP® punches.

Catalog No. 6989

SAE HEX KEY WRENCH SET



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

Catalog No. 6057

OIL STONE



3 square aluminum oxide sharpening stone.

Catalog No. 6060

METRIC HEX KEY WRENCH SET



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

Catalog No. 6105

DIAMOND FILE



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

Catalog No. 6059

SOFT FACE HAMMER



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

Catalog No. 6106

T-HANDLE EXTRACTOR



Used for large station guide assemblies.

Catalog No. 6483

TRU-ARC PLIERS



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

Catalog No. 6056

SPANNER WRENCH



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

Catalog No. 6058

HAND TOOLS

TOOL KIT



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

Catalog No. 6091

DIGITAL MEASURING EQUIPMENT

DIGITAL ANGLE CUBE



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

Catalog No. 974119

DIGITAL PROTRACTOR RULER



Lightweight, easy-to-use, highly accurate protractors measure angles from 0° to 360° with an accuracy of ±.01 degrees. Set angles in .05° increments. Front locking lever to hold the arm position. A hold function and reverse reading capability.

Catalog No. 980065

ZIP-MAR ADHESIVE DISCS

ZIP-MAR ADHESIVE DISCS



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

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

ALIGNMENT TOOLS

ALIGNMENT TOOLS



DESCRIPTION	CAT. NO.
1-1/4" Upper Unit	494
1-1/4" Lower Unit	495
2" Upper Unit	S190
2" Lower Unit	1841
3-1/2" Upper Unit	496
3-1/2" Lower Unit	497

ACCESSORIES

BALL RIDING & BRUSH DIE

BALL RIDING DIES



A spring loaded ball designed to help eliminate sheet hang-up from material running into a higher die, sheet deformation from punching next to dies of different heights and damage to die inserts when the die cap receives uneven loading.
OAH = 1.328" [33.73mm].

STATION SIZE	CAT. NO.
1-1/4"	10685

BALL RIDING DIES

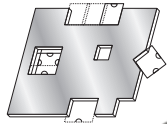


Used primarily in applications where any marking that might be caused by ball riding dies is not acceptable.
OAH = 1.248" [31.7mm].

STATION SIZE	CAT. NO.
1-1/4"	2761

ADAPTERS

SQUARE SHEAR-PROOF ADAPTER



FAB 7/8" [22.2mm]

DESCRIPTION	CAT. NO.
Punch & Guide Assembly	223
Punch only	228
Adjustable Punch Head	145
Spring	125
Guide Collar with O-Ring	146
Guide (Slip Fit Shaped)	231
Die (Positive)	162
Die (Slug Hugger® 2)	10073
Punch Shims (single)	152



THIN TURRET ADAPTER



Adapts 3-1/2" assembly to accept 1-1/4" station tooling

DESCRIPTION	CAT. NO.
Punch Assembly for Fab Station	10059
Die Adapter	10096
Keyed 4 ways for use in all machines	1949

TOOL STORAGE | SHEAR GRINDING FIXTURE

TOOL STORAGE CABINET — 9 DRAWERS



989826



989827

6 Drawers for 1-1/4" Station Tooling - 3" [76.2mm]

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

2 Drawers for 3-1/2" Station Tooling - 5" [127.0mm]

- 16 sets tooling (per drawer)

1 Drawer for 5" Station Tooling - 8" [203.2mm]

- 9 compartments for 5" guide assemblies or miscellaneous tooling

THIN TURRET TOOLING STORAGE CABINETS

W x D x H	Cat. No.
30" x 27" x 42" [76.2 x 68.5 x 106.6cm]	989826
30" x 27" x 47.5" [76.2 x 68.5 x 120.6 cm]	989825

Scan QR Code for More Storage Details



ACCESSORIES

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



SHEAR GRINDING FIXTURE



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

SHEAR GRINDING FIXTURE & ACCESSORIES

Description	CAT. NO.
Shear Grinding Fixture	6034
EXP® Sharpening Adapter	6990
1/2" Tooling Sleeve Adapter	6045
5/8" Tooling Sleeve Adapter	6046
1-1/4" Tooling Punch and Die Holder	6044
2" & 3-1/2" Tooling Punch Holder	6041
Universal Notch Punch Holder	6071
HP DuraBlade® Grinding Fixture	6932
Pointer (Replacement)	6035
Degree Scale (Replacement)	6036

MULTI-TOOL PUNCH & DIE HOLDERS

Description	CAT. NO.
8 Station Punch & Die Holder	6159
8mm Punch & Die Holder	6156
16mm Punch & Die Holder	6157
24mm Punch & Die Holder	6158

XSHARP™ GRINDER

Scan QR Code to See XSharp™ in Action



ACCESSORIES



Benefits of Accurate Regrinding

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

Fully Automated Grinding Process

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

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

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

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

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

Interlocking Safety Guard: Automatically opens and closes

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

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

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

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

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

5 EASY STEPS TO A SHARPER EDGE



Step 1. Load tool into chuck



Step 2. Set tool style



Step 3. Set tool size



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



Step 5. Touch start to sharpen the tool

TOOL MAINTENANCE

NYLON VICE JAWS



Used to aid in the assembly and maintenance of Thin and Thick Turret style punch assemblies.

Catalog No. 24001

RUBBERIZED ABRASIVE WHEEL



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

Catalog No. 8050

LUBRICANTS

PUNCH LUBRICANT



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

Catalog No. 6055

SHEET LUBRICANT



- Xcel 1 Liter Spray Bottle
Catalog No. 24315
- Xcel 5 Liter Concentrate
Catalog No. 24316

CUT-MAX 570



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

Catalog No. 6941

SURE SHOT SPRAYER



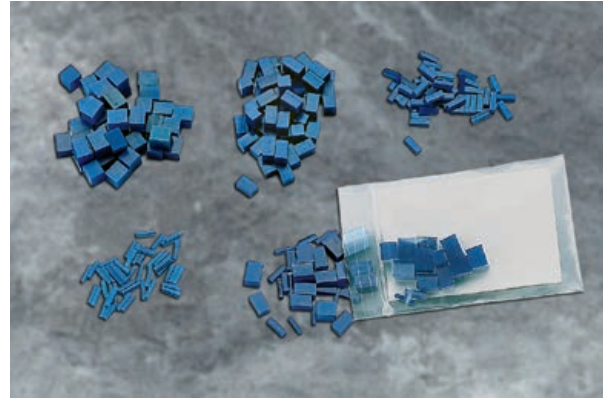
1 Quart [.95 Liter] capacity enamel steel sprayer with adjustable plastic nozzle.

Catalog No. 6120

DIE & PUNCH SHIMS

STATION	THICKNESS	QUANTITY	CAT. NO.
DIE SHIMS			
1-1/4"	.010" [0.25mm]	1	2097
		Package of 25	2209
	.030" [0.76mm]	1	2723
		Package of 25	2724
3-1/2"	.060" [1.5mm]	1	2100
		Package of 25	2173
	.010" [0.25mm]	1	2081
		Package of 5	2211
3-1/2"	.030" [0.76mm]	1	2727
		Package of 5	2728
	.060" [1.5mm]	1	2084
		Package of 5	2175
PUNCH SHIMS			
1/2"	.060" [1.5mm]	1	100
		Package of 25	99
1-1/4"	.060" [1.5mm]	1	152
		Package of 25	98

SLUG EJECTORS



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

TURRET BUSHINGS

MACHINE MODELS	KEYING	CAT. NO.
1-1/4" STATION 2.437" [61.9mm] Flange O.D.		
<ul style="list-style-type: none"> Any SAF that uses Strippit® 1-1/4" Tool Holder Assembly #62532-000 or #62515-000 T-SAF-30, FC75/30, FC750, FC1000 (I & II), FC1250 Cap 1000 	0° - 90° (Standard)	15
	0° - 90° - 180° & 270°	490
	0° - 45° - 180° & 315°	491
	0° - 135° - 225° & 270°	492
1-1/4" STATION 2.375" [60.3mm] Flange O.D.		
<ul style="list-style-type: none"> FC1000 III & 33 STN. 1250, FC1000R 	0° - 90° - 180° & 270°	471
	0° - 45° - 180° & 315°	
	0° - 135° - 225° & 270°	
	Multiple Keyways	
3-1/2" STATION		
<ul style="list-style-type: none"> FM-30-30 	1 Keyway	280
<ul style="list-style-type: none"> Any SAF that uses Strippit® 3-1/2" Tool Holder Assembly #62530-000 or #93023-100, 200 T-SAF-30, FC75/30, FC750, FC1000 (I, II & III), FC1250 Cap 1000, all XT & S Series machines 	1 Keyway	277



SHEAR OPTIONS

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

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

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



PUNCHING FORCE CHART

SHEAR DETAILS	A DIMENSION	EXCEPTION	SPECIAL SHEAR DETAILS
<ul style="list-style-type: none"> 1/32" [1.6mm] rooftop shear is given to all punches with A Dimension+ greater than 2.000" [50.8mm] and width greater than .250" [6.35mm] at no extra charge. All punches .250" [6.35mm] and under in width will be shipped with no shear unless specified. 		<p>In some instances, inverted rooftop is substituted for single and double concave shears.</p>	<ul style="list-style-type: none"> If specified: 1/16" [1.57mm] maximum rooftop shear can be given at N/C for any round or shape in 3-1/2" station. For rooftop shear on any round or shape in 1-1/4" station, additional charges apply.

STANDARD SHAPES

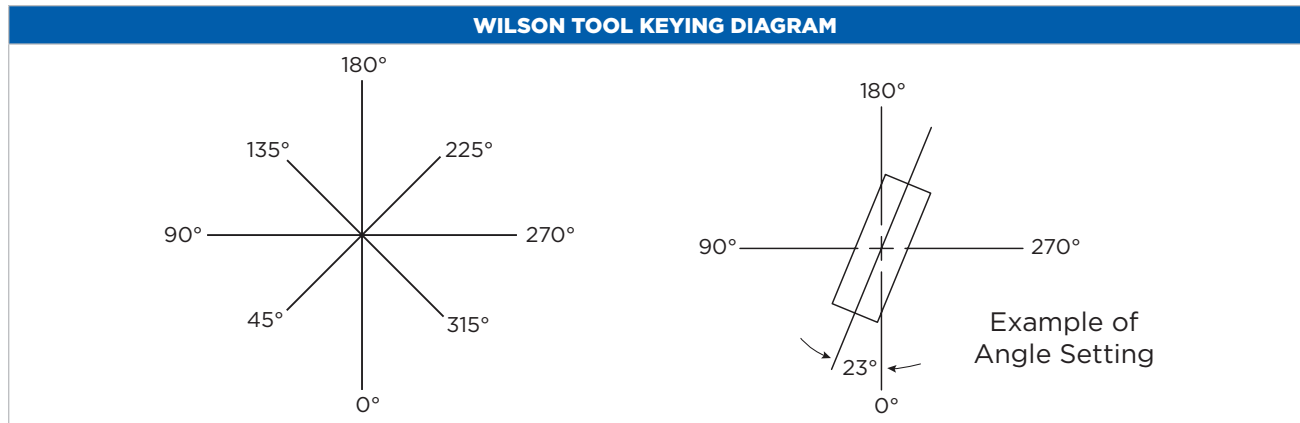
Obround	Square	Rectangle	Hexagon	Octagon	Single-D	Double-D	Obround	Quad-D	Equilateral

STANDARD KEYING LOCATIONS

REFERENCE

PUNCH VIEW					DIE VIEW				
1/2", 5/8" AND 1-1/4" STATION									
2" STATION									
3-1/2" STATION									

NON-STANDARD KEYING | DIE CLEARANCE



SHAPE AT SINGLE ANGLES OTHER THAN STANDARD			
STATION	PUNCH	DIE	GUIDE OR STRIPPER
1/2", 5/8"	N/C		N/C
1-1/4"			N/A
2"			N/A
3-1/2"			N/A

No additional charge on 1-1/4" station for shape at 45° increments

STANDARD KEYING, PLUS EXTRA PINS OR KEYS FOR SHAPES AT OTHER THAN 45° INCREMENTS			
STATION	PUNCH	DIE	GUIDE OR STRIPPER
1/2", 5/8"	N/A	N/A	N/A
1-1/4"	N/A	N/A	N/A
2"			N/A
3-1/2"			N/A

STANDARD KEYING, PLUS EXTRA PINS OR KEYS FOR SHAPES AT 45° INCREMENTS					
STATION	PUNCH		DIE		GUIDE OR STRIPPER
	AVAILABLE OPTIONS	ADD ON PRICE	AVAILABLE OPTIONS	ADD ON PRICE	
1-1/4"	0° & 45°		0° & 45°		Closed round guide or 2 fitted guides required
1-1/4"	0° & 180°		0° & 180°		
2"	45° increments		45° increments		N/A
3-1/2"	45° increments		45° increments		N/A

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

% x Material Thickness = Total Clearance

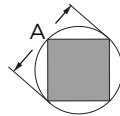
NON-STANDARD FEATURES ADD ON CHARGES

1-1/4" STATION			
ADD ON FOR ROUNDS			
Small Diameter	Punch	Die	Stripper
.031" - .061" [0.79mm - 1.56mm]			N/C
.062" - .092" [1.57mm - 2.34mm]		N/C	N/C
.093" - .249" [2.35mm - 6.32mm]		N/C	N/C
Clearance < .004" [0.10mm]			N/C
ADD ON FOR SHAPES			
Small Width	Punch	Die	Stripper
.031" - .039" [0.79mm - 1.0mm]			
.040" - .092" [1.01mm - 2.34mm]		N/C	
A Dimension < .437" [11.10mm]		N/C	N/C
Clearance < .004" [0.10mm]			N/C

2" STATION			
ADD ON FOR ROUNDS			
Small Diameter	Punch	Die	Stripper
<1.000" [25.4mm]		N/C	N/C
Clearance < .004" [0.10mm]			N/C
ADD ON FOR SHAPES			
Small Width	Punch	Die	Stripper
.031 - .039" [0.79mm - 1.0mm]			
.040 - .092" [1.01mm - 2.34mm]			
'A' Dim < 1.150" [29.21mm]		N/C	N/C
1.150 - 1.249" [29.21 - 31.72mm]		N/C	N/C
Clearance < .004" [0.10mm]			N/C

3-1/2" STATION			
ADD ON FOR ROUNDS			
Small Diameter	Punch	Die	Stripper
<1.000" [25.4mm]		N/C	N/C
Clearance < .004" [0.10mm]			N/C
ADD ON FOR SHAPES			
Small Width	Punch	Die	Stripper
.031" - .039" [0.79mm - 1.0mm]			
.040" - .092" [1.01mm - 2.34mm]			
'A' Dim < 1.150" [29.21mm]		N/C	N/C
Clearance < .004" [0.10mm]			N/C

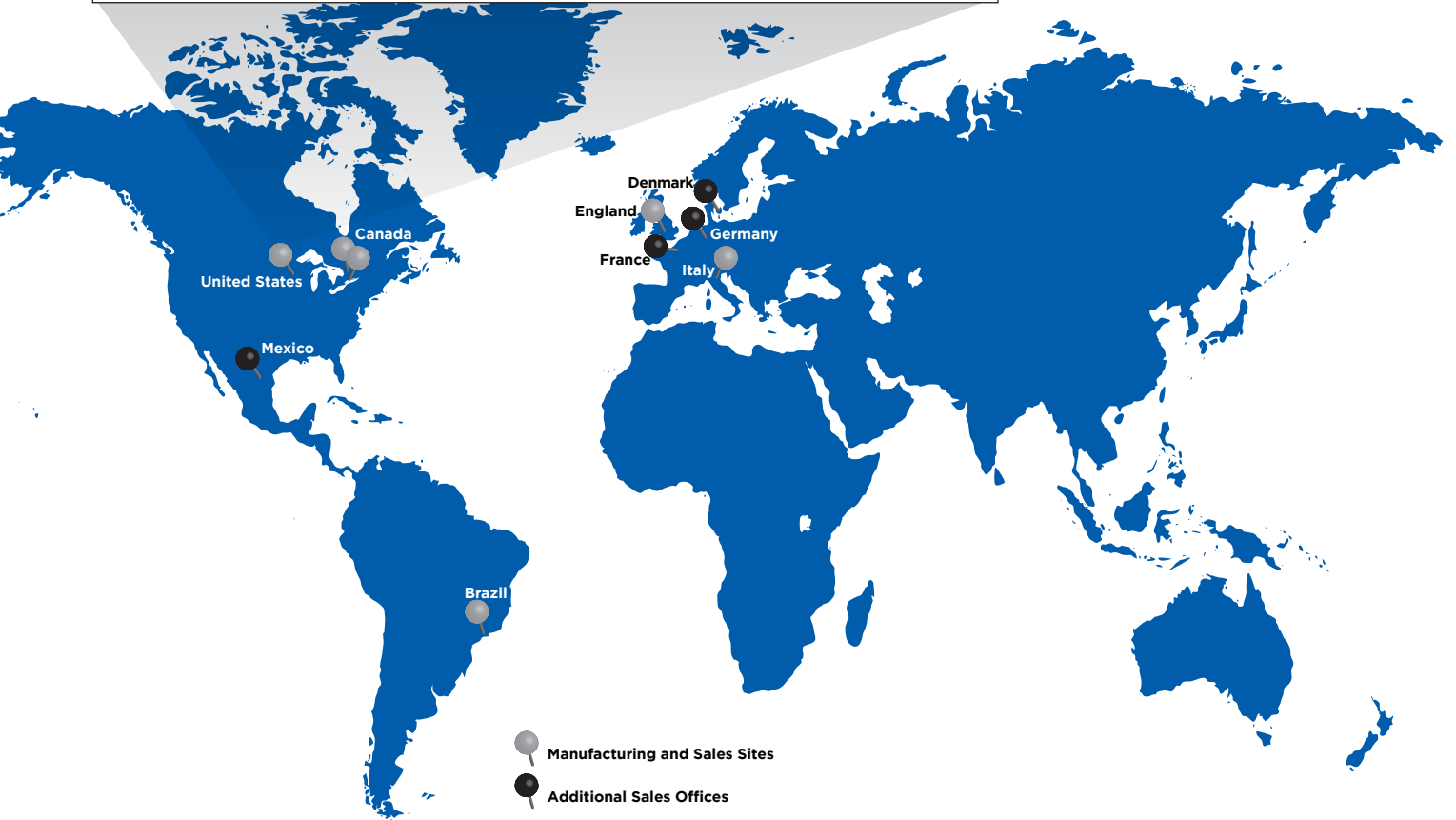
RADIUS OR 45° CHAMFER 4 CORNERS		
RADIUS OR CHAMFER SIZE		Price
Punch	.001" - .062" [0.02mm - 1.57mm]	
	.063" - .250" [1.58mm - 6.35mm]	
	> .250" [6.35mm]	
Die	Any Size	

MAXIMUM A DIMENSION	NOTES
	Additional charge to round or shape punch for: <ul style="list-style-type: none"> • Extra straight before radius • Extra back taper

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