



WIEDEMANN

PUNCH TOOLING SOLUTIONS

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WIEDEMANN 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, 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.



HP GUIDE ASSEMBLIES

HP GUIDE ASSEMBLIES



Wilson Tool's HP Guide Assemblies fit the following machines:

- Centrum 3000, 3500
- Magnum 2125, 5000
- Vectrums
- Motorums
- Wiedematic 3050, 4560

Features and Benefits:

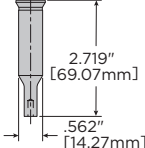
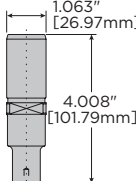
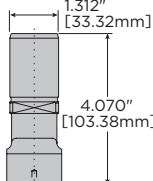
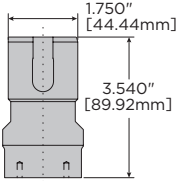
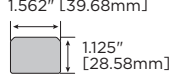
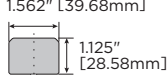
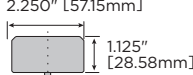
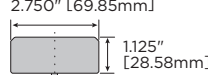
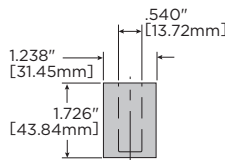
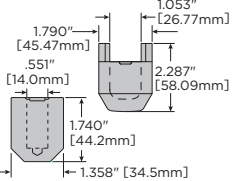
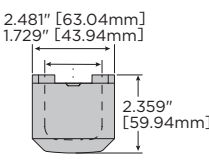
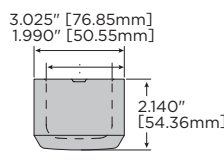
- Accepts standard 114 and 112 Style Wiedemann tooling.
- Push button length adjustment in .005" increments. (XB Assembly does not have the above feature).
- Punches are self-stripping and guided.
- Uses a steel stripper retention system (no tools required).

DESCRIPTION	CAT. NO.	PRICE
FOR 114 STYLE TOOLING		
XB HP Guide Assembly* <i>(requires thread adapter 22535)</i>	22500	
B HP Guide Assembly* <i>(requires thread adapter 22535)</i>	22513	
*Thread Adapter 5/16-18 to 1/2-13	22535	
C HP Guide Assembly	22592	
D HP Guide Assembly** <i>(converts to Auto-Index with 22596)</i>	22616	
**D-AI Lifter Button Assembly (set of 4)	22596	
D-AI HP Guide Assembly (3.375" O.D.)	22618	
E, F HP Guide Assembly (4.562" O.D.)	22537	
F-AI HP Guide Assembly (4.172" O.D.)	22562	
G, H, J HP Guide Assembly (5.937" O.D.)	22595	
FOR 112 STYLE TOOLING		
XB HP Guide Assembly	22517	
B HP Guide Assembly	22514	
C HP Guide Assembly	22591	
D HP Guide Assembly** <i>(converts to Auto-Index with 22596)</i>	22613	
**D-AI Lifter Button Assembly (set of 4)	22596	
D-AI HP Guide Assembly (3.375" O.D.)	22617	
E, F HP Guide Assembly (4.562" O.D.)	22536	
F-AI HP Guide Assembly (4.172" O.D.)	22563	

DESCRIPTION	CAT. NO.	PRICE
ACCESSORIES		
1/4" T-Handle Hex Wrench Used on: • 114 XB thru G, H, J Assembly • 112 XB thru E, F Assembly	23533	



114 STYLE TOOLING

	A STATION Up to .500" [12.7mm]		B STATION Up to 1.000" [25.4mm]		C STATION 1.001 - 1.500" [25.4 - 38.1mm]		D STATION 1.501 - 2.000" [38.1 - 50.8mm]	
								
PUNCH	Cat No.	Price	Cat No.	Price	Cat No.	Price	Cat No.	Price
Round	20113		20115		20117		20119	
Shape	—	—	20116		20118		20120	
Keyed Round Punch	—	—	20165		—	—	—	—
Shape Punch 0° & 45°	—	—	20166		20168		—	—
Optima*	—	—	—	—	—	—	—	—
								
DIE	Cat No.	Price	Cat No.	Price	Cat No.	Price	Cat No.	Price
Round Slug Hugger* 2*	20037		20037		20043		20049	
Round Standard	20036		20036		20042		20048	
Shape Slug Hugger* 2*	—	—	20040		20046		20052	
Shape Positive	—	—	20039		20045		20051	
Shape Positive at 0° & 45°	—	—	20291		—	—	—	—
Shape Slug Hugger* 2* at 0° & 45°	—	—	20292		—	—	—	—
								
STRIPPER	Cat No.	Price	Cat No.	Price	Cat No.	Price	Cat No.	Price
HP Round	—	—	22530		22607		22638	
HP Round for XB	—	—	22509		—	—	—	—
HP Shape	—	—	22531		22608		22639	
XB	—	—	20400		—	—	—	—
Standard	20401		20403		20405		20406	
(Magnum Machine)	20402		—	—	—	—	—	—
1" [2.54mm] SQ	—	—	—	—	—	—	20407	
≤ 1/8" [3.2mm] RT	—	—	20404		—	—	20408	
PUNCH SHIM THICKNESS	Cat No.	Qty.	Cat No.	Qty.	Cat No.	Qty.	Cat No.	Qty.
.060" [1.50mm]	20236	25	20236	25	20238	25	20240	5
DIE SHIM THICKNESS	Cat No.	Qty.	Cat No.	Qty.	Cat No.	Qty.	Cat No.	Price
.030" [0.75mm]	20202	25	20202	25	20204	25	20206	5

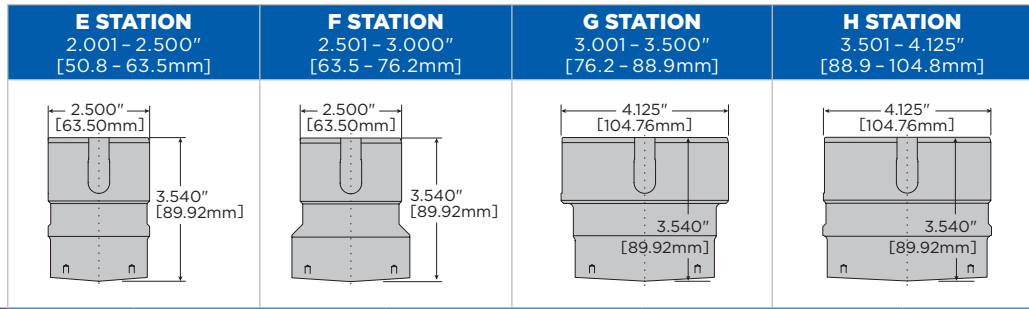
Slug Hugger 2 dies must be ordered punch size plus clearance, .098" [2.49mm] minimum diameter on rounds, .060" [1.53mm] minimum width on shapes, .006" [0.15mm] minimum clearance.

For 114 Style Tooling add ons, and other urethane stripper options, see page 10.

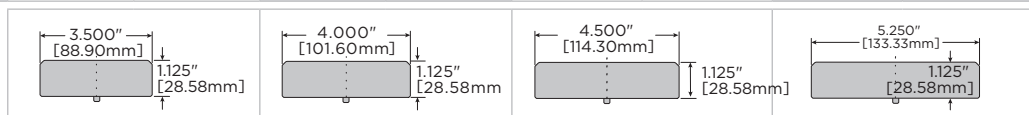
114 STYLE

114 STYLE TOOLING

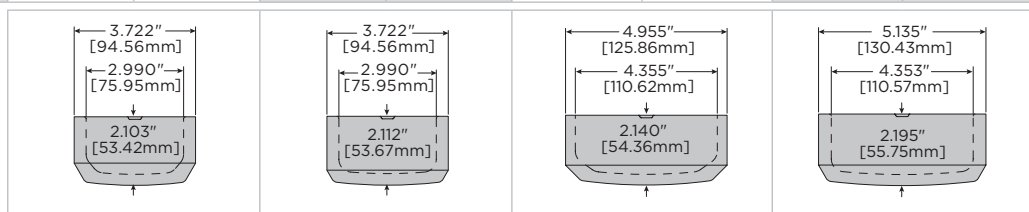
114 STYLE



PUNCH	Cat No.	Price	Cat No.	Price	Cat No.	Price	Cat No.	Price
Round	20121		20123		20125		20127	
Shape	20122		20124		20126		20128	
Optima*	—		—		—		—	



DIE	Cat No.	Price	Cat No.	Price	Cat No.	Price	Cat No.	Price
Round Slug Hugger* 2*	20055		20061		20067		20073	
Round Standard	20054		20060		20066		20072	
Shape Slug Hugger* 2*	20058		20064		20070		20076	
Shape Positive	20057		20063		20069		20075	



STRIPPER	Cat No.	Price	Cat No.	Price	Cat No.	Price	Cat No.	Price
HP Round	22557		22557		22587		22587	
HP Shape	22558		22558		22588		22588	
Standard	20410		20412		20415		20418	
≤ 1/2" [12.7mm] RT	20411		20414		20417		20419	
2" [50.8mm] SQ	—	—	20413		20416		—	—

PUNCH SHIMS	Cat No.	Price	Cat No.	Price	Cat No.	Price	Cat No.	Price
Punch Shims (5 qty.)	20242		20242		20244		20244	
Thickness	.060" [1.50mm]		.060" [1.50mm]		.060" [1.50mm]		.060" [1.50mm]	
O.D.	2.469" [62.70mm]		2.469" [62.70mm]		4.091" [103.91mm]		4.091" [103.91mm]	

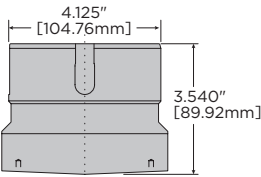
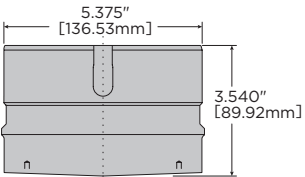
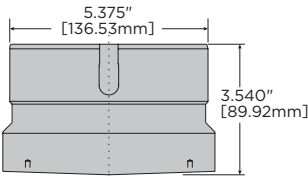
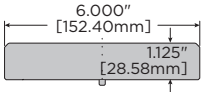
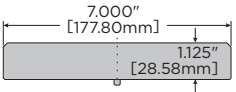
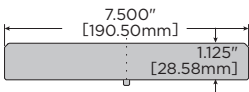
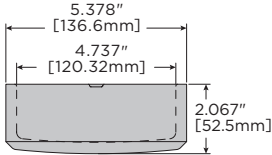
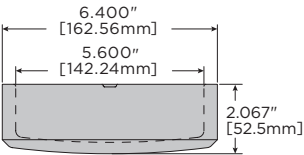
DIE SHIMS	Cat No.	Price	Cat No.	Price	Cat No.	Price	Cat No.	Price
Die Shims (5 qty.)	20208		20214		20216		20218	
Thickness	.030" [0.75mm]		.030" [0.75mm]		.030" [0.75mm]		.030" [0.75mm]	
O.D.	3.480" [88.40mm]		3.980" [101.10mm]		4.480" [113.80mm]		5.228" [132.80mm]	

Slug Hugger 2 dies must be ordered punch size plus clearance, .098" [2.49mm] minimum diameter on rounds, .060" [1.53mm] minimum width on shapes, .006" [0.15mm] minimum clearance.

For 114 Style Tooling add ons, and other urethane stripper options, see page 10.



114 STYLE TOOLING

	J STATION 4.126 – 4.750" [104.8 – 120.65mm]		K STATION 4.751 – 5.500" [120.65 – 139.7mm]		L STATION 5.501 – 6.000" [139.7 – 152.4mm]	
						
PUNCH	Cat No.	Price	Cat No.	Price	Cat No.	Price
Round	20129		20131		20133	
Shape	20130		20132		20134	
Optima*	—		—		—	
						
DIE	Cat No.	Price	Cat No.	Price	Cat No.	Price
Round Slug Hugger* 2*	20079		20085		20091	
Round Standard	20078		20084		20090	
Shape Slug Hugger* 2*	20082		20088		20094	
Shape Positive	20081		20087		20093	
						
STRIPPER	Cat No.	Price	Cat No.	Price	Cat No.	Price
HP Round	22587		—		—	
HP Shape	22588		—		—	
Standard	20420		20422		—	
≤ 1/2" [12.7mm] RT (Magnum Machine)	20421		20424		—	
	—		20423		—	
PUNCH SHIMS	Cat No.	Price	Cat No.	Price	Cat No.	Price
Punch Shims (5 qty.)	20244		20246		20246	
Thickness	.060" [1.50mm]		.060" [1.50mm]		.060" [1.50mm]	
O.D.	4.091" [103.91mm]		5.339" [135.60mm]		5.339" [135.60mm]	
DIE SHIMS	Cat No.	Price	Cat No.	Price	Cat No.	Price
Die Shims (5 qty.)	20220		20222		20224	
Thickness	.031" [0.79mm]		.031" [0.79mm]		.030" [0.75mm]	
O.D.	5.980" [151.90mm]		5.980" [151.90mm]		7.48" [190mm]	

Slug Hugger 2 dies must be ordered punch size plus clearance, .098" [2.49mm] minimum diameter on rounds, .060" [1.53mm] minimum width on shapes, .006" [0.15mm] minimum clearance.

For 114 Style Tooling add ons, and other urethane stripper options, see page 10.

114 STYLE

114 STYLE TOOLING ADD ONS

114 STYLE ADD ONS

A, B, C STATION ADD ONS

ADD ONS FOR ROUNDS

Small Diameter	Punch	Die
.031-.061" [0.79-1.55mm]		
.062-.092" [1.57-2.34mm]		N/C
Clearance < .004" [0.10mm]		

ADD ONS FOR SHAPES

Small Widths	Punch	Die
.031-.039" [0.79-1.0mm]		
.040-.092" [1.02-2.34mm]		N/C
Small A Dimension	Punch	Die
C < .750" [19.05mm]		N/C
Clearance < .004" [0.10mm]		

E, F, G STATION ADD ONS

ADD ONS FOR ROUNDS

Small Diameter	Punch	Die
E, F < 1.900" [48.26mm]		N/C
G < 3.024" [76.81mm]		N/C
Clearance < .004" [0.10mm]		

ADD ONS FOR SHAPES

Small Widths	Punch	Die
.031-.039" [0.79-1.0mm]		
.040-.092" [1.02-2.34mm]		
Small A Dimension	Punch	Die
E, F < 1.750" [44.45mm]		N/C
G < 2.750" [69.85mm]		N/C
Clearance < .004" [0.10mm]		

K, L STATION ADD ONS

ADD ONS FOR ROUNDS

Small Diameter	Punch	Die
< 4.650" [120.65mm]		N/C
Clearance < .004" [0.10mm]		

ADD ONS FOR SHAPES

Small Widths	Punch	Die
< 4.500" [114.3mm]		
.040-.092" [1.02-2.34mm]		
Small A Dimension	Punch	Die
< 4.500" [114.3mm]		N/C
Clearance < .004" [0.10mm]		

D STATION ADD ONS

ADD ONS FOR ROUNDS

Small Diameter	Punch	Die
< 1.250" [31.75mm]		N/C
Clearance < .004" [0.10mm]		

ADD ONS FOR SHAPES

Small Widths	PUNCH	DIE
.031-.039" [0.79-1.0mm]		
.040-.092" [1.02-2.34mm]		
Small A Dimension	Punch	Die
< 1.150" [29.21mm]		N/C
1.150" - 1.500" [29.21mm - 38.1mm]		N/C
Clearance < .004" [0.10mm]		

H, J STATION ADD ONS

ADD ONS FOR ROUNDS

Small Diameter	Punch	Die
< 3.400" [88.9mm]		N/C
Clearance < .004" [0.10mm]		

ADD ONS FOR SHAPES

Small Widths	Punch	Die
.031-.039" [0.79-1.0mm]		
.040-.092" [1.02-2.34mm]		
Small A Dimension	Punch	Die
< 3.250" [82.55mm]		N/C
Clearance < .004" [0.10mm]		

RADIUS OR 45° CHAMFER 4 CORNERS

PUNCH

Radius or Chamfer Size	Price
.001-.062" [0.02-1.57mm]	
.063-.249" [1.60-6.32mm]	
Greater than .250" [6.35mm]	

DIE

Any size	
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URETHANE STRIPPER OPTIONS

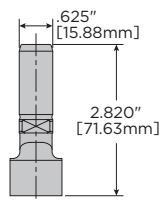
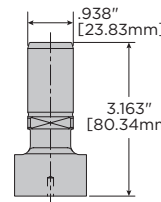
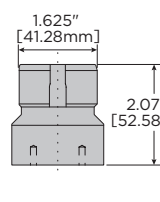
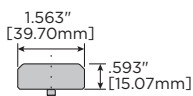
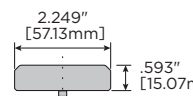
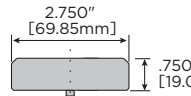
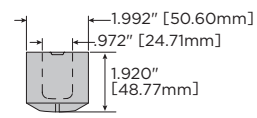
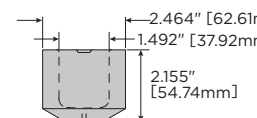
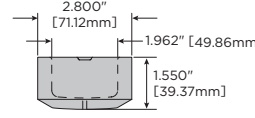
95 dA (Natural/Amber)*	Heavy Duty
90 dA (Black)	Standard
80 dA (Green)*	Light Duty
70 dA (Yellow)*	Very Light Duty
Custom Molded*	

*Contact our Tooling Technicians for price and delivery.

NOTES	
Additional cost to round or shape punch for extra straight before radius, extra back taper or no back taper.	A Dimension = longest distance across shape



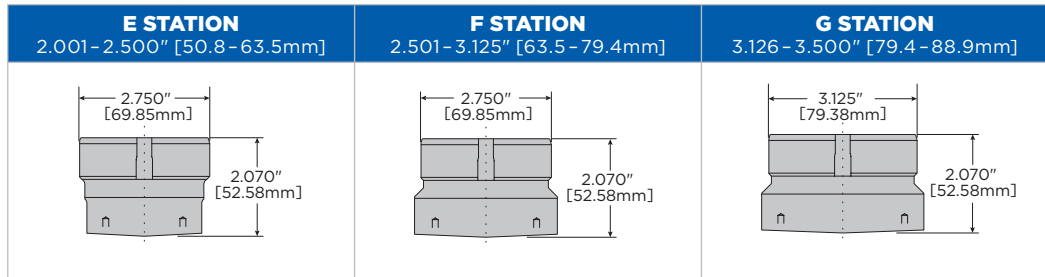
112 STYLE TOOLING

	B STATION Up to 1.000" [25.4mm]		C STATION 1.001-1.500" [25.4 - 38.1mm]		D STATION 1.501-2.000" [38.1 - 50.8mm]	
						
PUNCH	Cat No.	Price	Cat No.	Price	Cat No.	Price
Round	20101		20103		20105	
Shape	20102		20104		20106	
Shape Punch 0° & 45°	20152		20154		—	—
Optima*	—		—		—	
						
DIE	Cat No.	Price	Cat No.	Price	Cat No.	Price
Round Slug Hugger* 2*	20001		20007		20013	
Round Standard	20000		20006		20012	
Shape Slug Hugger* 2*	20004		20010		20016	
Shape Positive	20003		20009		20015	
Shape Positive at 0° & 45°	20282		—	—	—	—
Shape Slug Hugger* 2* at 0° & 45°	20283		—	—	—	—
						
STRIPPER	Cat No.	Price	Cat No.	Price	Cat No.	Price
HP Round	22530		22607		22638	
HP Round for XB	22509		—	—	—	—
HP Shape	22531		22608		22639	
Standard	20303		20305		20306	
≤ 1/8" [3.2mm] RT	20304		—	—	20308	
≤ 1/2" [12.7mm] RT	—	—	—	—	20309	
1" [2.54mm] SQ	—	—	—	—	20307	
PUNCH SHIMS	Cat No.	Qty.	Cat No.	Qty.	Cat No.	Qty.
Punch Shims	20226	25	20228	25	20230	5
Thickness	.030" [0.75mm]		.030" [0.75mm]		.060" [1.50mm]	
O.D.	1.535" [39.00mm]		2.228" [56.6mm]		1.590" [40.39mm]	
DIE SHIMS	Cat No.	Qty.	Cat No.	Qty.	Cat No.	Qty.
Die Shims	20202	25	20204	25	20206	5
Thickness	.030" [0.75mm]		.030" [0.75mm]		.030" [0.75mm]	
O.D.	1.535" [39.00mm]		2.228" [56.6mm]		2.228" [56.6mm]	

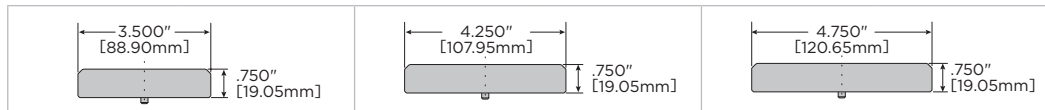
Slug Hugger 2 dies must be ordered punch size plus clearance, .098" [2.49mm] minimum diameter on rounds, .060" [1.53mm] minimum width on shapes, .006" [0.15mm] minimum clearance.

For 112 Style Tooling add ons, and other urethane stripper options, see page 13.

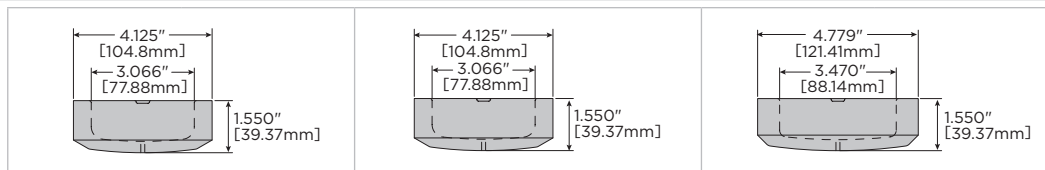
112 STYLE TOOLING



PUNCH	Cat No.	Price	Cat No.	Price	Cat No.	Price
Round	20107		20109		20111	
Shape	20108		20110		20112	
Optima*	—		—		—	



DIE	Cat No.	Price	Cat No.	Price	Cat No.	Price
Round Slug Hugger* 2*	20019		20025		20031	
Round Standard	20018		20024		20030	
Shape Slug Hugger* 2*	20022		20028		20034	
Shape Positive	20021		20027		20033	



STRIPPER	Cat No.	Price	Cat No.	Price	Cat No.	Price
HP Round	22557		22557		22587	
HP Shape	22558		22558		22588	
Standard	20310		20312		20315	
≤ 1/2" [12.7mm] RT	20311		20314		20317	
2" [50.8mm] SQ	—	—	20313		—	—

PUNCH SHIMS	Cat No.	Price	Cat No.	Price	Cat No.	Price
Punch Shims (5 qty.)	20232		20232		20234	
Thickness	.060" [1.50mm]		.060" [1.50mm]		.060" [1.50mm]	
O.D.	2.72" [69mm]		2.72" [69mm]		3.091" [78.5mm]	

DIE SHIMS	Cat No.	Price	Cat No.	Price	Cat No.	Price
Die Shims (5 qty.)	20208		20210		20212	
Thickness	.030" [0.75mm]		.030" [0.75mm]		.030" [0.75mm]	
O.D.	3.480" [88.40mm]		4.228" [107.40mm]		4.728" [120.1mm]	

Slug Hugger 2 dies must be ordered punch size plus clearance, .098" [2.49mm] minimum diameter on rounds, .060" [1.53mm] minimum width on shapes, .006" [0.15mm] minimum clearance.

For 112 Style Tooling add ons, and other urethane stripper options, see page 13.

112 STYLE TOOLING ADD ONS

A, B, C STATION ADD ONS		
ADD ONS FOR ROUNDS		
Small Diameter	Punch	Die
.031-.061" [0.79-1.55mm]		
.062-.092" [1.57-2.34mm]		N/C
Clearance < .004" [0.10mm]		
ADD ONS FOR SHAPES		
Small Widths	Punch	Die
.031-.039" [0.79-1.0mm]		
.040-.092" [1.02-2.34mm]		N/C
Small A Dimension [†]	Punch	Die
A < .750" [19.05mm]		N/C
Clearance < .004" [0.10mm]		

[†]A Dimension = longest distance across shape

D STATION ADD ONS		
ADD ONS FOR ROUNDS		
Small Diameter	Punch	Die
< 1.250" [31.75mm]		N/C
Clearance < .004" [0.10mm]		
ADD ONS FOR SHAPES		
Small Widths	Punch	Die
.031-.039" [0.79-1.0mm]		
.040-.092" [1.02-2.34mm]		
Small A Dimension [†]	Punch	Die
< 1.150" [29.21mm]		N/C
1.150-.1.500" [29.21-38.1mm]		N/C
Clearance < .004" [0.10mm]		

[†]A Dimension = longest distance across shape

E, F, G STATION ADD ONS		
ADD ONS FOR ROUNDS		
Small Diameter	Punch	Die
E, F < 1.900" [48.26mm]		N/C
G < 3.024" [76.81mm]		N/C
Clearance < .004" [0.10mm]		
ADD ONS FOR SHAPES		
Small Widths	Punch	Die
.031-.039" [0.79-1.0mm]		
.040-.092" [1.02-2.34mm]		
Small A Dimension [†]	Punch	Die
E, F < 1.750" [44.45mm]		N/C
G < 2.750" [69.85mm]		N/C
Clearance < .004" [0.10mm]		

[†]A Dimension = longest distance across shape

RADIUS OR 45° CHAMFER 4 CORNERS	
PUNCH	
Radius or Chamfer Size	Price
.063-.250" [1.58-6.35mm]	
Greater than .250" [6.35mm]	
DIE	
Any size	

URETHANE STRIPPER OPTIONS	
95 dA (Natural / Amber)*	Heavy Duty
90 dA (Black)	Standard
80 dA (Green)*	Light Duty
70 dA (Yellow)*	Very Light Duty
Custom Molded*	

*Contact our Tooling Technicians for price and delivery.

NOTE
Additional cost to round or shape punch for extra straight before radius, extra back taper or no back taper.

112 STYLE ADD ONS

FAST, FLEXIBLE AND ACCURATE HIGH PERFORMANCE SPECIAL TOOLING

HP Special Tooling from Wilson Tool International features unique High Performance holder technology that allows fast, “click-and-turn” in-machine adjustment.

ADDITIONAL FEATURES

- Positive, push-button adjustment in .002" [0.05mm] increments for improved accuracy without the use of shims, without tools and without removal from the machine
- Larger maximum A Dimension than other forming punches which allows larger-sized forming tools to be used in the XB-L stations of Murata Wiedemann punch presses for faster, easier and more efficient punching
- The shortest lead-times and fastest deliveries in the industry
- An extensive selection of Special Forming Tools including:
 - Embosses
 - Extrusions
 - Half Shears
 - EKO's
 - Coining Tools
 - Lance and Forms
 - Progressive Ribs
 - Louvers
 - Bridges
 - Letter Stamps
 - Hinges
 - Thread Forms
 - Card Guides



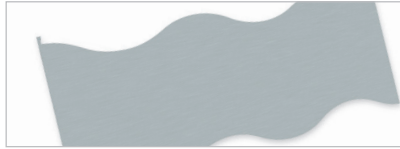
**For a special forming tool that is not on this list,
contact our Tooling Technicians.**

Scan for Punching
Specials Templates



WILSON WHEEL® 114 STYLE TOOLING

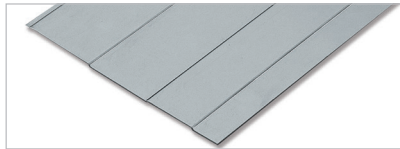
FOR F (I/T) STATION ONLY



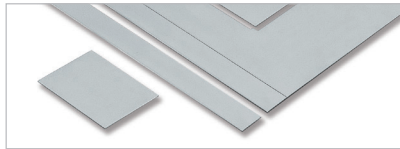
Rolling Shear



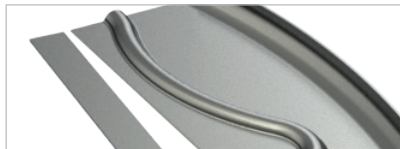
Rolling Rib



Rolling Offset



Rolling Pincher



Rolling Flare



Wheel tools shown with punch and die adapter set



PUNCH & DIE ADAPTER SET	
CAT. NO	PRICE
21064	

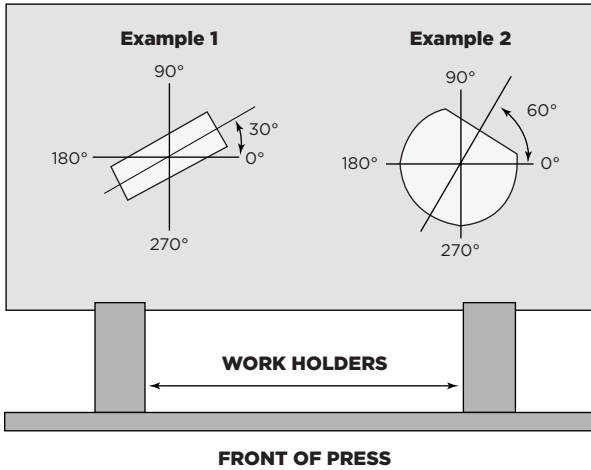
*Wheel tools not included

FEATURES	DESIGN CRITERIA	INFORMATION NEEDED
The Wilson Wheel® family of products offers fabricators flexible, high-speed production of flares, slits, ribs and offsets on a wide range of materials with virtually no burrs or nibble marks.	<ul style="list-style-type: none"> A programmable ram is required to use these wheel tools. Consult our Tooling Technicians for machine specific requirements. Consult our Tooling Technicians for minimum radius of each tool. 	<ul style="list-style-type: none"> Machine Model Material thickness and type

114 STYLE WILSON WHEEL®

NON-STANDARD KEYING

EXAMPLES OF ANGLE SETTINGS

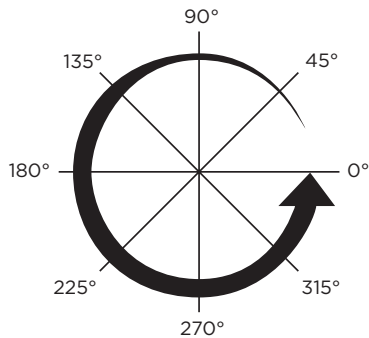


NOTE

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

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

WILSON TOOL KEYING DIAGRAM



SHAPE AT SINGLE ANGLE ONLY AT 15° INCREMENTS

FOR T12 AND T14

Station	Punch	Die
B, C		
D		
E, F		
G, H, J		
K, L		

SHAPE AT SINGLE ANGLE ONLY AT OTHER THAN 15° INCREMENTS

FOR T12 AND T14

Station	Punch	Die
B, C		
D		
E, F		
G, H, J		
K, L		

STANDARD KEYING, PLUS EXTRA KEYS FOR SHAPES AT 45° INCREMENTS

FOR T12 AND T14

Station	Available Options	Punch	Die
		Add On Price	Add On Price
B, C	45° Only		
D	45° Increments		
E, F	45° Increments		
G, H, J	45° Increments		
K, L	45° Increments		

STANDARD KEYING, PLUS EXTRA PINS OR KEYS FOR SHAPES AT OTHER THAN 45° INCREMENTS

FOR T12 AND T14

Station	Punch	Die
B, C	—	—
D	—	—
E, F		
G, H, J		
K, L		

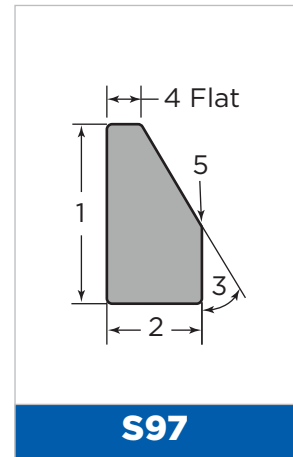
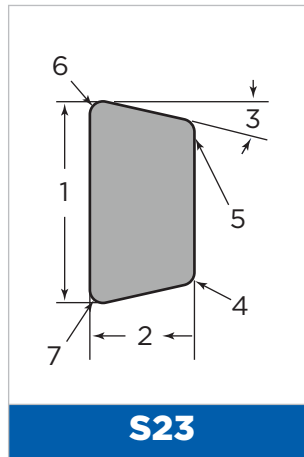
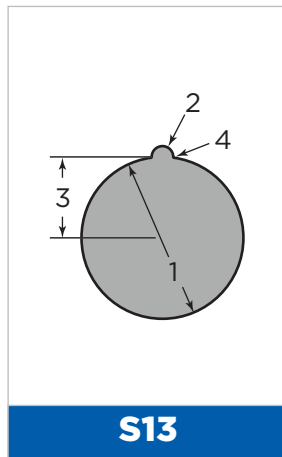
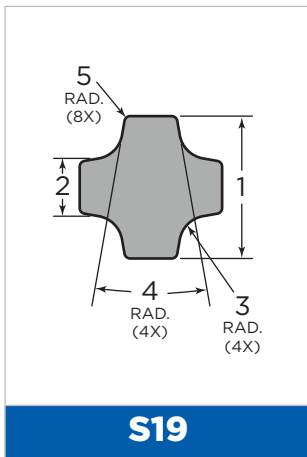
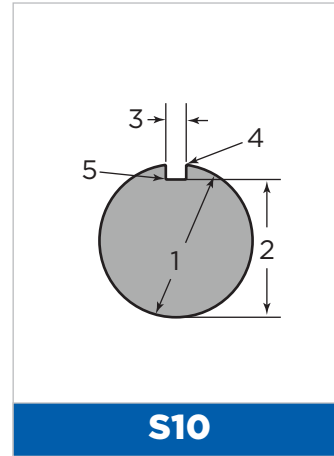
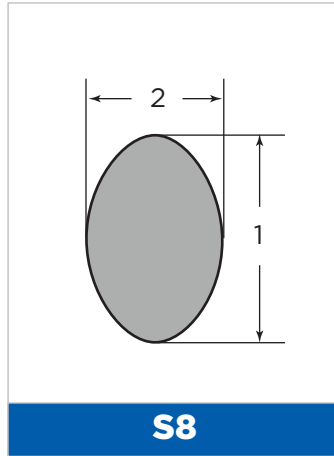
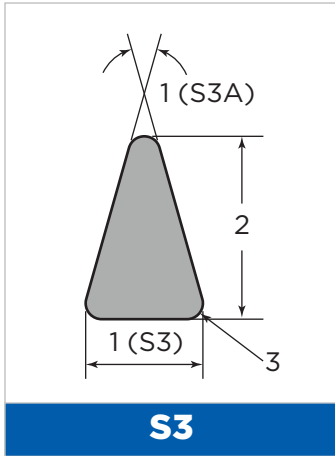


STANDARD KEYING LOCATIONS

B & C STATIONS	PUNCH VIEW	
	DIE VIEW	
D - L STATIONS	PUNCH VIEW	
	DIE VIEW	

STANDARD KEYING LOCATIONS

SPECIAL SHAPES

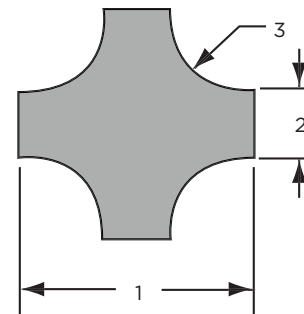


NOTE: Additional shapes available. Special considerations may alter price and lead time.

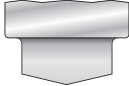
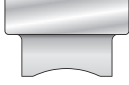
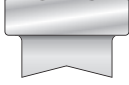
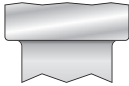

SPECIALS / 4-WAY RADIUS TOOLS

4-WAY RADIUS TOOLS

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 [1.75] Ø	.250 [6.35]	.500 [12.7]



SHEAR OPTIONS

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

†A Dimension = Longest dimension across shape.

SPECIAL SHEARS

STATION	A DIMENSION	INVERTED ROOFTOP or SINGLE CONCAVE		DOUBLE VALLEY or DOUBLE CONCAVE	
		112 .062" [1.6mm] Shear	114 .093" [2.4mm] Shear	112 .062" [1.6mm] Shear	114 .093" [2.4mm] Shear
B, C	within 1.500" [38.10mm]				—
D, E, F	within 3.125" [79.38mm]				
G, H, J	within 4.750" [120.65mm]				
K, L	within 6.000" [152.40mm]	—	—	—	—

.062" [1.6mm] (112 Style) and .093" [2.4mm] (114 Style) 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.

Note: In some instances, inverted rooftop is substituted for single and double concave shears.

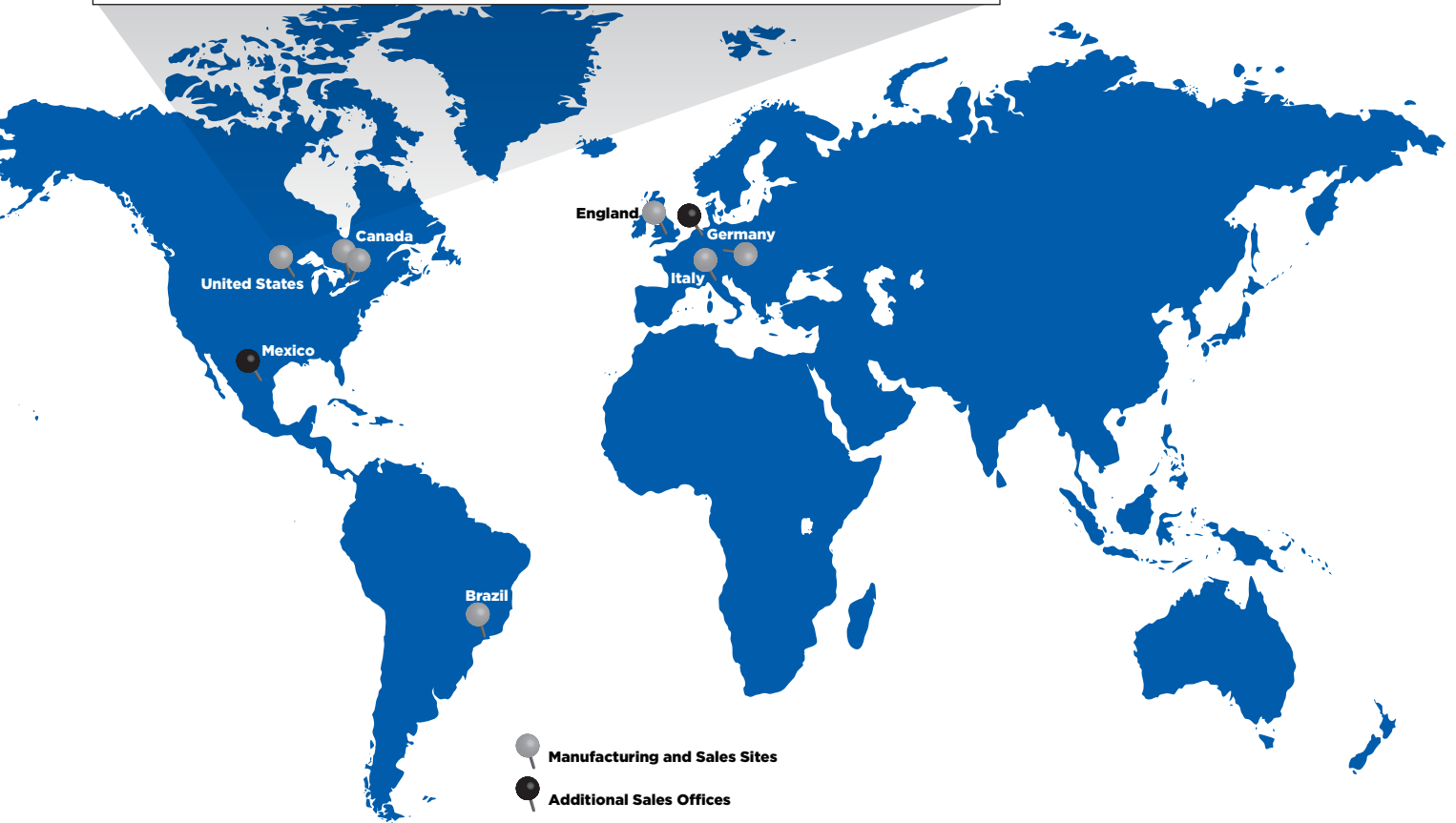
JK SHEAR

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

WILSON TOOL INTERNATIONAL HEADQUARTERS

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

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



GUARANTEED TO OUTPERFORM

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



P234C (10.2025)