

# SALVAGNINI

PUNCH TOOLING SOLUTIONS

# TOOLING OVERVIEW

HEAD POSITION	TOOL TYPE	STATION SIZE	RANGE	NOTES
1-20 and 41-76 (7 Tons)	WPA	33mm	.031"-.236" [.79mm-6mm]	Round Only
	WPO		.031"-.394" [.79mm-10mm]	Fully Guided
	WPB		.237"-.413" [6mm-10.5mm]	Round Only
	WP9		Up to 1.023" [26mm]	Fully Guided
	WS4		Up to 1.300" [33mm]	—
30-35 (12 Tons)	WP5	60mm	Up to 1.669" [42.4mm]	Rotational
	WS6		Up to 2.362" [60mm]	Rotational
21-24 (26 Tons)	WS8	70mm x 90mm	2.755" x 3.543" [70mm x 90mm]	Type 70
	WS9			Type 90
	WSA	90mm x 90mm	3.543" x 3.543" [90 x 90mm]	Type 90

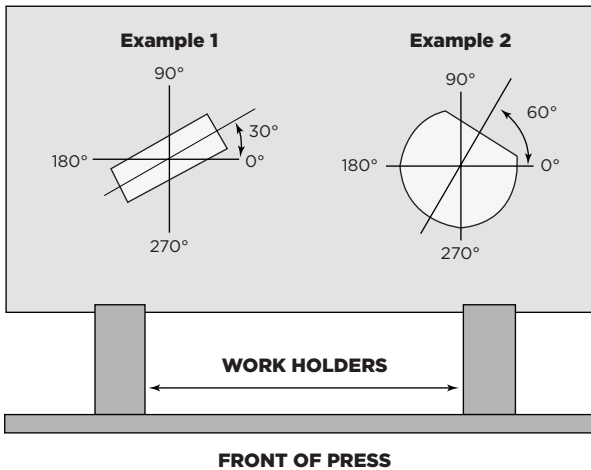
Wilson Tool types are compatible with Salvagnini S4, S6, S8, S9, SA, P0, P9, P5 and Mate tool types PA and PB.

## TOOLING ORIENTATION

Refer to non-standard key locations as follows:

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

### EXAMPLES OF ANGLE SETTINGS



STANDARD SHAPE DIE VIEW			
0°	90°	180°	270°



# SALVAGNINI TOOLING SOLUTIONS

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



#### TERMS AND CONDITIONS

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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.



## EXP® PUNCH TIP TECHNOLOGY

EXP® punch tip technology from Wilson Tool International provides manufacturers with a universal tool that is more affordable and durable than standard punches.

Manufacturers who run EXP® tooling benefit from decreased tool set-up time, less time resharpener, less storage space required, plus the advantages of Ultima® premium tool steel — increased tool life and more hits between sharpening.



### Longer-Lasting Punches

Every EXP punch is manufactured with Wilson Tool's exclusive Ultima® tool steel to significantly increase wear resistance over conventional tool steels. As a result, EXP punches have twice the tool life as most standard punches. With up to twice as long between regrinds, EXP punches made with Ultima tool steel substantially reduce downtime and tool replacement costs. Breaking, chipping, cracking, tool fatigue and other downtime problems are minimized, providing long-term gains in productivity and profitability.

### Faster Tool Changes

Loading EXP is as easy as inserting the punch tip into the punch holder, then turning the key to lock it in place. Switching from one punch to the next can be done in seconds, significantly reducing downtime.

### Storage Savings

A fraction of the size of standard punches, EXP punches give you the flexibility to stock more shapes, using less space for storage.

### Universal Design

EXP punches offer greater flexibility because they fit into multiple styles of tooling, allowing you to enjoy the ease, speed and durability of EXP for all your punch tooling needs.

### Lowest Cost of Ownership in the Long Term

When you consider the lower punch price combined with faster setup, increased life between sharpening, and greater versatility, EXP clearly offers the lowest cost of ownership of any punch on the market today.

Scan QR Code  
to Explore  
More EXP®



# 33mm EXP® HOLDER, PUNCH, STRIPPER, DIE

## 33mm EXP®

- Punches can be resharpened .157" [4mm]
- Dies can be resharpened .060" [1.5mm]

DESCRIPTION	PART NO.	PRICE
<b>Punch Holder</b>	17712	
<b>Punch - Round</b>	17916	
<b>Punch - Shape</b>	17917	
<b>Optima® Coating</b>	—	
<b>Stripper - Round</b> <i>up to 1.378" [35mm] diameter</i>	17502	
<b>Stripper - Shape</b>	17503	
<b>Die - Round</b>	17504	
<b>Die - Round Slug Hugger**</b>	17604	
<b>Die - Shape</b>	17505	
<b>Die - Shape Slug Hugger**</b>	17605	
<b>Die Shim Pack</b>	17602	

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



		H3 HEAD						
		30	31	32	33	34	35	
<b>24</b> 90 x 90		76	68	60	56	52	48	44
		75	67	59	55	51	47	43
<b>23</b> 70 x 90		74	66	58	54	50	46	42
		73	65	57	53	49	45	41
<b>22</b> 70 x 90		72	64	20	16	12	8	4
		71	63	19	15	11	7	3
<b>21</b> 90 x 90		70	62	18	14	10	6	2
		69	61	17	13	9	5	1

# PUNCH, STRIPPER AND DIE COMPONENTS

## WPA

.031 - .236" [.79 - 6mm]

- Punches can be resharpened .157" [4mm]
- Dies can be resharpened .060" [1.5mm]

DESCRIPTION	PART NO.	PRICE
<b>Punch Holder w/Locking Screw</b>	17610	
<b>Punch Locking Screw</b>	25212	
<b>Punch - Round</b>	17611	
<b>Optima® Coating</b>	—	
<b>Stripper - Round†</b>	17502	
<b>Die - Round</b>	17504	
<b>Die - Round Slug Hugger® 2</b>	17604	
<b>Die Shim Pack*</b>	17602	

## WPB

.237 - .413" [6 - 10.5mm]

- Punches can be resharpened .157" [4mm]
- Dies can be resharpened .060" [1.5mm]

DESCRIPTION	PART NO.	PRICE
<b>Punch Holder w/Locking Screw</b>	17612	
<b>Punch Locking Screw</b>	25212	
<b>Punch - Round</b>	17613	
<b>Optima® Coating</b>	—	
<b>Stripper - Round†</b>	17502	
<b>Die - Round</b>	17504	
<b>Die - Round Slug Hugger® 2</b>	17604	
<b>Die Shim Pack*</b>	17602	

## WS4

Up to 1.30" [33mm]

- Punches can be resharpened .157" [4mm]
- Dies can be resharpened .060" [1.5mm]

DESCRIPTION	PART NO.	PRICE
<b>Punch - Round</b>	17500	
<b>Punch - Shape</b>	17501	
<b>Optima® Coating</b>	—	
<b>Stripper - Round†</b>	17502	
<b>Stripper - Shape</b>	17503	
<b>Die - Round</b>	17504	
<b>Die - Round Slug Hugger® 2</b>	17604	
<b>Die - Shape</b>	17505	
<b>Die - Shape Slug Hugger® 2</b>	17605	
<b>Die Shim Pack*</b>	17602	

### H3 HEAD

	30	31	32	33	34	35
<b>24</b> 90 x 90	76	68	60	56	52	48
	75	67	59	55	51	47
<b>23</b> 70 x 90	74	66	58	54	50	46
	73	65	57	53	49	45
<b>22</b> 70 x 90	72	64	20	16	12	8
	71	63	19	15	11	7
<b>21</b> 90 x 90	70	62	18	14	10	6
	69	61	17	13	9	5

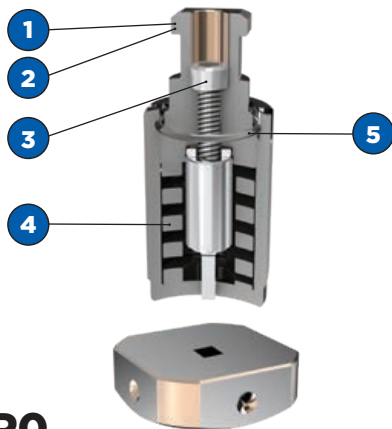
### STANDARD SHAPE DIE VIEW

	0°	90°	180°	270°

†Round strippers available up to 1.378" [35mm] dia.

\*Die Shim Pack includes:  
- 5 each .004" [0.1mm]  
- 3 each .008" [0.2mm]  
- 2 each .012" [0.3mm]

# FULLY GUIDED PERFORATING ASSEMBLY

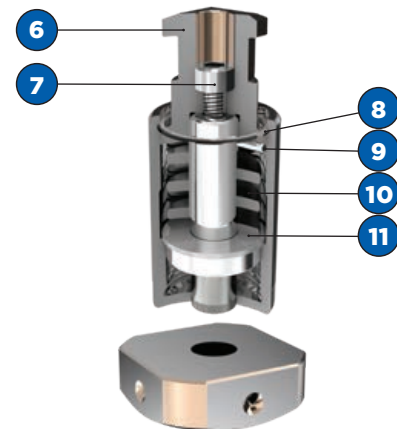


## WPO

0.031" x 0.394" [0.79mm x 10mm]

- Punches can be resharpened .060" [1.5mm]
- Dies can be resharpened .060" [1.5mm]

DESCRIPTION	PART NO.	PRICE
<b>Punch Assembly - Round</b>	17510	
<b>Punch Assembly - Shape</b>	17511	
<b>Punch - Round</b>	17512	
<b>Punch - Shape</b>	17513	
<b>Optima® Coating</b>	—	
<b>Stripping Guide - Round</b>	17514	
<b>Stripping Guide - Shape</b>	17515	
<b>Die - Round</b>	17504	
<b>Die - Round Slug Hugger* 2</b>	17604	
<b>Die - Shape</b>	17505	
<b>Die - Shape Slug Hugger* 2</b>	17605	
<b>Die - Shim Pack*</b>	17602	
<b>1 Punch Holder - Round</b>	17516	
<b>2 Punch Holder - Shaped</b>	17517	
<b>3 Socket Head Cap Screw</b>	6409	
<b>4 Spring</b>	980644	
<b>5 Retaining Ring</b>	980572	



## WP9

Up to 1.023" [26mm]

- Punches can be resharpened .118" [3mm]
- Dies can be resharpened .060" [1.5mm]

DESCRIPTION	PART NO.	PRICE
<b>Punch Assembly - Round</b>	17529	
<b>Punch Assembly - Shape</b>	17521	
<b>Punch - Round</b>	17522	
<b>Punch - Shape</b>	17523	
<b>Optima® Coating</b>	—	
<b>Stripping Guide - Round</b>	17524	
<b>Stripping Guide - Shape</b>	17525	
<b>Die - Round</b>	17504	
<b>Die - Round Slug Hugger* 2</b>	17604	
<b>Die - Shape</b>	17505	
<b>Die - Shape Slug Hugger* 2</b>	17605	
<b>Die - Shim Pack*</b>	17602	
<b>6 Punch Holder</b>	17526	
<b>7 Socket Head Cap Screw</b>	6416	
<b>8 Retaining Ring</b>	17528	
<b>9 Dowel Pin</b>	980273	
<b>10 Spring</b>	6241	
<b>11 Spring Support Washer</b>	17527	

		H3 HEAD					
		30	31	32	33	34	35
<b>24</b> 90 x 90	76	68	60	56	52	48	44
	75	67	59	55	51	47	43
<b>23</b> 70 x 90	74	66	58	54	50	46	42
	73	65	57	53	49	45	41
<b>22</b> 70 x 90	72	64	20	16	12	8	4
	71	63	19	15	11	7	3
<b>21</b> 90 x 90	70	62	18	14	10	6	2
	69	61	17	13	9	5	1

\*Die Shim Pack includes:  
 - 5 each .004" [0.1mm]  
 - 3 each .008" [0.2mm]  
 - 2 each .012" [0.3mm]

STANDARD SHAPE - DIE VIEW										
0°										
90°										
180°										
270°										

# 60mm PUNCH, STRIPPER, DIE

## WP5

Up to 1.669" [42.4mm]

- Punches can be resharpened .157" [4mm]
- Dies can be resharpened .060" [1.5mm]



## WP6

Up to 2.362" [60mm]

- Punches can be resharpened .157" [4mm]
- Dies can be resharpened .060" [1.5mm]



DESCRIPTION	PART NO.	PRICE
Punch - Round	17532	
Punch - Shape	17533	
Optima® Coating	—	
Stripper - Round	17534	
Stripper - Shape	17535	
Die - Round	17536	
Die - Round Slug Hugger* 2	17636	
Die - Shape	17537	
Die - Shape Slug Hugger* 2	17637	
Die Brush* [8mm]	17601	

\*Dies come with brushes installed.

DESCRIPTION	PART NO.	PRICE
Punch - Round	17542	
Punch - Shape	17543	
Optima® Coating	—	
Stripper - Round	17544	
Stripper - Shape	17545	
Die - Round	17536	
Die - Round Slug Hugger* 2	17636	
Die - Shape	17537	
Die - Shape Slug Hugger* 2	17637	
Die Brush* [8mm]	17601	

\*Dies come with brushes installed.

H3 HEAD							
	30	31	32	33	34	35	
<b>24</b> 90 x 90	76	68	60	56	52	48	44
	75	67	59	55	51	47	43
<b>23</b> 70 x 90	74	66	58	54	50	46	42
	73	65	57	53	49	45	41
<b>22</b> 70 x 90	72	64	20	16	12	8	4
	71	63	19	15	11	7	3
<b>21</b> 90 x 90	70	62	18	14	10	6	2
	69	61	17	13	9	5	1

STANDARD SHAPE — DIE VIEW										
0°										
90°										
180°										
270°										

When ordering, specify orientation if the shape is other than a round or square.

# LARGE STATION PUNCH, STRIPPER, DIE

## WS8

2.755" x 3.543" [70mm x 90mm]

- Punches can be resharpened .157" [4mm]
- Dies can be resharpened .060" [1.5mm]

*Slug retention options available upon request.*

DESCRIPTION	PART NO.	PRICE
Punch - Round	17562	
Punch - Shape	17563	
Optima® Coating	—	
Stripper - Round	17564	
Stripper - Shape	17565	
Die - Round	17566	
Die - Round Slug Hugger* 2	17666	
Die - Shape	17567	
Die - Shape Slug Hugger* 2	17667	
Large Brush [13mm]	17600	

Die and Strippers come with brushes installed.



TYPE 70							
	30	31	32	33	34	35	
<b>24</b> 70x90	76	68	60	56	52	48	44
	75	67	59	55	51	47	43
<b>23</b> 70x90	74	66	58	54	50	46	42
	73	65	57	53	49	45	41
<b>22</b> 70x90	72	64	20	16	12	8	4
	71	63	19	15	11	7	3
<b>21</b> 70x90	70	62	18	14	10	6	2
	69	61	17	13	9	5	1

STANDARD SHAPE – DIE VIEW											
0°											
90°											
180°											
270°											

# LARGE STATION PUNCH, STRIPPER, DIE



## WS9

2.755" x 3.543" [70mm x 90mm]

- Punches can be resharpened .157" [4mm]
- Dies can be resharpened .060" [1.5mm]

Slug retention options available upon request.

DESCRIPTION	PART NO.	PRICE
Punch - Round	17562	
Punch - Shape	17563	
Optima® Coating	—	
Stripper - Round	17574	
Stripper - Shape	17575	
Die - Round	17576	
Die - Round Slug Hugger® 2	17676	
Die - Shape	17577	
Die - Shape Slug Hugger® 2	17677	
Die Brush* [8mm]	17600	

\*Dies come with brushes installed.

## WSA

3.543" x 3.543" [90mm x 90mm]

- Punches can be resharpened .157" [4mm]
- Dies can be resharpened .060" [1.5mm]

Slug retention options available upon request.

DESCRIPTION	PART NO.	PRICE
Punch - Round	17582	
Punch - Shape	17583	
Optima® Coating	—	
Stripper - Round	17584	
Stripper - Shape	17585	
Die - Round	17586	
Die - Round Slug Hugger® 2	17686	
Die - Shape	17587	
Die - Shape Slug Hugger® 2	17687	
Large Brush [13mm]	17600	

Die and Strippers come with brushes installed.

### STANDARD SHAPE — DIE VIEW

Angle	Circle	Square	Hexagon	Octagon	Rectangle	Triangle	Star	Circle	Triangle	Circle	Triangle
0°	●	■	⬡	⬢	▭	▴	☆	●	▴	●	▴
90°			⬡		▭	▴		●	▴	●	▴
180°						▴		●	▴	●	▴
270°						▴		●	▴	●	▴

### TYPE 90

	30	31	32	33	34	35
<b>24</b> 70 x 90	76	68	60	56	52	48
	75	67	59	55	51	47
<b>23</b> 70 x 90	74	66	58	54	50	46
	73	65	57	53	49	45
<b>22</b> 70 x 90	72	64	20	16	12	8
	71	63	19	15	11	7
<b>21</b> 70 x 90	70	62	18	14	10	6
	69	61	17	13	9	5

Verify what stations are in the cartridge.



# SHEAR OPTIONS

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

SHEAR DETAILS	A DIMENSION	EXCEPTION
<ul style="list-style-type: none"> <li>1/32" (0.8mm) inverted rooftop shear is given to all punches with A Dim greater than 2.000" [50.8mm] and width greater than .250" [6.35mm] at no extra charge.</li> <li>All punches .250" [6.35mm] and under in width will be shipped with no shear unless specified.</li> </ul>		In some instances, inverted rooftop is substituted for single and double concave shears.

Scan QR Code for Punching Force Chart



## ULTIMA® PREMIUM TOOL STEEL IMPROVES DURABILITY AND PERFORMANCE

Available exclusively from Wilson Tool, Ultima® premium tool steel is engineered to increase wear resistance by up to an astounding 100% over conventional tool steels. Ultima punches and dies are especially useful for the toughest applications, but are effective for any job.

### A New Level of Performance

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

### Remarkable Downtime Reductions

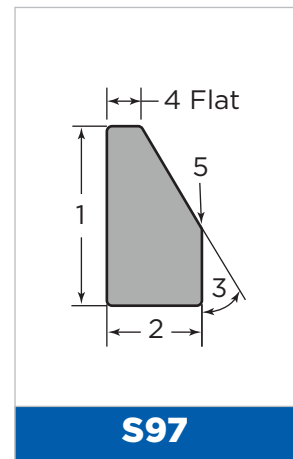
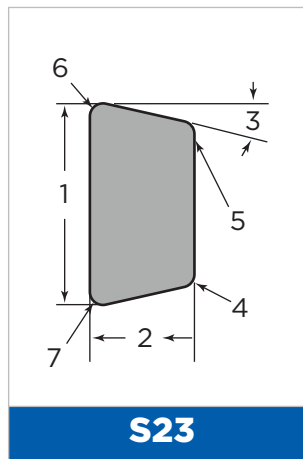
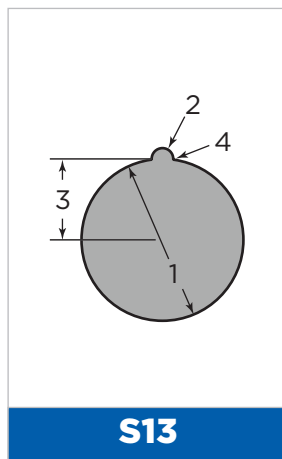
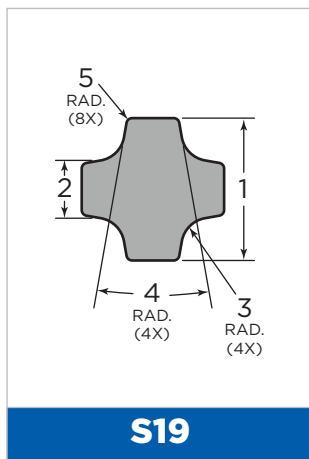
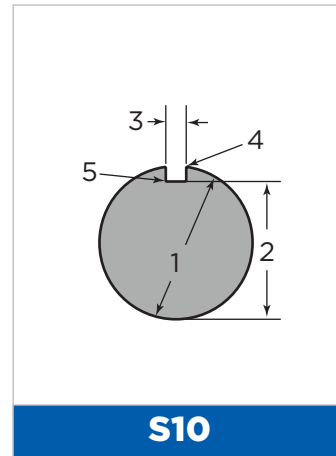
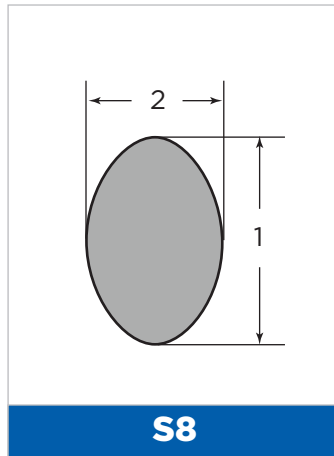
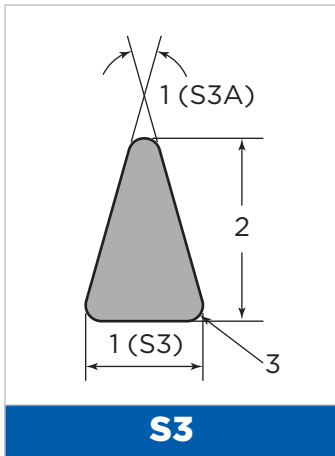
With up to twice as long between regrinds, Ultima punches and dies substantially reduce downtime and tool replacement costs. Breaking, chipping, cracking, tool fatigue and other problems are minimized, providing long-term gains in productivity and profitability.

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



Scan QR Code for Ultima® Premium Tool Steel Flyer

## SPECIAL SHAPES



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

# XSHARP™ GRINDER

Scan QR Code to See XSharp™ in Action



### 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: Adapter required for 33mm dies.

\*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

# HAND TOOLS

## MAGNET SQUARE



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

**Catalog No. 974150**

## SAE HEX KEY WRENCH SET



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

**Catalog No. 6057**

## OIL STONE



3 square aluminum oxide sharpening stone.

**Catalog No. 6060**

## METRIC HEX KEY WRENCH SET



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

**Catalog No. 6105**

## DIAMOND FILE



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

**Catalog No. 6059**

## SOFT FACE HAMMER



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

**Catalog No. 6106**

## EXP® PUNCH REMOVAL KEY



This wrench is designed for use with EXP® punches.

**Catalog No. 6989**

## 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**


# 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**

# TOOL MAINTENANCE

**RUBBERIZED ABRASIVE WHEEL**




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

**Catalog No. 8050**

# 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

ACCESSORIES

# 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

# 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

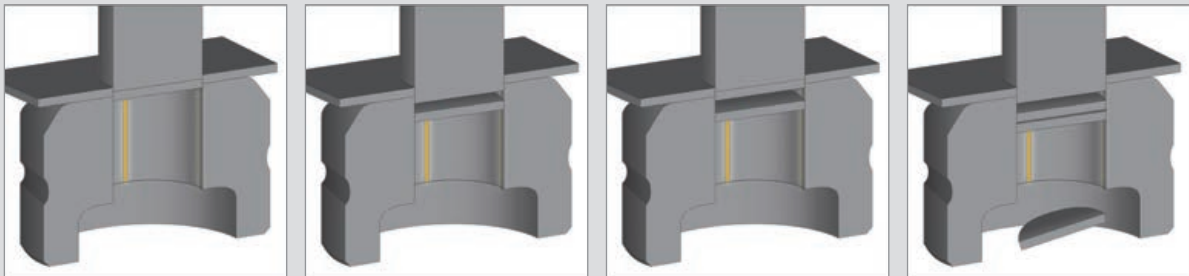
- Reduce scrapped parts, costly downtime, and possible press and tooling damage from slug pulling.
- Unique design helps eliminate unnecessary back-pressure on small punch tips by preventing packed slugs.
- Works on most material types and thicknesses including aluminum and stainless steel.
- Available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



SALVAGNINI

## 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.

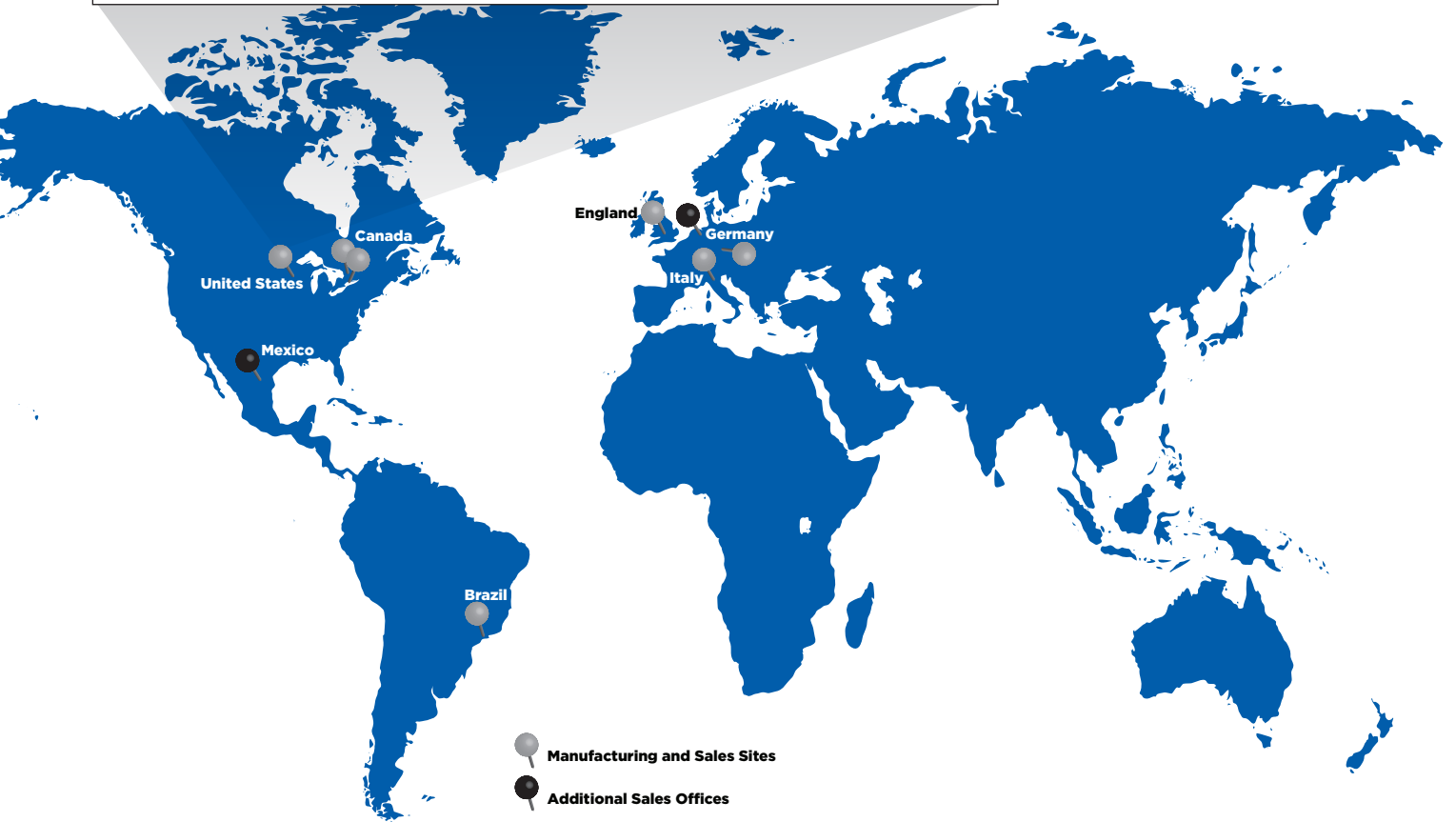


Note: Slug Hugger dies must be ordered punch size plus clearance. Size restrictions apply.

# WILSON TOOL INTERNATIONAL HEADQUARTERS

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**800.328.9646** | **punching@wilsontool.com**

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**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.



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