



TRUMPF-STYLE PUNCH TOOLING SOLUTIONS

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by Wilson Tool International

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TERMS AND CONDITIONS

ORDER Minimum order is \$50.00

CREDIT REQUIREMENTS All orders are subject to approval by our Credit Department. If you are a new account, please furnish us with your tax exempt status, a bank reference, three current supplier references and/or your current D&B rating with your first order. A credit limit will be imposed on new accounts until credit has been established.

PAYMENT TERMS Terms are net 10 days. Catalog prices are subject to change without notice.

FREIGHT Orders are shipped F.O.B. from our manufacturing facility. (International Shipments are Incoterms: Ex Works).

ORDER CANCELLATION If an order is canceled, an additional charge will be assessed to cover the cost of labor and material.

RETURNED MATERIAL A handling/restocking fee will be applied to all standard products returned for credit. A return authorization number and shipping instructions must be obtained in advance before an item can be returned.

CLAIMS All claims or product shortages must be made within 30 days of the invoice date.



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MACHINE GROUPS										
A	B	C	D	E		F	G	H	I	S
CN 700	CN 901E	CN 1200S	TRUMATIC	SUNIMAT 400		TRUMATIC	TRUMATIC	TRUMATIC	TRUMATIC	MINIMATIC
CN 900	CN 902	CN 1200A	20	TRUMATIC	TRUMATIC	150W	20AW	500R	2000R	100
CN 701	CS 75	CS 15	20A	150K	202K	152W	202W	200R	2010R	TRUMATIC
CN 901	CS 75.2	CS 20	202M	151K	225K	180W	300W	190R	2020R	120R
		CS 20A		152K	235K	180.2W	300LW	600L	3000-1300R	160R
		MP 25		180K	300K	180R	300PW		3000-1600R	
		MP 25D		180.2K	300LK	180LW	300TOP		5000R	
				180KD	300PK	180.2LW	400W		6000R	
				180LK	400K	ELX/SWIFT			1000R	
				180.2LK		185			7000L	
						240				
						240R				
						250				
						260R				

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.



INCREASE GRIND LIFE OF TRUMPF-STYLE DIES

Cut retooling costs, save valuable time and get more out of your tooling when you increase your die's grind life up to 150%. Wilson Tool International's TRUMPF-style grind life ("GL") die and die plate enable you to shim your dies up to 2.5mm instead of the standard 1.0mm maximum.

GL Die

The radius profile of the GL die allows up to 1.5mm of grind life with the standard die plate, or 2.5mm with the GL die plate, while still having radius left to allow the sheet to flow over the top of the die.

GL Die Plate and Key

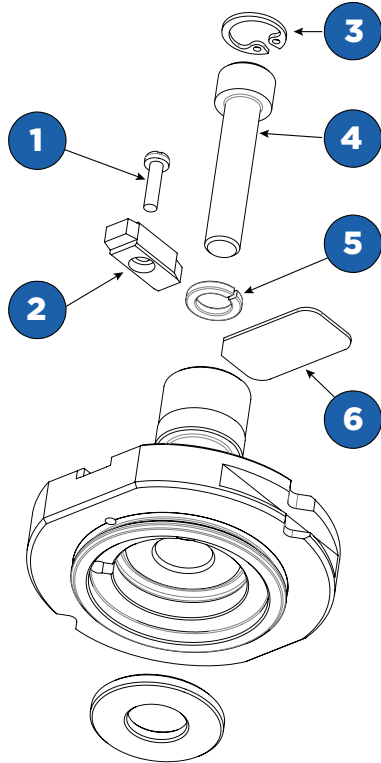
The GL die plate and key allow for the GL die to be shimmed up to 2.5mm while still maintaining key engagement.

The key is coated in Wilson Tool's Nitrex® coating for easy identification. Nitrex is commonly used in piercing, blanking and forming applications for improved durability.

The GL size 2 die plate key contains a spring loaded ball plunger to better secure the die. The size 2 key is available separately and is also compatible with standard die plates.



2-4-1 SERIES

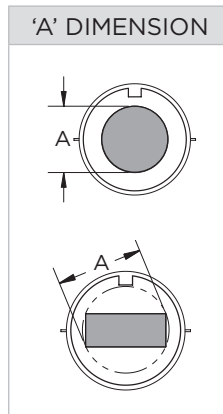


Punch Assembly 26659 shown

2-4-1 PUNCH HOLDERS		
Description	Cat. No.	Price
Punch Holder Assembly* 0 - 1.575" [0 - 40mm]	26659	
Precision Ground Spacer 0 - 1.575" [0 - 40mm]	25806	
Punch Holder Assembly* 1.576 - 3.000" [40.01 - 76.20mm]	26660	
Precision Ground Spacer 1.576 - 3.000" [40.01 - 76.20mm]	25807	

*Each Punch Holder Assembly is shipped with a Precision Ground Spacer.

REPLACEMENT PARTS		
Description	Cat. No.	Price
1 Cheese Head Screw M3 X 12mm [0 - 40]	25215	
Cheese Head Screw M3 x 7mm [40.01 - 76.2]	24150	
2 Punch Body Location Key	25113	
3 Retaining Ring 15.1mm x 1.0mm	24424	
4 Socket Head Cap Screw M8 x 40mm	30161	
5 Lockwasher M8	974100	
6 Magnetic I.D. Label	26657	

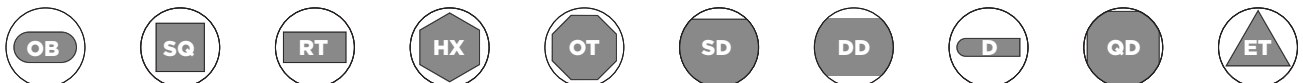


ROUND 2-4-1 DIE INSERT		
'A' Dimension	Cat. No.	Price
0 - 1.575" [0 - 40.0mm]	25980	
1.576 - 2.205" [40.01 - 56.0mm]	25982	

SHAPE 2-4-1 DIE INSERT		
'A' Dimension	Cat. No.	Price
0 - 1.575" [0 - 40.0mm]	25979	
1.576 - 2.205" [40.01 - 56.0mm]	25981	

DIE SHIM PACKS		
Dimension	Cat. No.	Price
0 - 1.575" [0 - 40.0mm]	25983	
1.576 - 2.205" [40.01 - 56mm]	25984	

STANDARD SHAPES



2-4-1 SERIES ROUND



Flat

ROUND PUNCH							
'A' Dimension	Flat		Whisper Shear		Long Flat**		Optima [®] Add-on
	Cat. No.	Price	Cat. No.	Price	Cat. No.	Price	
.093 - 1.181" [2.36 - 30.00mm]	25768		25769		25770		
1.182 - 1.575" [30.01 - 40.000mm]	25774		25775		25776		
1.576 - 2.205" [40.01 - 56.00mm]	25780		25781		25782		
2.206 - 2.598" [56.01 - 66.00mm]	25786		25787		25788		
2.599 - 3.000" [66.01 - 76.20mm]	25792		25793		25794		

** For Group I machines.



Whisper Shear

ROUND STRIPPER		
Description	Cat. No.	Price
Group H/I	25358	
Keyed	25006	
Stripper Pin	25179	

PUSH ON 2-4-1 URETHANE STRIPPERS		
Description	Cat. No.	Price
For Flat [0 - 30mm 'A' Dim]	26661	
For Whisper/Long [0 - 30mm 'A' Dim]	26649	
For Flat [30.01 - 40mm 'A' Dim]	26662	
For Whisper/Long [30.01 - 40mm 'A' Dim]	26652	



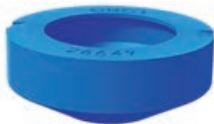
Long

ROUND GL DIE			
Size	'A' Dimension	Cat. No.	Price
I	Up to 1.260" [32.0mm]	26739	
	Up to 1.528" [38.0mm*]	26737	
II	1.261 - 3.031" [32.01 - 77.0mm]	26727	



Stripper

ADD ON FOR SPECIAL SHEARS		
Size	Description	Price
I	Inverted Rooftop / Single Concave	
II		
I	Double Valley / Double Concave	
II		

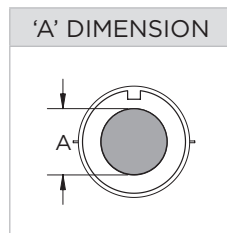


Urethane Stripper

ADD ON FOR ROUNDS			
Size	Small Diameter	Punch	Die
	.031 - .061" [0.79 - 1.56mm]		
	.062 - .092" [1.57 - 2.34mm]		N/C
I	Clearance ≤ .002" [≤ 0.05mm]		
	Clearance .003 - .004" [.076 - 0.10mm]		
II	Clearance ≤ .002" [≤ 0.05mm]		
	Clearance .003 - .004" [.076 - 0.10mm]		



GL Die



STANDARD SHAPES



2-4-1 SERIES SHAPE

SHAPE PUNCH							
'A' Dimension	Flat		Whisper Shear		Long Flat**		Optima* Add-on
	Cat. No.	Price	Cat. No.	Price	Cat. No.	Price	
.093 - 1.181" [2.36 - 30.00mm]	25771		25772		25773		
1.182 - 1.575" [30.01 - 40.000mm]	25777		25778		25779		
1.576 - 2.205" [40.01 - 56.00mm]	25783		25784		25785		
2.206 - 2.598" [56.01 - 66.00mm]	25789		25790		25791		
2.599 - 3.000" [66.01 - 76.20mm]	25795		25796		25797		

** For Group I machines.

PUSH ON 2-4-1 URETHANE STRIPPERS		
Description	Cat. No.	Price
For Flat [0 - 30mm 'A' Dim]	26661	
For Whisper / Long [0 - 30mm 'A' Dim]	26649	
For Flat [30.01 - 40mm 'A' Dim]	26662	
For Whisper / Long [30.01 - 40mm 'A' Dim]	26652	

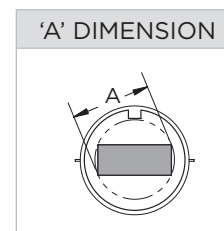
SHAPE STRIPPER		
Description	Cat. No.	Price
Group H/I	25359	
Keyed	25028	
Stripper Pin	25179	

ADD ON FOR SPECIAL SHEARS		
Size	Description	Price
I	Inverted Rooftop / Single Concave	
II		
I	Double Valley / Double Concave	
II		

SHAPE GL DIE			
Size	Description	Cat. No.	Price
I	Up to 1.260" [32.0mm]	26740	
	Up to 1.528" [38.0mm*]	26738	
II	1.261 - 3.031" [32.01 - 77.0mm]	26726	

ADD ON FOR RADIUS OR 45° CHAMFER 4 CORNERS	
Punch	Price
.001 - .062" [0.02 - 1.57mm]	
.063 - .250" [1.58 - 6.35mm]	
Greater than .250" [6.35mm]	
Die	Price
Any Size	

ADD ON FOR SHAPES			
Size	Small Diameter	Punch	Die
I	.031 - .039" [0.79 - 1.00mm]		
	.040 - .092" [1.01 - 2.34mm]		N/C
II	.031 - .039" [0.79 - 1.00mm]		
	.040 - .092" [1.01 - 2.34mm]		N/C
I	Clearance ≤ .002" [≤ 0.05mm]		
	Clearance .003 - .004" [.076 - 0.10mm]		
II	Clearance ≤ .002" [≤ 0.05mm]		
	Clearance .003 - .004" [.076 - 0.10mm]		



2-4-1 SERIES

STANDARD SHAPES



STANDARD ROUND

STANDARD



Flat



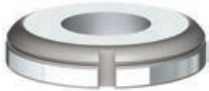
Whisper Shear



Long Flat



Stripper



GL Die

STANDARD ROUND PUNCH								
Size	'A' Dimension	Flat		Whisper Shear		Long Flat**		Optima* Add-on
		Cat. No.	Price	Cat. No.	Price	Cat. No.	Price	
O+	.093 - .236" [2.36 - 6.0mm]	25008		—	—	25740		
	.237 - .413" [6.01 - 10.5mm]	25009		—	—	25744		
I	.093 - 1.181" [2.36 - 30.0mm]	25004		25069		25748		
II	1.182 - 1.496** [30.01 - 38.0mm*]	25035		25071		—	—	
	1.182 - 1.575" [30.01 - 40.0mm]	25042		25071		25752		
	1.576 - 2.000" [40.01 - 50.8mm]	25043		25072		25756		
	2.001 - 3.000" [50.81 - 76.2mm]	25002		25073		25760		

*Not recommended for punching stainless steel.

*For Group S machines.

**For Group I machines.

ROUND STRIPPER		
Description	Cat. No.	Price
Group H/I	25358	
Keyed	25006	
Group 'S'	25032	
Non-Keyed	25136	
Stripper Pin	25179	

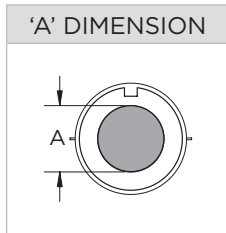
ROUND GL DIE			
Size	'A' Dimension	Cat. No.	Price
I	Up to 1.260" [32.0mm]	26739	
	I Up to 1.528" [38.0mm*]	26737	
II	1.261 - 3.031" [32.01 - 77.0mm]	26727	

*For Group S machines.

For size III tooling, contact our punching Tooling Technicians.

ADD ON FOR SPECIAL SHEARS		
Size	Description	Price
I	Inverted Rooftop / Single Concave	
II		
I	Double Valley / Double Concave	
II		

ADD ON FOR ROUNDS			
Size	Small Diameter	Punch	Die
	.031 - .061" [0.79 - 1.56mm]		
	.062 - .092" [1.57 - 2.34mm]		N/C
I	Clearance ≤ .002" [≤ 0.05mm]		
	Clearance .003 - .004" [.076 - 0.10mm]		
II	Clearance ≤ .002" [≤ 0.05mm]		
	Clearance .003 - .004" [.076 - 0.10mm]		



STANDARD SHAPES



STANDARD SHAPE

STANDARD SHAPE PUNCH								
Size	'A' Dimension	Flat		Whisper Shear		Long Flat**		Optima* Add-on
		Cat. No.	Price	Cat. No.	Price	Cat. No.	Price	
O+	.093 - .236" [2.36 - 6.0mm]	25022		—	—	25743		
	.237 - .413" [6.01 - 10.5mm]	25023		—	—	25747		
I	.093 - 1.181" [2.36 - 30.0mm]	25026		25063		25751		
II	1.182 - 1.496** [30.01 - 38.0mm*]	25031		25065		—	—	
	1.182 - 1.575" [30.01 - 40.0mm]	25039		25065		25755		
	1.576 - 2.000" [40.01 - 50.8mm]	25040		25066		25759		
	2.001 - 3.000" [50.81 - 76.2mm]	25001		25067		25763		

*Not recommended for punching stainless steel.

*For Group S machines.

**For Group I machines.

SHAPE GL DIE			
Size	'A' Dimension	Cat. No.	Price
I	Up to 1.260" [32.0mm]	26740	
	I Up to 1.528" [38.0mm*]	26738	
II	1.261 - 3.031" [32.01 - 77.0mm]	26726	

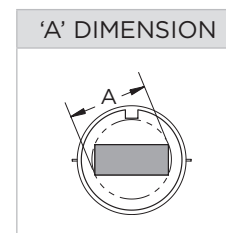
*For Group S machines.

SHAPE STRIPPER		
Description	Cat. No.	Price
Group H/I	25359	
Keyed	25028	
Group 'S'	25030	
Non-Keyed	25137	
Stripper Pin	25179	

ADD ON FOR RADIUS OR 45° CHAMFER 4 CORNERS	
Punch	Price
.001 - .062" [0.02 - 1.57mm]	
.063 - .250" [1.58 - 6.35mm]	
Greater than .250" [6.35mm]	
Die	Price
Any Size	

ADD ON FOR SPECIAL SHEARS		
Size	Description	Price
I	Inverted Rooftop / Single Concave	
II		
I	Double Valley / Double Concave	
II		

ADD ON FOR SHAPES			
Size	Small Diameter	Punch	Die
I	.031 - .039" [0.79 - 1.00mm]		
	.040 - .092" [1.01 - 2.34mm]		N/C
II	.031 - .039" [0.79 - 1.00mm]		
	.040 - .092" [1.01 - 2.34mm]		N/C
I	Clearance ≤ .002" [≤ 0.05mm]		
	Clearance .003 - .004" [.076 - 0.10mm]		
II	Clearance ≤ .002" [≤ 0.05mm]		
	Clearance .003 - .004" [.076 - 0.10mm]		



Flat



Whisper Shear



Long Flat



Stripper



GL Die

STANDARD

STANDARD SHAPES



HEAVY DUTY TOOLING



Alignment Collar

Designed to withstand the higher tonnage associated with punching and nibbling thicker materials.

- The large shoulder punch withstands the higher force involved.
- The punch has extra back taper as standard, reducing galling and pick-up.
- Optima® coating greatly improves performance.
- The die is strengthened by a step on the bottom.



Flat



Whisper Shear



Rooftop



Stripper Round



Heavy Duty Die

HEAVY DUTY TOOLING			ROUND		SHAPE	
	Punch	'A' Dimension	Cat. No.	Price	Cat. No.	Price
1	Flat	.394 - 1.575" [10 - 40mm]	25140		25141	
1	Whisper Shear	.394 - 1.575" [10 - 40mm]	25322		25321	
1	Rooftop	1.575 - 3.000" [40 - 76.2mm]	25407		25406	
	Optima® add-on for punch		—		—	
			Cat. No.	Price	Cat. No.	Price
2	Heavy Duty Die		26733		26728	
3	Stripper, Keyed		25006		25028	
4	Stripper, Non-keyed		25136		25137	
5	Stripper Group H		25358		25359	
6	Heavy Duty Alignment Collar		25138		25138	
7	Spare Collar Key		25142		25142	
8	Key Locating Screw		25215		25215	
	Collar Clamping Screw		25216		25216	
	Die Shim Pack (not shown)		25182		25182	

DESIGN CRITERIA	'A' DIMENSION
<ul style="list-style-type: none"> • Minimum punch dia .394" [10mm]. For < .394" [10mm] use standard Size 1 punch. • Maximum die 'A' dimension 2.716" [69mm]. • Uses Heavy Duty system collar. • .039" [1.00mm] radius on corners will increase the life of the punch and die. • Rooftop or whisper shear will reduce the tonnage significantly as long as the depth of shear is at least half the thickness of the material. • Heavy Duty punch to be used on material .250" [6.35mm] thick and above or where punching force is over 22.5 tons. • Heavy Duty die to be used where punching force is over 20 tons. • Uses standard strippers. • Tools for thicker plate often exceed the machine tonnage. Ask our Tooling Technicians to verify. 	
INFORMATION REQUIRED	MATERIAL THICKNESS
<ul style="list-style-type: none"> • Size and shape of punch. • Material thickness and type. • Machine model. 	

STANDARD SHAPES

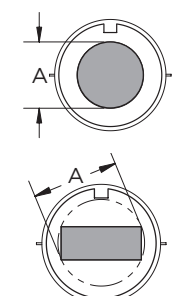


KEYED COLLAR & PUNCH

KEYED COLLAR			
Size	Description	Cat. No.	Price
II	0° - 45° - 90° - 180°	25317	
KEYED PUNCH			
	'A' Dimension	Cat. No.	Price
Flat	Up to 2.380" [60.5mm]	25376	
	2.380 - 3.000" [60.5 - 76.2mm]	25575	
Whisper	up to 2.380" [60.5mm]	25576	
	2.380 - 3.000" [60.5 - 76.2mm]	25577	
Optima* add-on for punch		-	



HEAVY DUTY

DESIGN CRITERIA	'A' DIMENSION
<ul style="list-style-type: none"> Allows for a keyed punch to be set at 0°, 45°, 90° or 135° without the use of Quick Set. Designed for use with Wilson Tool Keyed Trumpf-style punches. With a keyed punch and collar, a positive key location between the punch and collar results in cost savings that are realized by less scrap and longer tool life. The positioning is 100% reliable and repeatable. Fixed slots for greater accuracy and consistency. Inherent accuracy reduces the reliance required on the operator. The punch cannot turn at all during operation, resulting in scrap rate reduction. 	

STANDARD SHAPES



PARTING TOOLS

PARTING AND SLITTING ARE COMMON PRACTICES IN SHEET METAL FABRICATION.

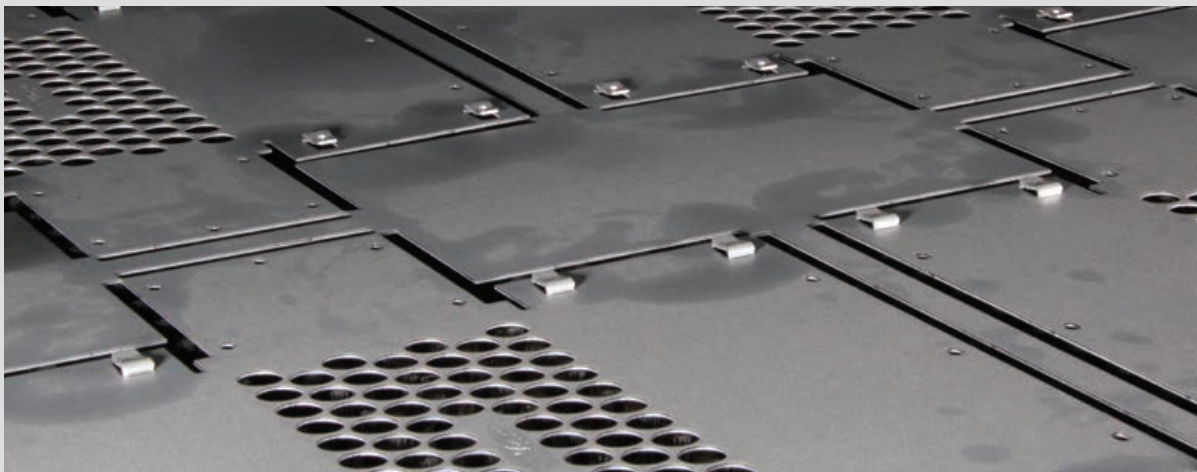
Whether you are parting nested parts or straightening the edge of the sheet, you need a product that is rigid and delivers a long tool life. Wilson Tool developed TRUMPF-style parting products specifically to maximize your productivity for these applications. Even when punching close to a form.

HP DuraBlade® has a replaceable cutting blade insert made from Ultima® premium tool steel that delivers up to 100% more tool life. It also has a self-stripping steel stripper that is relieved for punching close to forms.

2-4-1 Parting Punch Assembly has a replaceable cutting blade insert made from Ultima® premium tool steel that delivers up to 100% more tool life. It has replaceable wedged urethane strippers mounted on the sides to allow punching close to forms without crushing them.

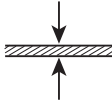
Standard Parting Punch Assembly is a solid size 2 punch with replaceable wedged urethane strippers mounted on the sides to allow punching close to forms without crushing them.

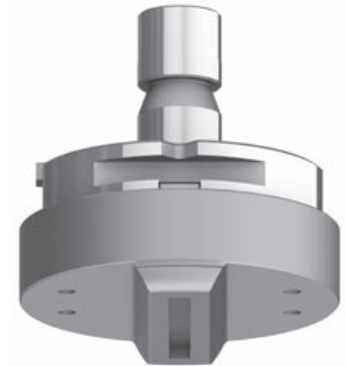
Parting Tool Die has a removable insert that can be replaced at lower cost than a conventional die.



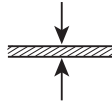
CLOSE TO FORM PARTING PUNCH

HP DURABLADE® PUNCH ASSEMBLY		
Description	Cat. No.	Price
Complete punch assembly (includes shims)	26783	
Punch insert only	26781	
2.5mm shim pack	26789	

INFORMATION NEEDED		MATERIAL THICKNESS
Maximum material thickness	.118" [3mm]	
Maximum width	.250" [6.35mm]	
Maximum length	2.204" [56mm]	

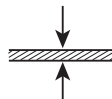


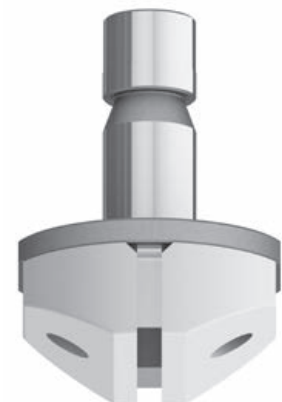
2-4-1 PUNCH ASSEMBLY				
Description	30-60mm Length		60-76.2mm Length	
	Cat. No.	Price	Cat. No.	Price
Complete punch assembly (includes shims)	26802		26800	
Punch only	26803		26801	
Urethane Strippers (Pair)	26760		26762	
Stripper Screws	25205		25205	

INFORMATION NEEDED			MATERIAL THICKNESS
Maximum material thickness	Stainless Steel	.060" [1.52mm]	
	Mild Steel / Aluminum	.078" [1.98mm]	
Maximum width	.250" [6.35mm]		
Maximum length	3.00" [76.2mm]		



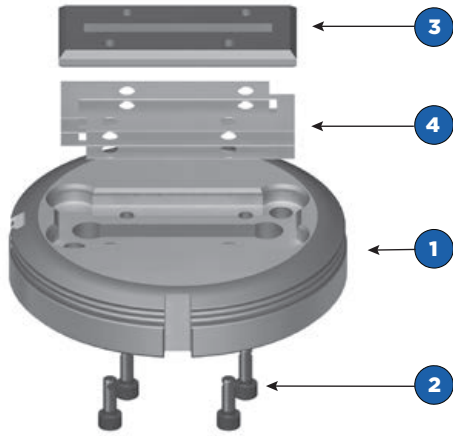
STANDARD PUNCH ASSEMBLY				
Description	30-60mm Length		60-76.2mm Length	
	Cat. No.	Price	Cat. No.	Price
Complete punch assembly (includes shims)	26761		26763	
Punch only	25586		25589	
Urethane Strippers (Pair)	26760		26762	
Stripper Screws	25205		25205	

INFORMATION NEEDED			MATERIAL THICKNESS
Maximum material thickness	Stainless Steel	.060" [1.52mm]	
	Mild Steel / Aluminum	.078" [1.98mm]	
Maximum width	.250" [6.35mm]		
Maximum length	3.00" [76.2mm]		



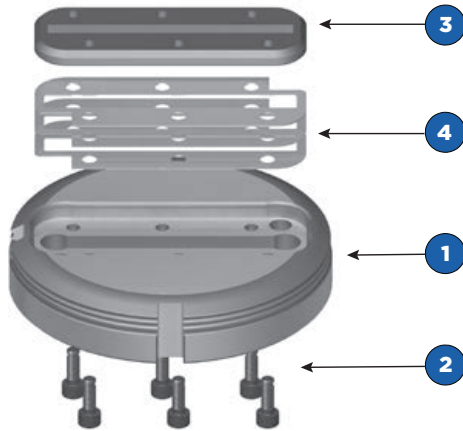
PARTING TOOLS

PARTING TOOL DIE



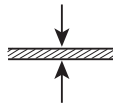
PARTING TOOL DIE ASSEMBLY			
Lengths up to 2.250" (57.15mm)		Widths up to .250" [6.35mm]	
	Description	Cat. No.	Price
1	Complete Assembly without Blade	25464	
2	Blade Fixing Screw (4 required)	25443	
3	Blade, max. length 2.250" [57.15mm]	25463	
4	Shim Pack	25439	

This blade holder is designed to accept the interchangeable rectangular die blades, and also any special shapes with maximum length of 2.250" (57.15mm).



PARTING TOOL DIE ASSEMBLY			
Lengths up to 3.000" (76.20mm)		Widths up to .250" [6.35mm]	
	Description	Cat. No.	Price
1	Complete Assembly without Blade	25466	
2	Blade Fixing Screw (6 required)	25443	
3	Blade, max. length 3.000" [76.20mm]	25465	
4	Shim Pack	25441	

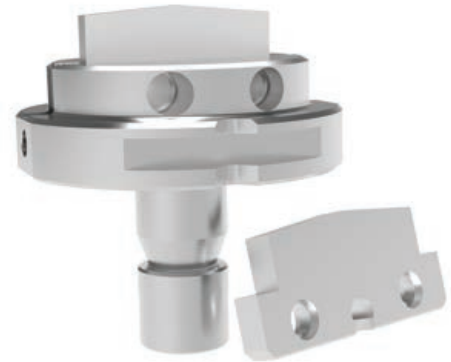
This blade holder is designed to accept die blades, with maximum length of 3.000" (76.20mm).

DESIGN INFORMATION	MAX. MATERIAL THICKNESS	INFORMATION REQUIRED
<ul style="list-style-type: none"> Special sizes and shapes available. Must fit within ranges as specified. Blades can be reground by .039" (1.00mm) max. Must be held flat for regrinding and coolant must be used. To ensure the screws do not come loose, reassemble using Loctite. 	.118" [3.00mm] 	<ul style="list-style-type: none"> Conventional rectangle size or special size and shape Material thickness and type Machine model

QUICK SET PARTING TOOL PUNCH

QUICK SET PARTING TOOL PUNCHES		
Description	Cat. No.	Price
Complete Assembly without Blade 0° (.200") (Pullmax)	25613	
Complete Assembly without Blade 90° (.200")* (Standard)	25614	
Complete Assembly without Blade 0° (.250") (Pullmax)	25611	
Complete Assembly without Blade 90° (.250")* (Standard)	25612	
Location Pin	970416	
Blade Locking Screw	25345	
Blade: 0 - 1.181" [30.0mm] — .200" [5.08mm]	25605	
Blade: 0 - 1.181" [30.0mm] X .250" [6.35mm]	25606	
Blade: 1.181" [30.0mm] - 2.250" [57.15mm] x .200" [5.08mm]	25607	
Blade: 1.181" [30.0mm] - 2.250" [57.15mm] x .250" [6.35mm]	25608	
Blade: 2.250" [57.15mm] - 3.000" [76.2mm] x .200" [5.08mm]	25609	
Blade: 2.250" [57.15mm] - 3.000" [76.2mm] x .250" [6.35mm]	25610	
Optima® coating add-on for punch	—	

*Standard for Trumpf-style machine.

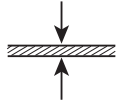


With Integral Collar

METRIC QUICK SET PARTING TOOL PUNCHES		
<i>Not Standard to North America</i>		
Description	Cat. No.	Price
Complete Assembly without Blade 0° (5mm)	25600	
Complete Assembly without Blade 90° (5mm)	25602	
Location Pin	970416	
Blade Locking Screw	25345	
56 x 5mm RT Blade with 0.5mm radius	25346	
30 x 5mm RT Blade with 0.5mm radius	25347	
76.2 x 5mm RT Blade with 0.5mm radius	25414	
0 - 30 x 5mm Blade (Special)	25447	
30 - 56 x 5mm Blade (Special)	25448	
56 - 76.2 x 5mm Blade (Special)	25449	
Optima® coating add-on for punch	—	



PARTING TOOLS

DESIGN INFORMATION	MAX. MATERIAL THICKNESS	INFORMATION REQUIRED
<ul style="list-style-type: none"> The parting tool punch holder is designed to accept interchangeable punch blades up to a maximum length of 3.000" [76.20mm], with widths of .200" [5.08mm] and .250" [6.35mm] or 5mm. The Parting Punch assembly is permanently set at 0° or 90° eliminating blade misalignment. The blades have a regrind life of .118" (3.00mm) and the assembly is limited to use in up to .118" (3.00mm) material. Blades are supplied with rooftop shear as standard to reduce punching force and noise. Special sizes and shapes available. Must fit within ranges as specified. Blades must be reground in vibration-free fixture with coolant. Blades supplied only with rooftop shear. Use with standard stripper. 	<p>.118" [3.00mm]</p> 	<ul style="list-style-type: none"> Conventional rectangle size or special size and shape Material thickness and type Machine model

DIE SHIMS



MULTI-TOOL DIE SHIMS			
# of Stations	Quantity	Cat. No.	Price
4-Station	Package includes: (2) 0.1mm, (1) 0.3mm (1) 0.5mm	25389	
5-Station		26003	
6-Station		25388	
10-Station		25995	

SIZE 1 DIE SHIMS			
Thickness	Quantity	Cat. No.	Price
0.1mm	1	25299	
0.3mm	1	25300	
0.5mm	1	25301	
Package includes: (2) 0.1mm, (1) 0.3mm and (1) 0.5mm		25181	

SIZE 1 DIE SHIMS			
Thickness	Quantity	Cat. No.	Price
1mm	Pack of 5	26753	
1mm	1	26756	

SIZE 2 DIE SHIMS			
Thickness	Quantity	Cat. No.	Price
0.1mm	1	25296	
0.3mm	1	25297	
0.5mm	1	25298	
Package includes: (2) 0.1mm, (1) 0.3mm and (1) 0.5mm		25182	

SIZE 2 DIE SHIMS			
Thickness	Quantity	Cat. No.	Price
1mm	Pack of 5	26752	
1mm	1	26755	

MULTI-TOOLS

Your punch press has a limited number of stations, but that doesn't mean you need to buy a new machine or stop production to change out tooling. Multi-tools increase the tool capacity of your punch press by adding 4, 5, 6 or 10 additional tools in a single station. That means you can expand the tool capacity of your machine and reduce downtime due to additional tooling changes.

These are available for Group I, Group H, and Trumatic 240R/260R machines.



MULTI-TOOL 5 STATION



MULTI-TOOLS

UPPER UNIT — ASSEMBLY		
Cat. No.	Price	
Upper Assembly	27022	
LOWER UNIT — ASSEMBLY		
Cat. No.	Price	
Lower Unit Assembly	27031	
STRIPPER		
Cat. No.	Price	
Stripper with 17.2mm dia. holes	27025	
Fitted Stripper (for thin material 18 ga. or less)	27029	

PUNCH		
Cat. No.	Price	
Round	25735	
Shape	25736	
DIE		
Cat. No.	Price	
Round	25737	
Shape	25738	
MT5 Die Shim Pack	26003	

OPTIMA® ADD ON FOR PUNCH		
Cat. No.	Price	
Round		N/C
Shape		

ADD ON FOR ROUNDS		
Small Diameter	Punch	Die
.031 - .061" [0.79 - 1.56mm]		
.062 - .092" [1.57 - 2.34mm]		N/C
Clearance ≤ .002" [≤ 0.05mm]		
Clearance .003 - .004" [.076 - 0.10mm]		

ADD ON FOR SHAPES		
Small Width	Punch	Die
.031 - .039" [0.79 - 1.00mm]		
.040 - .092" [1.01 - 2.34mm]		N/C
Clearance ≤ .002" [≤ 0.05mm]		
Clearance .003 - .004" [.076 - 0.10mm]		

ADD ON FOR RADIUS OR 45° CHAMFER 4 CORNERS		
Punch	Price	
.001 - .062" [0.02 - 1.57mm]		
.063 - .250" [1.58 - 6.35mm]		
Greater than .250" [6.35mm]		
Die	Price	
Any Size		

DESIGN INFO	MAX. 'A' DIMENSION
All punches and dies will be made for position 1, angle 90° unless stated otherwise.	.630" [16mm]
MAX. MATERIAL THICKNESS	
Mild Steel / Aluminum	.177" [4.5mm]
Stainless Steel	.118" [3mm]

STANDARD SHAPES



MULTI-TOOL 10 STATION

UPPER UNIT - ASSEMBLY		
Cat. No.	Price	
Upper Assembly	27003	
LOWER UNIT- ASSEMBLY		
Cat. No.	Price	
Lower Unit Assembly	27012	
STRIPPER		
Cat. No.	Price	
Stripper with 11.7mm dia. holes	27006	
Fitted Stripper (for thin material 18 ga. or less)	27010	

PUNCH		
Cat. No.	Price	
Round	25809	
Shape	25810	
DIE		
Cat. No.	Price	
Round	25996	
Shape	25997	
MT10 Die Shim Pack	25995	
Brush Insert (24mm)	25926	

OPTIMA® ADD ON FOR PUNCH		
Cat. No.	Price	
Round		N/C
Shape		

ADD ON FOR ROUNDS			
Small Diameter	Punch	Die	
.031 - .061" [0.79 - 1.56mm]			
.062 - .092" [1.57 - 2.34mm]			N/C
Clearance ≤ .002" [≤ 0.05mm]			
Clearance .003 - .004" [.076 - 0.10mm]			

ADD ON FOR SHAPES			
Small Width	Punch	Die	
.031 - .039" [0.79 - 1.00mm]			
.040 - .092" [1.01 - 2.34mm]			N/C
Clearance ≤ .002" [≤ 0.05mm]			
Clearance .003 - .004" [.076 - 0.10mm]			

ADD ON FOR RADIUS OR 45° CHAMFER 4 CORNERS			
Punch	Price		
.001 - .062" [0.02 - 1.57mm]			
.063 - .250" [1.58 - 6.35mm]			
Greater than .250" [6.35mm]			
Die	Price		
Any Size			



DESIGN INFO	MAX. 'A' DIMENSION
All punches and dies will be made for position 1, angle 90° unless stated otherwise.	.413" [10.5mm]
MAX. MATERIAL THICKNESS	
Mild Steel / Aluminum	.177" [4.5mm]
Stainless Steel	.118" [3mm]

STANDARD SHAPES

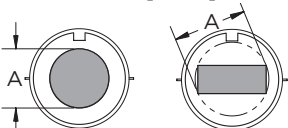



MULTI-TOOL 4 STATION

FOR TRUMATIC 240R / 260R
AND GROUP H MACHINES



MULTI-TOOLS

DESIGN INFO	MAX. 'A' DIMENSION
All punches and dies will be made for position 1, angle 90° unless stated otherwise.	.630" [16mm] 
MAX. MATERIAL THICKNESS	
Mild Steel / Aluminum	.125" [3.2mm]
Stainless Steel	.079" [2mm]
	

PUNCH & DIE ASSEMBLY COMPLETE*	Cat. No.	Price
Trumatic 240R/260R	25888	
Group H	25886	

*With Alignment Tool

UPPER UNIT — ASSEMBLY**	Cat. No.	Price
Trumatic 240R/260R	25888	
Group H	25884	
MT4 Alignment Tool	25893	

**Does not include inserts

LOWER UNIT — ASSEMBLY**	Cat. No.	Price
Trumatic 240R/260R and Group H	25866	

**Does not include inserts

PUNCH	Cat. No.	Price
Round	25151	
Shape	25152	
DIE	Cat. No.	Price
Round	25153	
Shape	25154	
MT4 Die Shim Pack	25389	

OPTIMA® ADD ON FOR PUNCH		
Round		N/C
Shape		

ADD ON FOR ROUNDS		
Small Diameter	Punch	Die
.031 - .061" [0.79 - 1.56mm]		
.062 - .092" [1.57 - 2.34mm]		N/C
Clearance ≤ .002" [≤ 0.05mm]		
Clearance .003 - .004" [.076 - 0.10mm]		

ADD ON FOR SHAPES		
Small Width	Punch	Die
.031 - .039" [0.79 - 1.00mm]		
.040 - .092" [1.01 - 2.34mm]		N/C
Clearance ≤ .002" [≤ 0.05mm]		
Clearance .003 - .004" [.076 - 0.10mm]		

ADD ON FOR RADIUS OR 45° CHAMFER 4 CORNERS	
Punch	Price
.001 - .062" [0.02 - 1.57mm]	
.063 - .250" [1.58 - 6.35mm]	
Greater than .250" [6.35mm]	
Die	Price
Any Size	

STANDARD SHAPES



MULTI-TOOL 6 STATION

FOR TRUMATIC 240R / 260R
AND GROUP H MACHINES

PUNCH & DIE ASSEMBLY COMPLETE*	Cat. No.	Price
Trumatic 240R / 260R	25889	
Group H	25887	

*With Alignment Tool

UPPER UNIT — ASSEMBLY**	Cat. No.	Price
Trumatic 240R / 260R	25888	
Group H	25885	
MT6 Alignment Tool	25894	

**Does not include inserts

LOWER UNIT — ASSEMBLY**	Cat. No.	Price
Trumatic 240R / 260R and Group H	25863	

**Does not include inserts

PUNCH	Cat. No.	Price
Round	25147	
Shape	25148	

DIE	Cat. No.	Price
Round	25149	
Shape	25150	
MT6 Die Shim Pack	25388	

OPTIMA® ADD ON FOR PUNCH		
Round		N/C
Shape		

ADD ON FOR ROUNDS		
Small Diameter	Punch	Die
.031 - .061" [0.79 - 1.56mm]		
.062 - .092" [1.57 - 2.34mm]		N/C
Clearance ≤ .002" [≤ 0.05mm]		
Clearance .003 - .004" [.076 - 0.10mm]		

ADD ON FOR SHAPES		
Small Width	Punch	Die
.031 - .039" [0.79 - 1.00mm]		
.040 - .092" [1.01 - 2.34mm]		N/C
Clearance ≤ .002" [≤ 0.05mm]		
Clearance .003 - .004" [.076 - 0.10mm]		

ADD ON FOR RADIUS OR 45° CHAMFER 4 CORNERS	
Punch	Price
.001 - .062" [0.02 - 1.57mm]	
.063 - .250" [1.58 - 6.35mm]	
Greater than .250" [6.35mm]	

Die	Price
Any Size	



DESIGN INFO	MAX. 'A' DIMENSION
All punches and dies will be made for position 1, angle 90° unless stated otherwise.	.413" [10.5mm]
MAX. MATERIAL THICKNESS	
Mild Steel / Aluminum	.125" [3.2mm]
Stainless Steel	.079" [2mm]

STANDARD SHAPES



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.



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


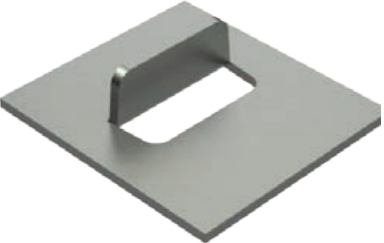

No matter how unique your requirement, Wilson Tool works with you to design and manufacture punch press tooling that meet the needs of your most demanding application. Our highly skilled engineers and toolmakers combine unmatched experience with specialized manufacturing systems to produce products that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



A-PLUS® SERIES



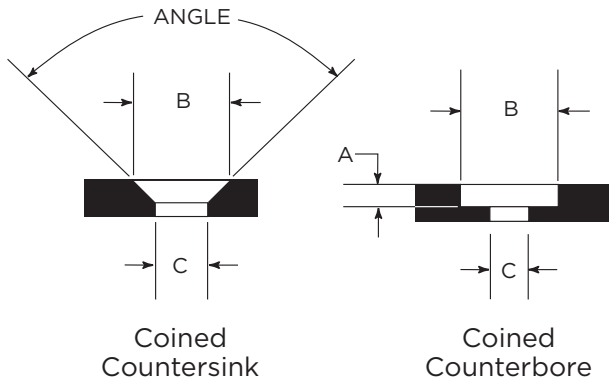
		
<p style="text-align: center;">CARD GUIDE</p>	<p style="text-align: center;">LANCE & FORM</p>	<p style="text-align: center;">LOUVER</p>
<ul style="list-style-type: none"> • Maximum length is 3.4" [86.4mm]. • Used for retaining printed circuit boards that require standard lead-in or special lead-in shapes. 	<ul style="list-style-type: none"> • Maximum length is 3.5" [88.9mm]. • Used in many applications such as airflow, decoration, location markers, shear tabs, wire harnesses and clip attachments. 	<ul style="list-style-type: none"> • Maximum length is 4" [101.6mm]. • Replaceable forming unit in the die. • Used in many applications such as airflow, electrical enclosures, HVAC and food service equipment.

<p>DESIGN INFORMATION</p>	<p>INFORMATION NEEDED</p>
<ul style="list-style-type: none"> • Extends the range of forming in the 'A' dimension, allowing for longer and larger forms. • Offers a full additional 1" [25.4mm] more in your forming application. • Available for most Trumpf-style Group I machines (specifications subject to change.) • Requires an A-Plus cartridge. 	<ul style="list-style-type: none"> • Machine and model number. • Material thickness and type. <div style="text-align: center;">  </div>

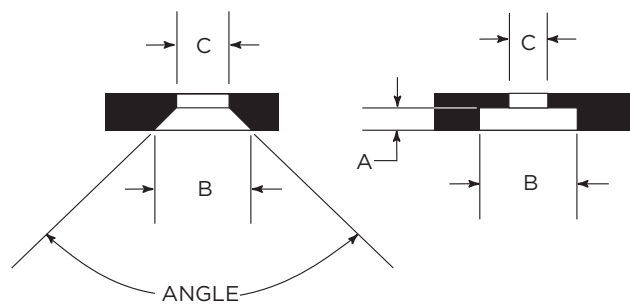
COINING TOOLS — FORM-DOWN / FORM-UP



FORM DOWN

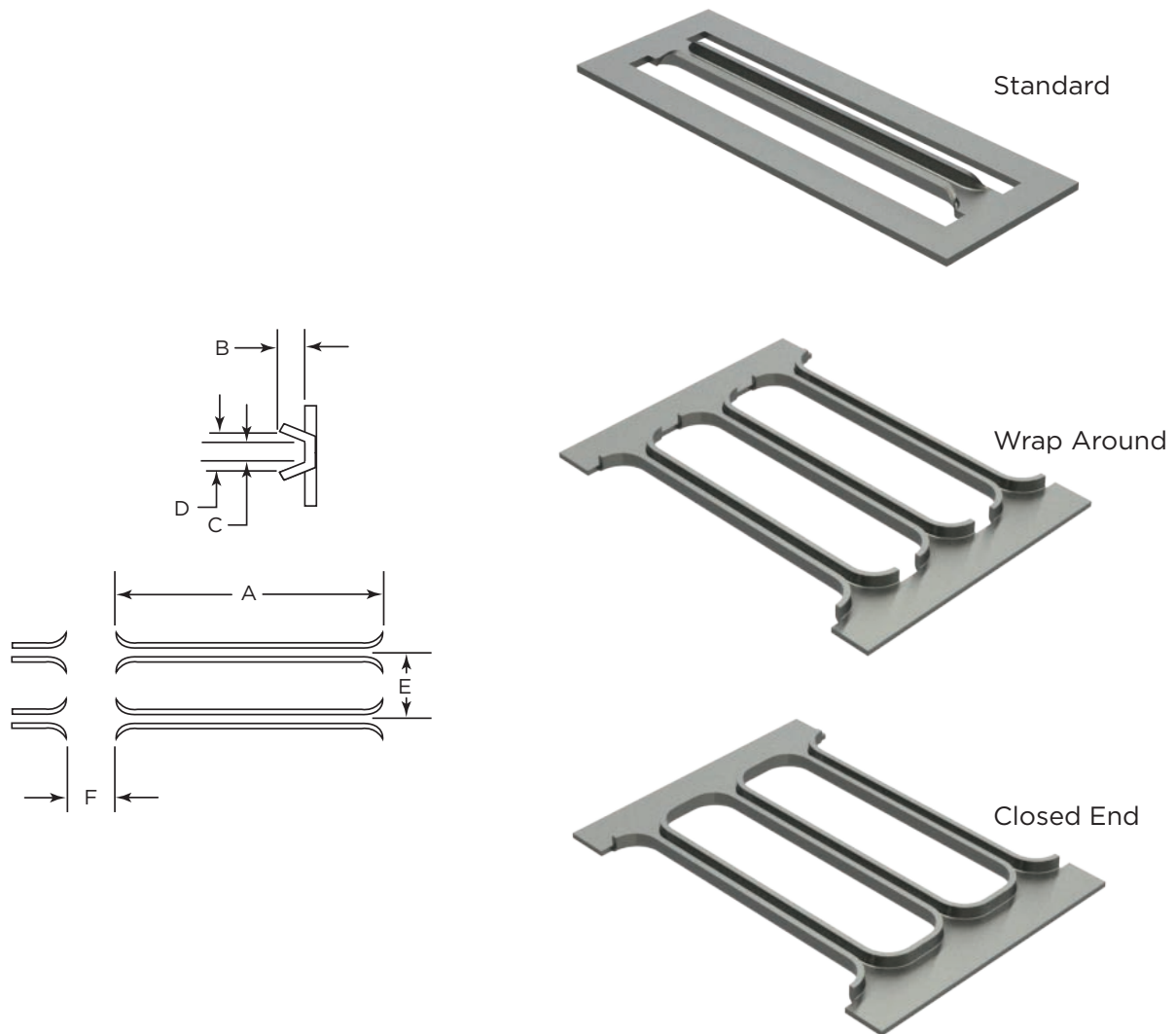


FORM UP



APPLICATION	ADVANTAGES	INFORMATION NEEDED
<ul style="list-style-type: none"> Coining tools are used for forming countersinks and counterbores for screws or to de-burr the edge of a hole. 	<ul style="list-style-type: none"> Coining on the punch press eliminates costs and time when compared to a secondary operation of machining countersinks. Interchangeable inserts for form down countersinks allow you to easily change coin sizes and reduce tooling costs. Form up coin dies are self-stripping. 	<ul style="list-style-type: none"> Machine model Material thickness and type Angle, coin diameter (B), thru-hole size with or without pilot (C). Form-up or form-down

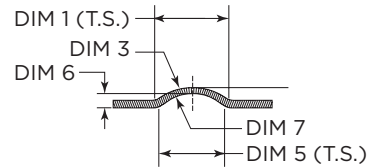
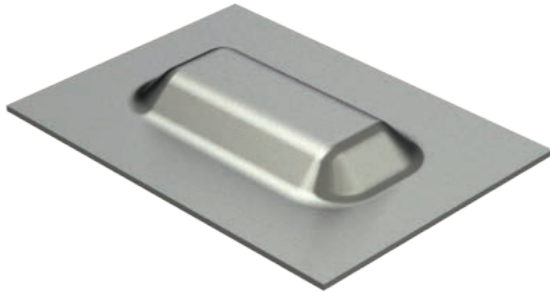
CARD GUIDE — FORM-UP



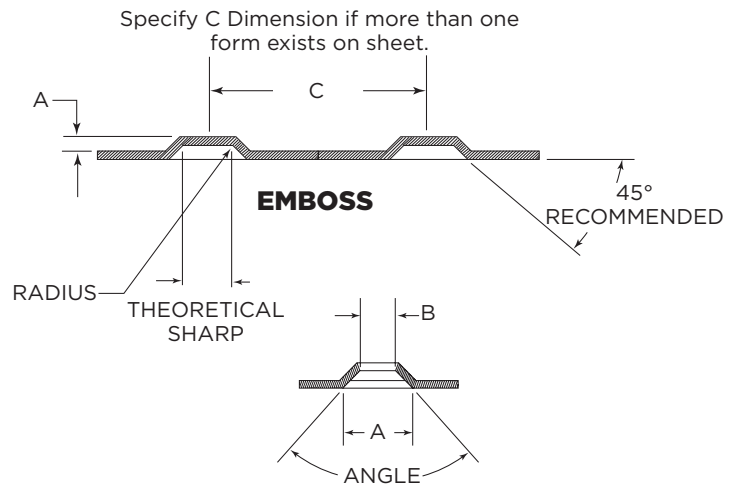
SPECIALS

APPLICATION	ADVANTAGES	INFORMATION NEEDED
<ul style="list-style-type: none"> A card guide is used for retaining printed circuit boards that require standard lead-in or special lead-in shapes. Wilson Tool will estimate the web of material to be formed on all card guides and the pre-punch shape and size on special lead-in card guides. 	<ul style="list-style-type: none"> The replaceable insert design allows for lower costs and conversion to different size card guides. Special lead-ins are available. Built in stripping for best results. Multiple coating options available to aid in stripping. 	<ul style="list-style-type: none"> Machine model Material thickness and type Dimensional drawing or electronic file (center-to-center location and narrowest pre-punch). Pre-punch shape rectangle, obround, or rectangle with radius corners. Maximum length 2.756" [70mm]. For longer lengths, see A-Plus® Series, page 25.

EMBOSS – FORM-DOWN / FORM-UP



DIMPLE



FORMED COUNTERSINK

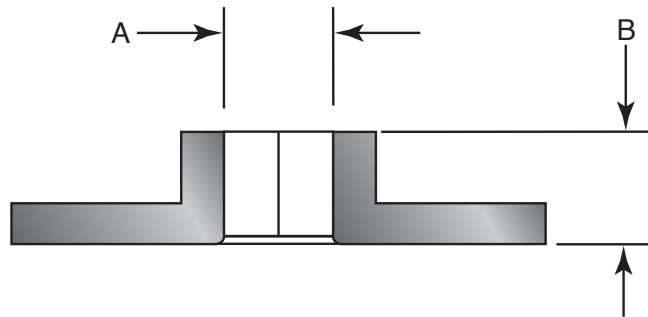
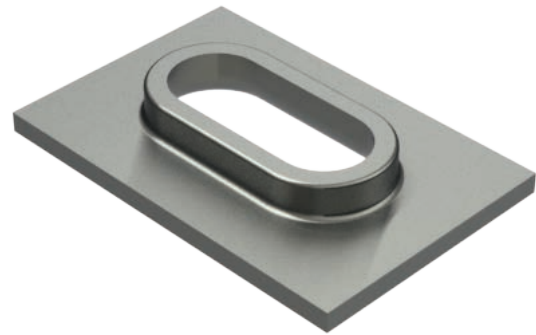
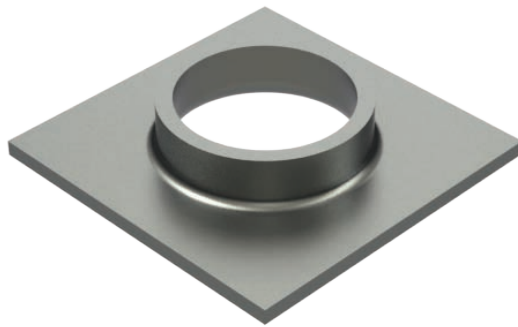


SPECIALS

APPLICATION	ADVANTAGES	INFORMATION NEEDED
<ul style="list-style-type: none"> • Embosses, dimples and forming tools are typically used to create stand-offs, spacers, countersinks, locks for nuts. • Logo embosses and other special shapes can be manufactured easily when an electronic file is provided. 	<ul style="list-style-type: none"> • All tools are made to achieve a consistent high quality form. 	<ul style="list-style-type: none"> • Material thickness and type • Machine model • Dimensional drawing or electronic file • Form-up or form-down



EXTRUSION



APPLICATION	ADVANTAGES	INFORMATION NEEDED
<ul style="list-style-type: none"> Extrusions are used in a broad spectrum of applications: <ul style="list-style-type: none"> Self-tapping screws Cooling tube holders Air flow applications Tread plates 	<ul style="list-style-type: none"> Many extrusions are insert style for fast and economical replacement. Form-down extrusions are designed to be self-stripping, providing consistent and trouble-free operation. Multiple coating options available to aid in stripping. 	<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. Maximum length 2.756" [70mm]

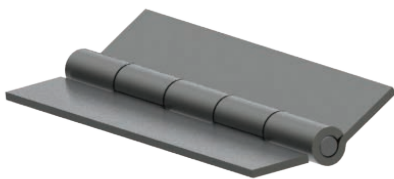
HINGE TOOL



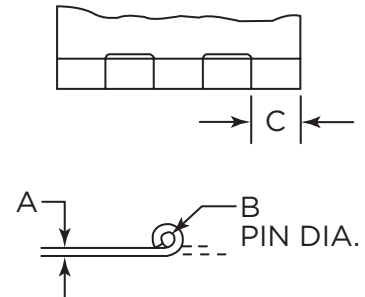
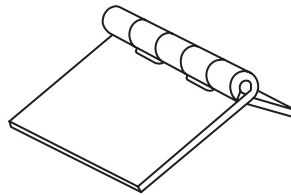
Standard Fully Curled Hinge



One-Hit Half Knuckle Hinge



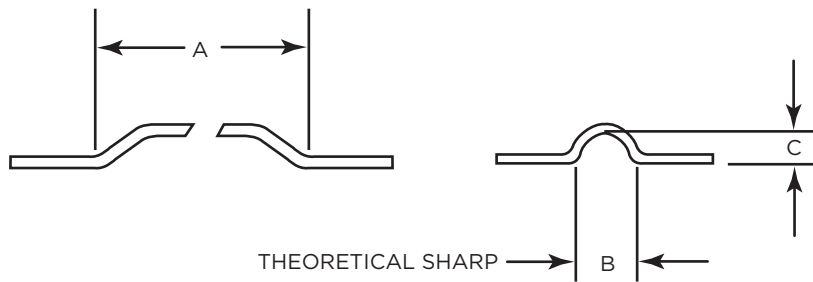
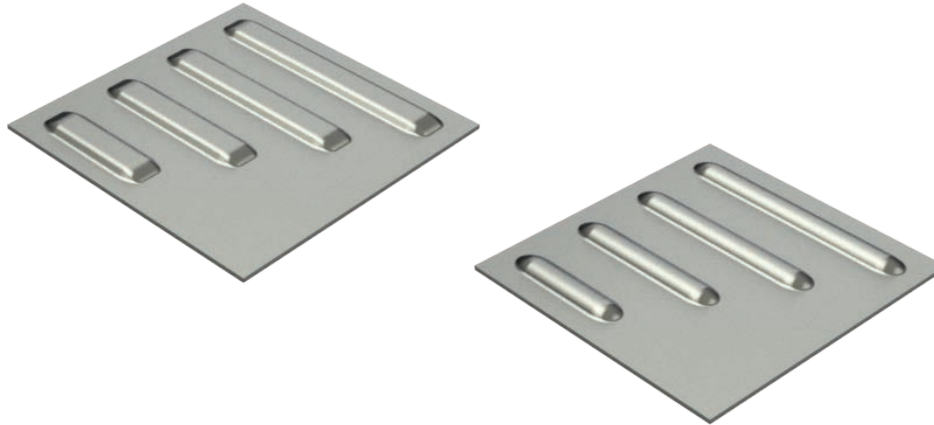
Offset Fully Curled Hinge



 **Watch the video on our YouTube Channel!**

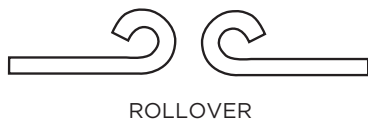
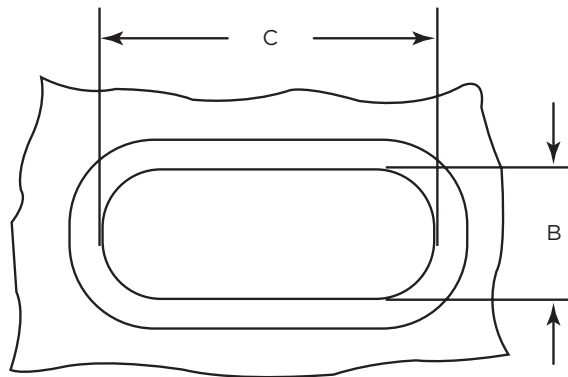
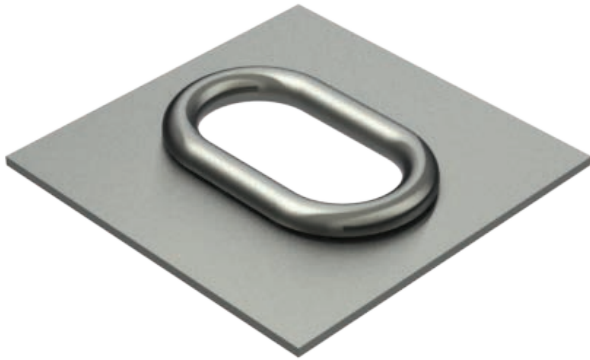
APPLICATION	ADVANTAGES	INFORMATION NEEDED
<ul style="list-style-type: none"> Integrating a formed hinge on the edge of the sheet in your machine eliminates the need for costly hardware and a secondary operation to weld or fasten them. 	<ul style="list-style-type: none"> Wilson Tool's one-hit hinge tool is achieved with 1 set of tools. Standard hinge is achieved with 2 sets of tools. Offset hinge requires 3 sets of tools. 	<ul style="list-style-type: none"> Machine model Material thickness (A) and type Dimensional drawing or electronic file – inside diameter or pin size (B) Knuckle size (C)

PROGRESSIVE RIB



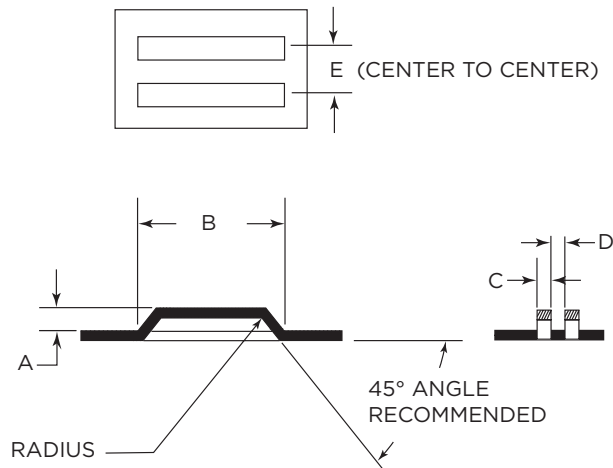
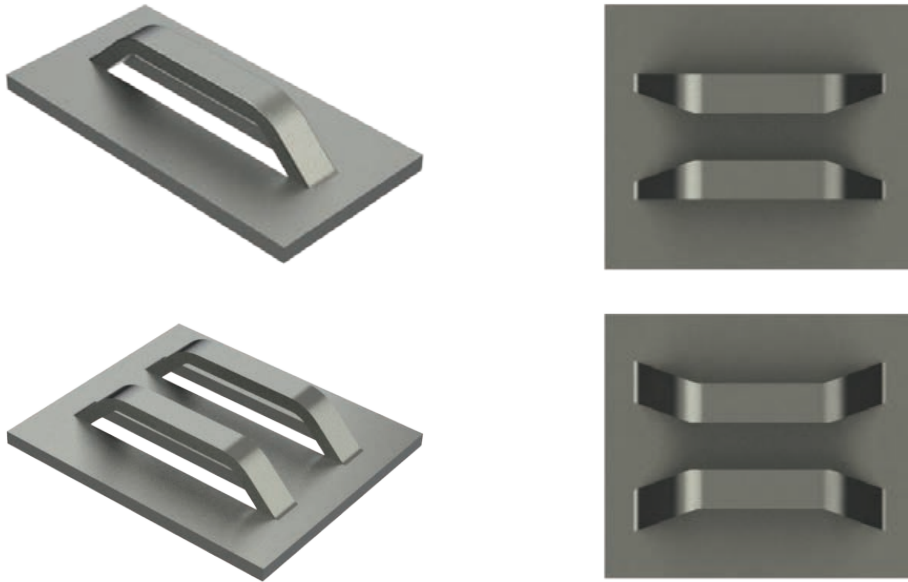
APPLICATION	INFORMATION NEEDED
<ul style="list-style-type: none"> • A progressive rib produces quality stiffening ribs, programmable to any length. • Rounded or flat top ribs are available. For best results, inside radius should be equal to or greater than the height. • Run in nibbling mode recommended (incremental moves should be equal to the material thickness or less). 	<ul style="list-style-type: none"> • Machine model • Material thickness and type • Dimensional drawing or electronic file • Specify center-to-center if more than one form exists on the sheet

ROLLOVER TOOL



APPLICATION	ADVANTAGES	INFORMATION NEEDED
<ul style="list-style-type: none"> Rollover and hemming tools can be used in many applications such as hand holds, wire feeds and grommets. Rollover is achieved in three operations: <ol style="list-style-type: none"> Pre-punch (developed by Wilson Tool free of charge) Form-up extrusion Rollover Hemming is achieved in three operations: <ol style="list-style-type: none"> Pre-punch (developed by Wilson Tool free of charge) Form-up extrusion Flare and Flatten 	<ul style="list-style-type: none"> Reduces costly secondary operations and handling. Designed and manufactured to produce consistent results. Multiple coating options available to extend tool life. 	<ul style="list-style-type: none"> Machine model Material thickness and type Diameter or length and width of opening (C, B) Tolerance of opening What type of application (hand hold, wire feed, etc.)

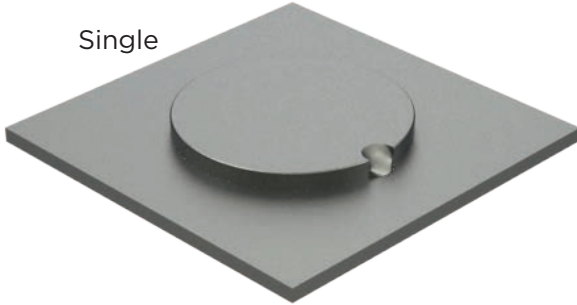
BRIDGE LANCE AND FORM



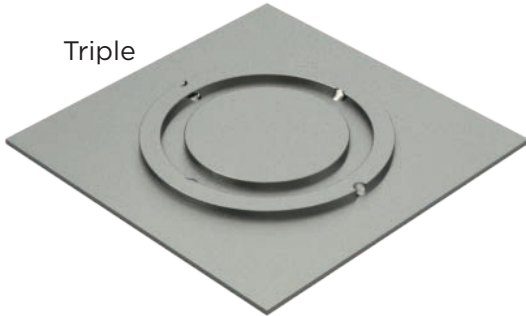
APPLICATION	ADVANTAGES	INFORMATION NEEDED
<ul style="list-style-type: none"> • Bridge style lance and forms can be used for the following: <ul style="list-style-type: none"> - Shear stops - Locators - Card guides - Dividers - Ventilation - Wire tie downs 	<ul style="list-style-type: none"> • This design creates a positive form ensuring a high quality, consistent part. • Special lead-ins available. • Form-down bridges are made self-stripping. • Multiple coating options available to aid in stripping. 	<ul style="list-style-type: none"> • Machine model • Material thickness and type • Dimensional drawing or electronic file for relief • Top, side and end views • Form-up or form-down

EKO – ELECTRICAL KNOCKOUT

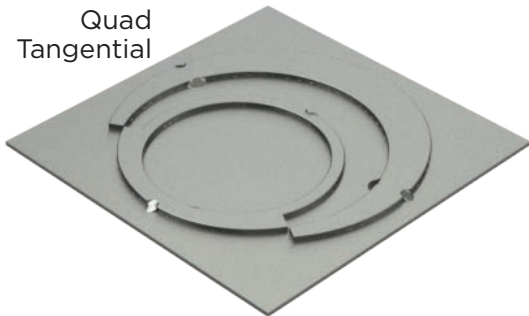
Single



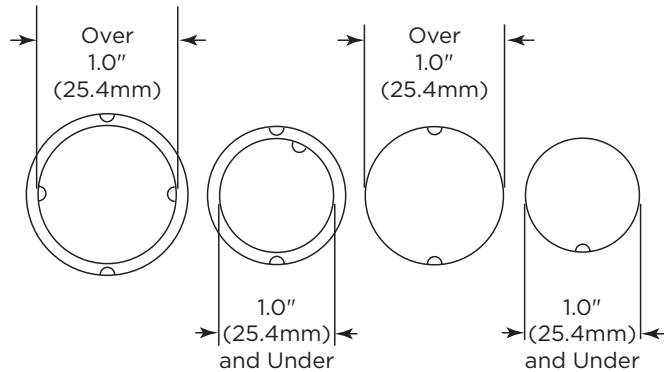
Triple



Quad
Tangential

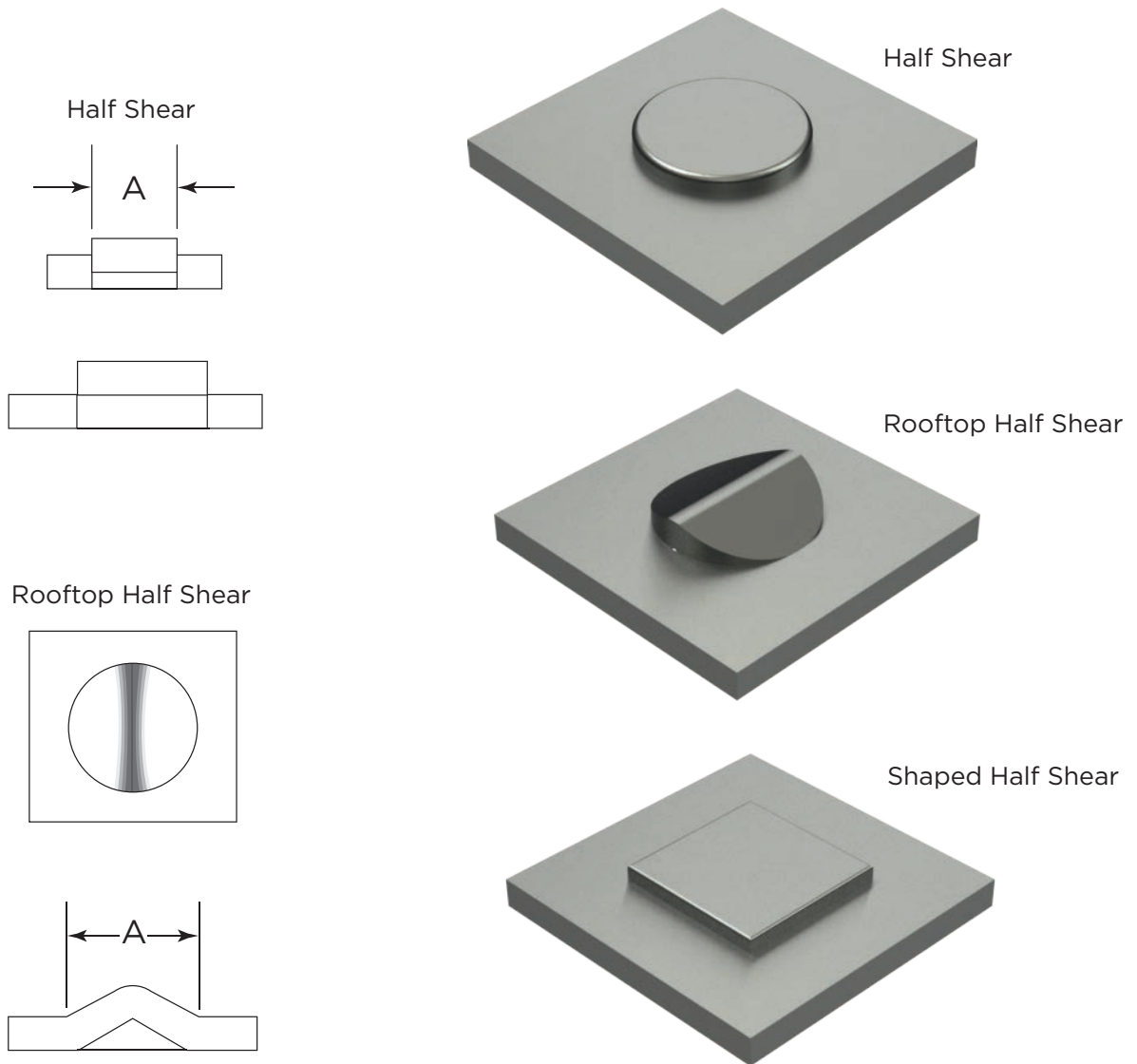


Standard Wilson Tool Tab Location



APPLICATION	ADVANTAGES	INFORMATION NEEDED
<ul style="list-style-type: none"> Electrical knockouts (EKOs) are used to create connection points for cable pathways. Available for: <ul style="list-style-type: none"> - Single - Double (concentric or tangential) - Triple (concentric or tangential) - Quad (concentric or tangential) - Standard and special shapes Single or multiple tools can be used to produce the desired number of EKOs for your requirements. 	<ul style="list-style-type: none"> Wilson Tool's EKO design has full stripping in both upper and lower units, which produce good quality, reliable knockouts every time. Multiple coating options available for extending tool life. 	<ul style="list-style-type: none"> Machine model Material thickness, type or range Actual diameter Specify center-to-center if more than one knockout exists on the sheet Form-up or form-down

HALF SHEAR / ROOFTOP HALF SHEAR



SPECIALS

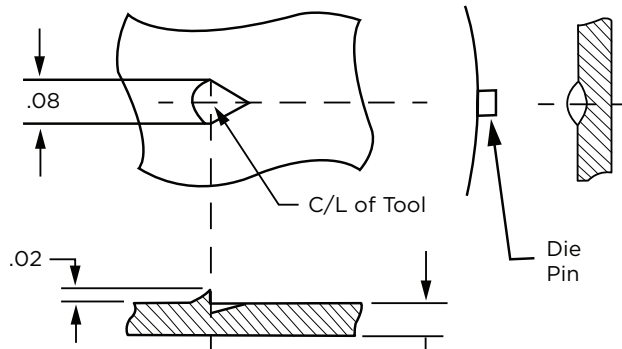
APPLICATION	ADVANTAGES	INFORMATION NEEDED
<ul style="list-style-type: none"> The half shear is an easy-to-use tool that allows you to put in shear buttons and spot welding locators to the accuracy of your punch press. Round half shears make excellent locators for angular shearing. Rooftop half shears have approximately a 3 gauge material thickness range. 	<ul style="list-style-type: none"> Rooftop half shears give you greater height protrusion compared to a standard half-shear when using thinner material. Half shears can be used on a .125" (3.17mm) range of material if requested. 	<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 exists on the sheet. Form-up or form-down

SCRATCH TOOL

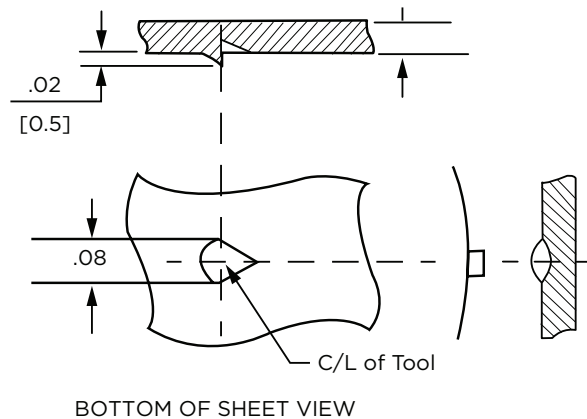
Top of Sheet



TOP OF SHEET VIEW



Bottom of Sheet



APPLICATION

- The scratch form can be used for spot welding locators, locators for angular shearing and shear stops.
- Height of the stop is .020" - .030" [0.5mm - 0.8mm].
- Tool is designed with relief for .500" [12.7mm] centers.

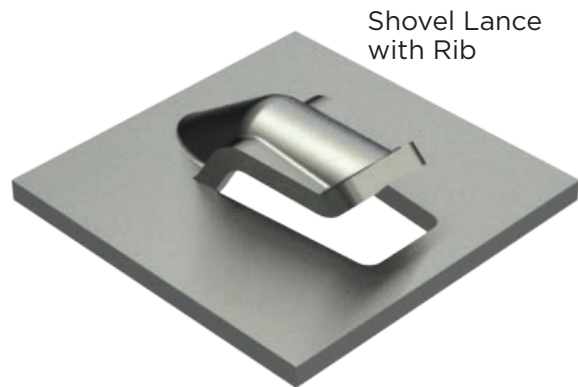
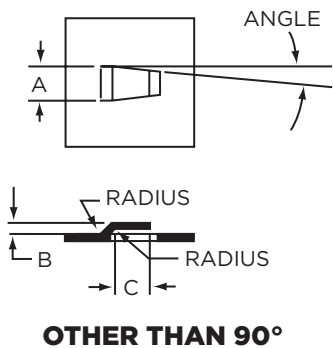
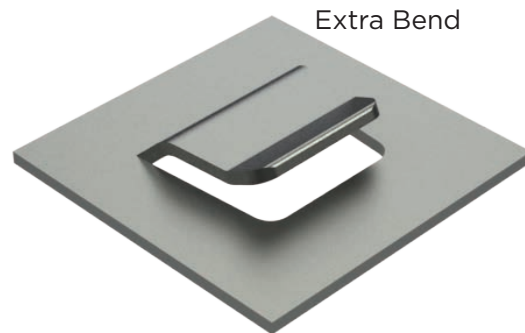
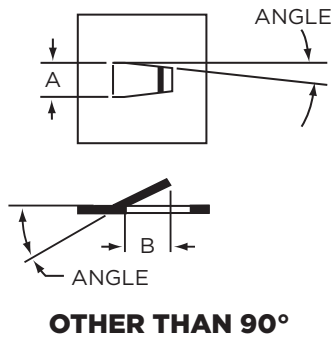
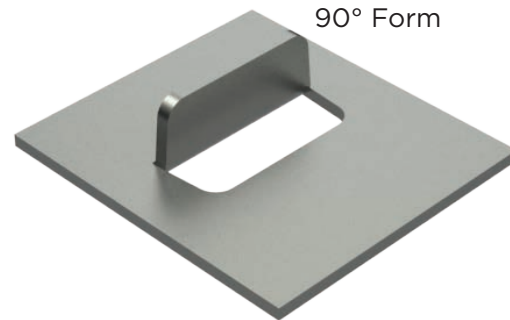
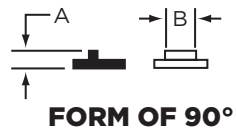
ADVANTAGES

- Punches a range of material from .036" to .125" [.91mm to 3.18mm]

INFORMATION NEEDED

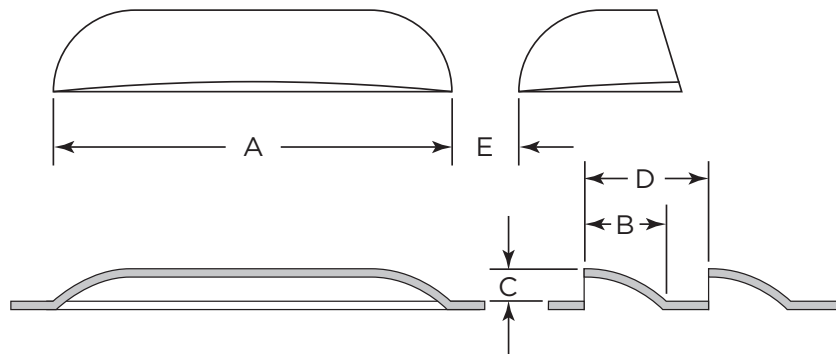
- Machine model
- Material thickness and type
- Specify top or bottom of the sheet scratch

LANCE AND FORMS



APPLICATION	ADVANTAGES	INFORMATION NEEDED
<ul style="list-style-type: none"> Lance and forms are used for a variety of applications, including: <ul style="list-style-type: none"> - Air flow - Decoration - Location markers - Shear tabs - Wire harnesses - Clip attachments 	<ul style="list-style-type: none"> High-quality lance and forms are assured with Wilson Tool's positive form and self-stripping design. Multiple coating options available to extend tool life. 	<ul style="list-style-type: none"> Machine model Material thickness and type Dimensional drawing or electronic file and pattern if relief is required. A taper of 5° per side should be added (if possible) to aid in stripping large lance and forms. Form-up or Form-down

LOUVERS

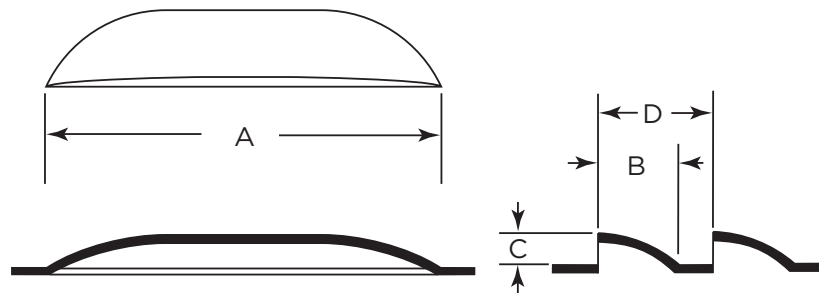


SPECIALS

APPLICATION	ADVANTAGES	INFORMATION NEEDED
<ul style="list-style-type: none"> Used in a variety of industry applications that require airflow; electrical enclosures, HVAC, and food service equipment. 	<ul style="list-style-type: none"> Lower costs with replaceable inserts that can be converted to different size louvers. Multiple coating options available to extend tool life. 	<ul style="list-style-type: none"> Machine model Material thickness and type Dimensional drawing or electronic file



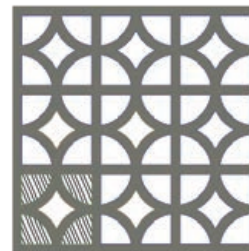
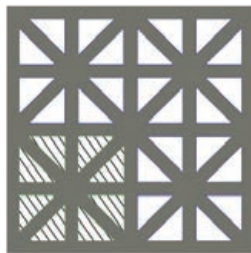
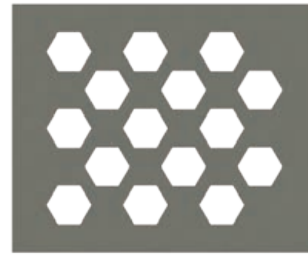
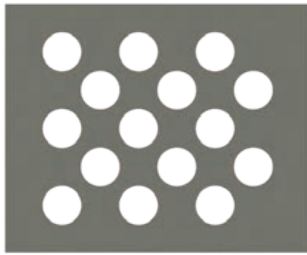
PROGRESSIVE LOUVERS



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

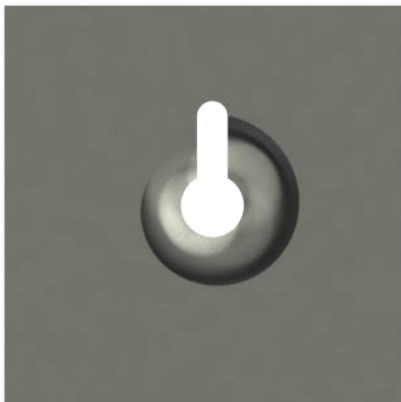
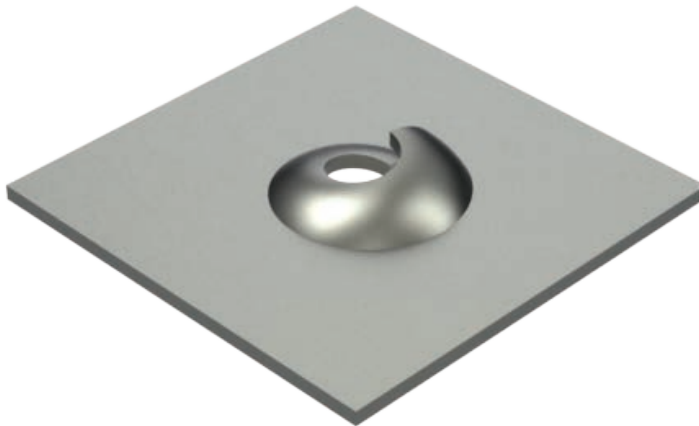
APPLICATION	ADVANTAGES	INFORMATION NEEDED
<ul style="list-style-type: none"> Used in a variety of industry applications that require airflow; Electrical enclosures, HVAC, and food service equipment. Run in nibbling mode (recommended incremental moves equal to the material thickness or less). 	<ul style="list-style-type: none"> Produces various length louvers to give flexibility using one tool. Lower costs with replaceable inserts that can be converted to different size louvers. Multiple coating options available to extend tool life. 	<ul style="list-style-type: none"> Machine model Material thickness and type B, C and D dimensions.

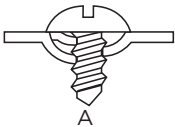
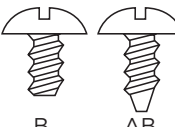

CLUSTER TOOL



APPLICATION	ADVANTAGES	INFORMATION NEEDED
<ul style="list-style-type: none"> The cluster tool is the most cost-effective method to manufacture perforated patterns and is commonly used for air ventilation, drains and filters. Cluster piercing is ideal for applications where tight tolerance is required on the hole pattern. 	<ul style="list-style-type: none"> Creates maximum number of holes with minimal hits. Saves on machine punching time and costly tool maintenance. Available in any hole size, shape or pattern. Holds tight tolerance from hole to hole. Punch available as solid or replaceable insert style. Wilson Tool's back bending feature on dies can help reduce sheet distortion. Multiple coating options available to extend tool life. 	<ul style="list-style-type: none"> Machine model Material type, thickness or range Number of holes in clusters Straight or staggered pattern Center-to-center dimensions Replaceable or solid design

THREAD FORM



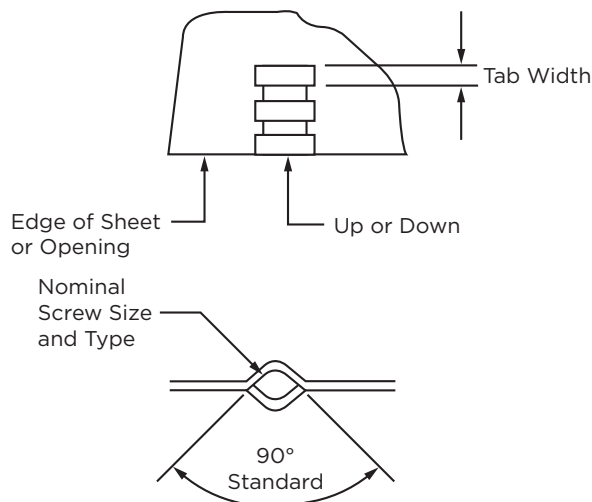
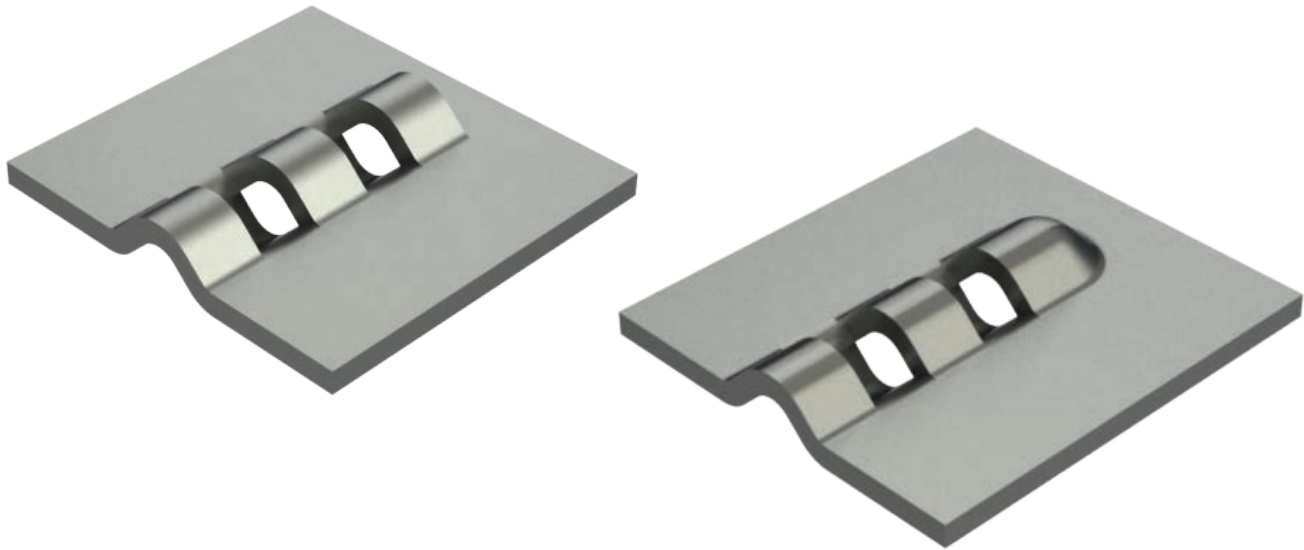
THREAD FORM	
Screw Type	Thread Size
 A	6 - 18
	8 - 15
	10 - 12
	12 - 11
	14 - 10
	20 - 9
 B	6 - 20
	8 - 18
	10 - 16
	12 - 14
	1/4 - 14
	5/16 - 12
 C (Machine Screws)	6 - 32
	8 - 32
	10 - 24
	10 - 32
	1/4 - 20
	5/16 - 18

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

SPECIALS

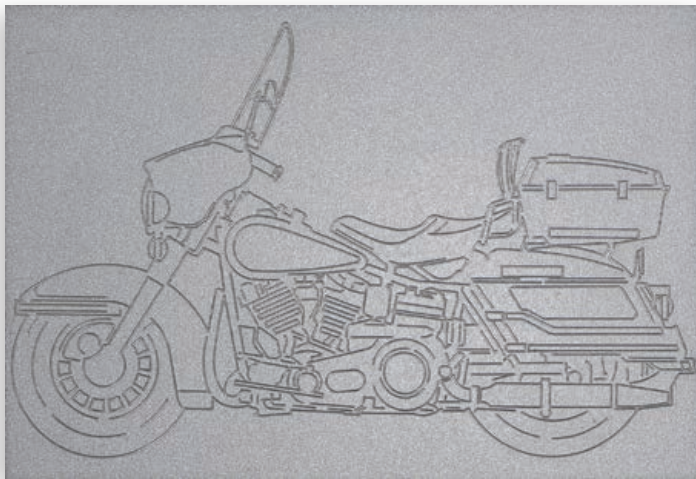
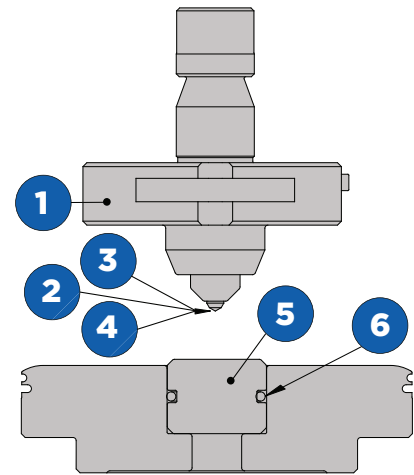
APPLICATION	ADVANTAGES	INFORMATION NEEDED
<ul style="list-style-type: none"> A thread form is a great solution for eliminating secondary operations and supplemental hardware where a threaded hole is required. 	<ul style="list-style-type: none"> Reduces costly hardware and assembly time. Coining is included in the design of the tool when material exceeds the recommended thickness up to 2 times. Pre-punch information is provided. Multiple coating options available to extend tool life. 	<ul style="list-style-type: none"> Machine model Material thickness and type Thread size and type

THREAD LOOP



APPLICATION	ADVANTAGES	INFORMATION NEEDED
<ul style="list-style-type: none"> A thread loop is a great solution for eliminating secondary operations and supplemental hardware when a threaded hole is required. 	<ul style="list-style-type: none"> The Wilson Tool design gives a positive form, which ensures a high quality part. Reduces costly hardware and assembly time. Multiple coating options are available to extend tool life. 	<ul style="list-style-type: none"> Machine model Material thickness and type Number of thread loop tabs Width of tab Direction of first tab Diameter of opening or screw size and type Dimensional drawing or electronic file

WILSON MULTI-SCRIBE®



SIZE 2 MULTI-SCRIBE		
	Description	Cat No.
1	Trumpf Multi-Scribe Kit (includes all inserts)	26210
2	90° Carbide Insert	13563
3	120° Diamond Insert	13564
4	150° Diamond Insert	13565
5	Die Insert with O-Ring	12689
6	O-Ring (1" P.D X 3/32)	2282

SPECIALS

APPLICATION	ADVANTAGES	INFORMATION NEEDED
<ul style="list-style-type: none"> Wilson Multi-Scribe® is ideal for both sheet scribing and dot-matrix marking on a wide range of materials. Unique designs and logos can be achieved just by programming. Sold as a kit which includes: <ul style="list-style-type: none"> - Punch & die assembly - Red medium spring, yellow light spring - Green heavy spring - 120° and 150° diamond insert - 90° carbide insert - 3mm hex wrench 	<ul style="list-style-type: none"> Can achieve 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. Multi-Scribe tool comes assembled with 120° diamond and red medium spring. Works on a wide range of materials. 	<ul style="list-style-type: none"> Machine model Material thickness and type

5 STATION AND 10 STATION ID-STAMP



SPECIALS

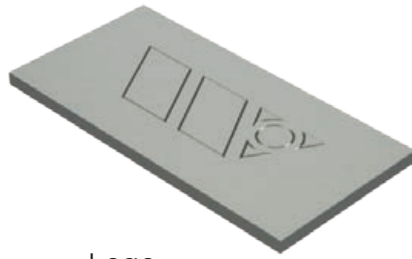
APPLICATION	5 STATION ADVANTAGES	10 STATION ADVANTAGES	INFORMATION NEEDED
<ul style="list-style-type: none"> An ID-Stamp tool is a perfect solution for permanently marking and displaying company names, serial numbers, or part numbers. You can stamp different characters, including numbers, letters and various symbols. 	<ul style="list-style-type: none"> Uses a set of 5 special stamping punches when as a group or combined create the letters A-Z, numbers 0-9 and symbols %, \$, /, \, <, >, =, +. The standard font size is 10mm. Designed for use in materials up to 8mm thick. 	<ul style="list-style-type: none"> Eliminates secondary stamping operations and ensures consistent marking. Reduces the number of tools needed to mark parts. Designed to take the standard .125" [3.18mm] letter stamp character. 	<ul style="list-style-type: none"> Machine model Material thickness and type

LETTERSTAMP

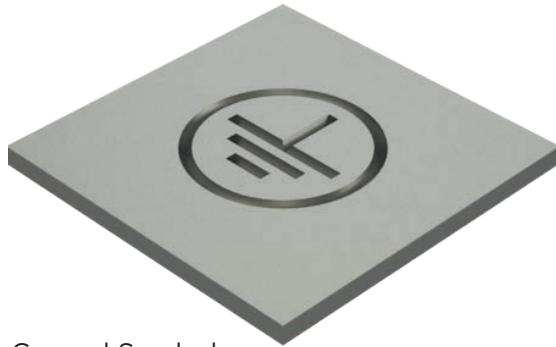


APPLICATION	ADVANTAGES	INFORMATION NEEDED
<ul style="list-style-type: none"> • A letter stamp is a perfect solution for permanently marking and displaying company names, serial numbers, or part numbers. • Replaceable punch tip design allows quick and easy change out, reducing the number of tools needed to mark parts. 	<ul style="list-style-type: none"> • Available in single and double row. • Eliminates secondary stamping operations. • Interchangeable punch tip design provides cost savings and flexibility to easily change character size by purchasing only a punch tip and characters. 	<ul style="list-style-type: none"> • Machine model • Material thickness and type • Size character, number of rows, number of characters per row • Form-up or form-down

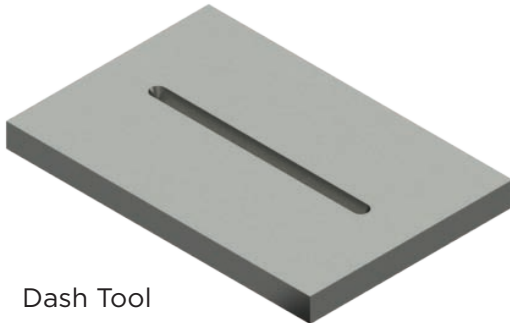
STAMPING



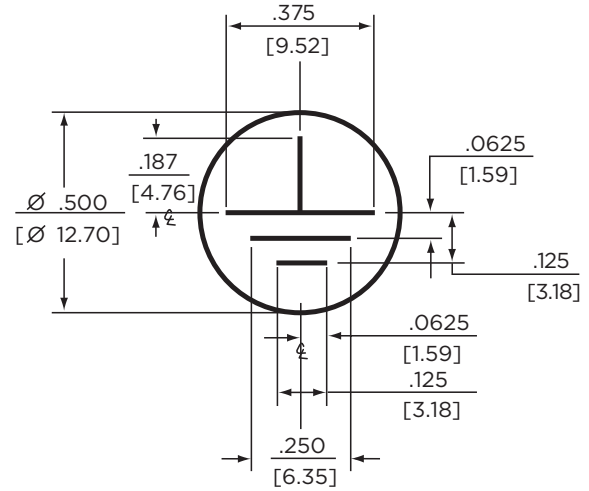
Logo



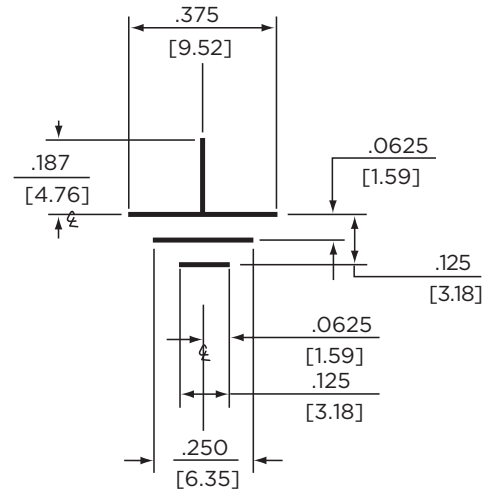
Ground Symbol



Dash Tool



GROUND SYMBOL
STOCK DIMENSIONS



APPLICATION	ADVANTAGES	INFORMATION NEEDED
<ul style="list-style-type: none"> Stamping the top or bottom of the sheet is the perfect solution for permanently displaying company names, serial numbers, symbols, and product or company logos. Ground symbols, widely used in the electrical industry are available in stock sizes, form-down or form-up. Dash tools can be used to "V" notch the sheet to aid in bending, create numbers and letters, and location marks on a sheet. Dash tools are available in form-down or form-up, in various lengths and can be run progressively. 	<ul style="list-style-type: none"> All form-up tools are designed self-stripping to prevent sheet marking and tool wear. Logo stamps and other special stamps can be manufactured easily when an electronic file is provided. Dash tools can be used to create numbers or letters. 	<ul style="list-style-type: none"> Machine model Material thickness and type Length of dash Size of ground symbol (Stock or non-stock) Electronic file for logos Form-up or form-down

TAPPING TOOL



Extruded Hole Shown

SPECIALS

APPLICATION	ADVANTAGES	INFORMATION NEEDED
<p>The tapping tool allows you to create high precision threads at any programmed location on the sheet.</p> <ul style="list-style-type: none"> • Able to tap in flat or extruded holes. • Quick change tapping modules. • Scratch-free machining 	<ul style="list-style-type: none"> • Fast! Tap a hole or an extruded hole with every machine stroke, up to 20 holes per minute. • Works on a wide range of material. • Stock size pitch inserts and taps are available for fast delivery. 	<ul style="list-style-type: none"> • Machine model • Material thickness and type • Pitch and tap size

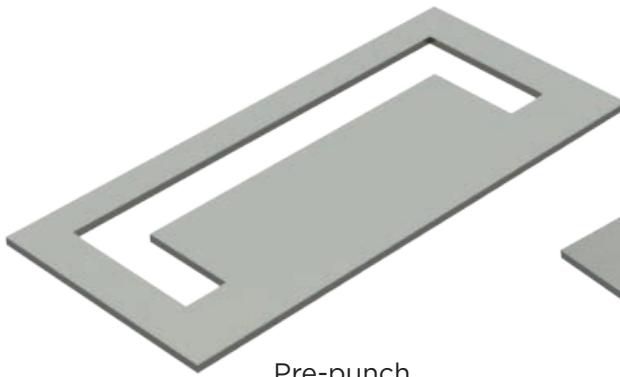
ROLLING DE-BURR



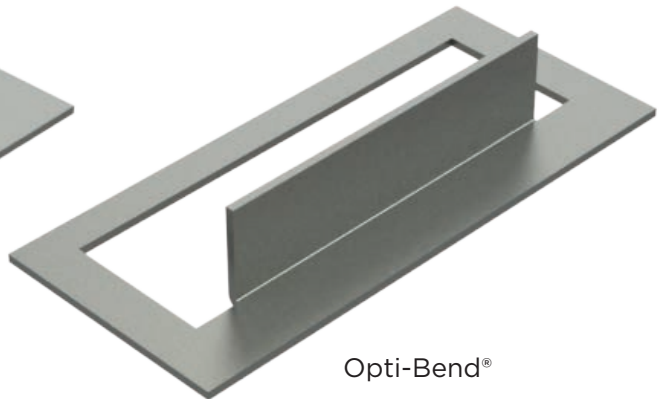
 **Watch the video on our YouTube Channel!**

APPLICATION	ADVANTAGES	INFORMATION NEEDED
The rolling de-burring tool eliminates the secondary operation of removing burrs from your parts.	<ul style="list-style-type: none"> • Quickly and efficiently de-burrs your parts while on the machine. • Eliminates costly secondary operations. • Coins a small chamfer on the cut edge top and bottom of the sheet. • Can be used to de-burr nested parts. • Adjust ball pressure without disassembling the tool. 	<ul style="list-style-type: none"> • Machine model • Material thickness and type

OPTI-BEND®



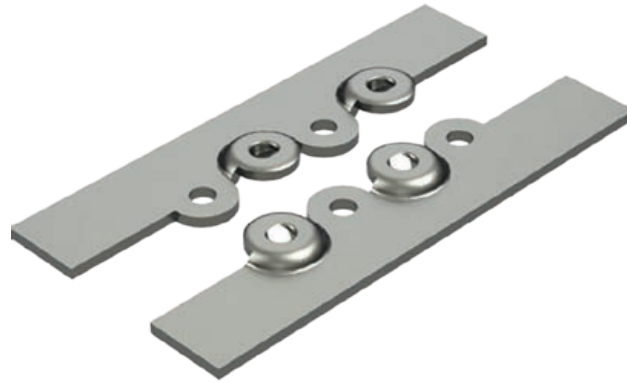
Pre-punch



Opti-Bend®

APPLICATION	ADVANTAGES	INFORMATION NEEDED
<ul style="list-style-type: none"> • Opti-Bend® allows you to achieve exceptionally high bends (up to 90°) in your punch press, eliminating costly time-consuming secondary operations in a press brake. • It is possible to achieve 3° over bend. 	<ul style="list-style-type: none"> • Performs up to 90° bends on a punch press with neutral pull on the sheet (won't pull out of clamps). • Special rotating cam design minimizes sheet marking on soft or high polished materials. • Available in single hit or progressive styles. • Can be run on a small range of material. • Allows multiple bending in a machine. 	<ul style="list-style-type: none"> • Machine model • Material thickness and type • Dimensional drawing or electronic file

ZIP-TECH

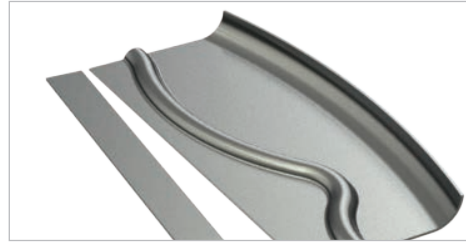


APPLICATION	ADVANTAGES	INFORMATION NEEDED
<ul style="list-style-type: none"> • Zip-Tech lance is achieved in three operations: <ol style="list-style-type: none"> 1. Pre-punch — Round hole 2. Pre-punch — T-shape hole 3. Zip-Tech Lance and Form 	<ul style="list-style-type: none"> • Fabricates snaps to 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. 	<ul style="list-style-type: none"> • Machine model • Material thickness and type

WILSON WHEEL® FAMILY



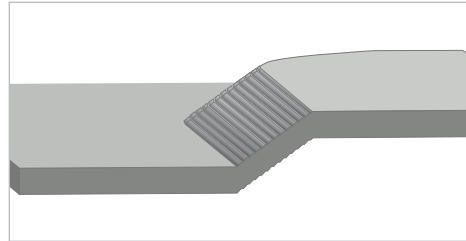
Rolling Shear



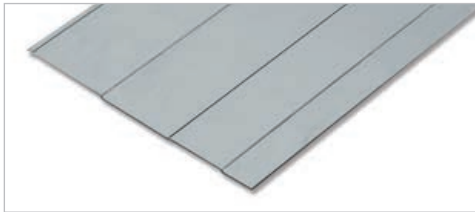
Rolling Flare



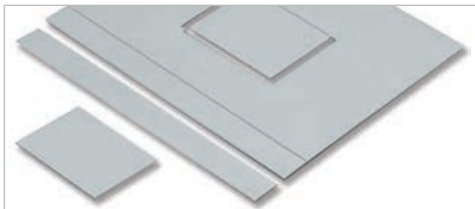
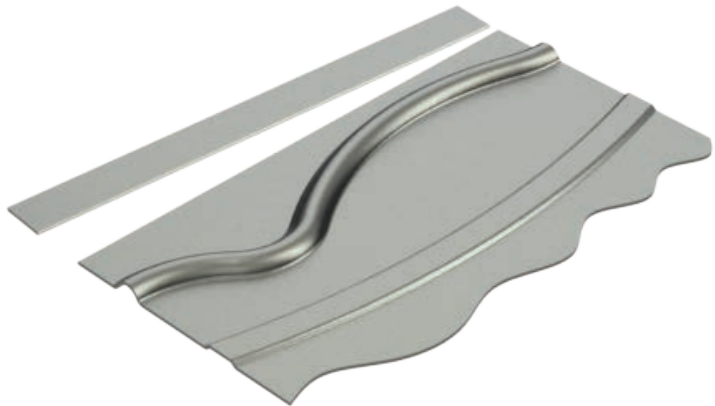
Rolling Rib



Rolling Forge



Rolling Offset



Rolling Pincher

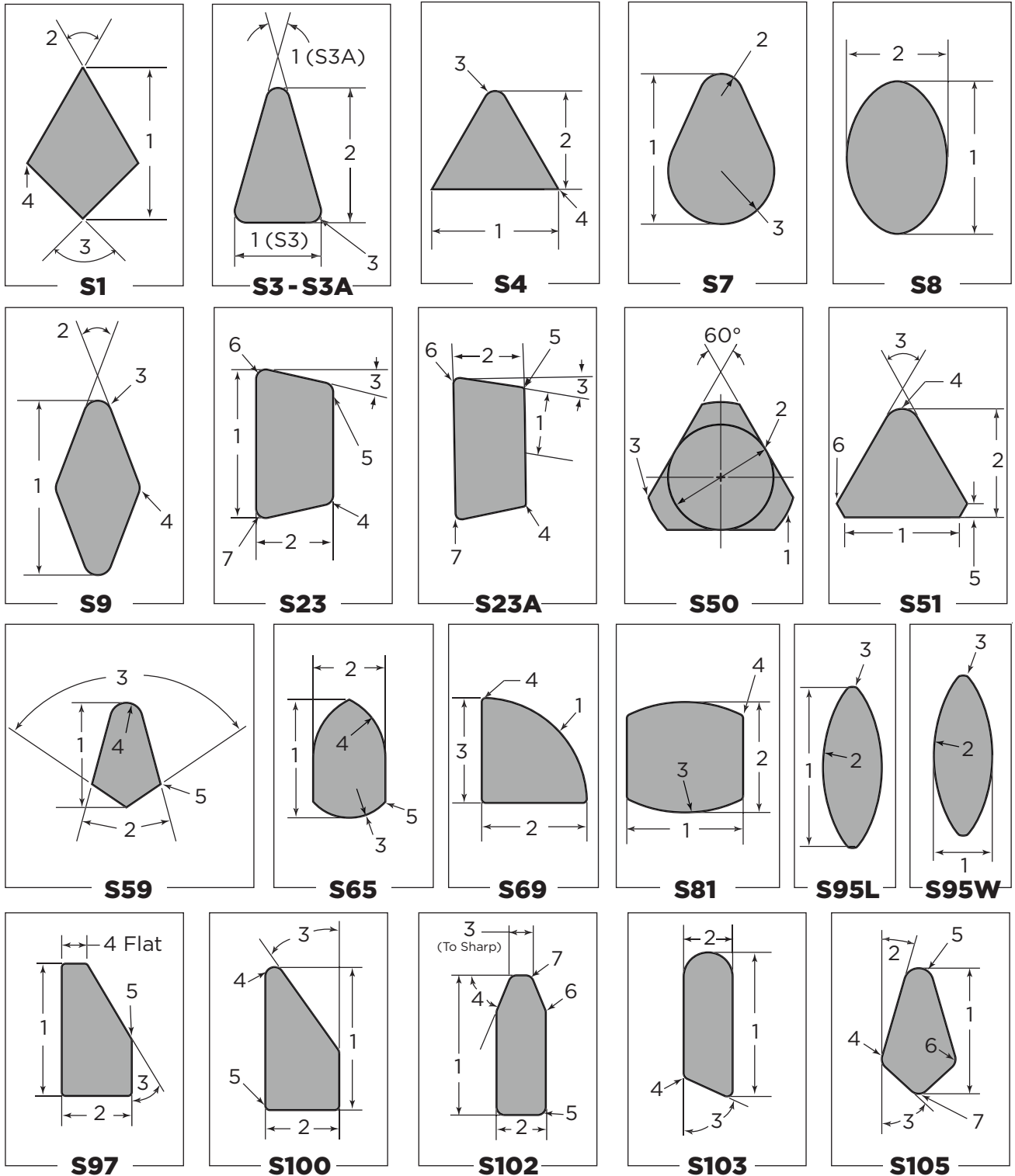
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APPLICATION	ADVANTAGES	INFORMATION NEEDED
<ul style="list-style-type: none"> The Wilson Wheel® family of products offers you flexible, high speed production of slits, ribs and offsets on a wide range of materials with virtually no burrs or nibble marks. Create curves, arcs and circles 	<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



SPECIAL SHAPES

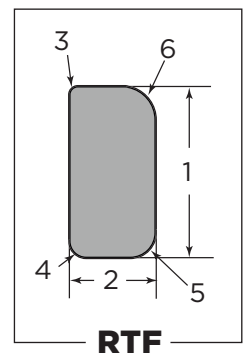
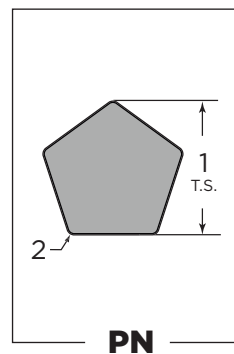
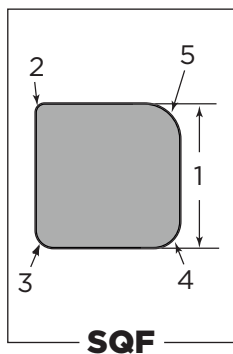
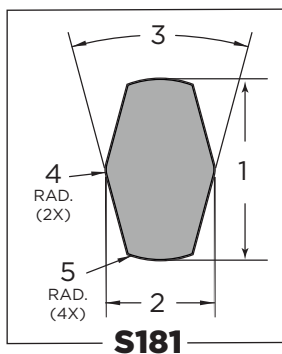
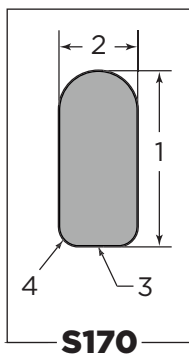
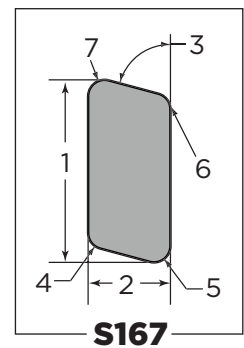
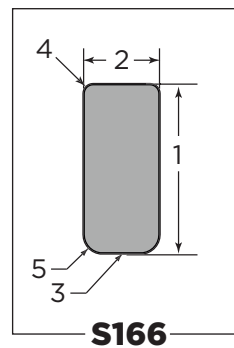
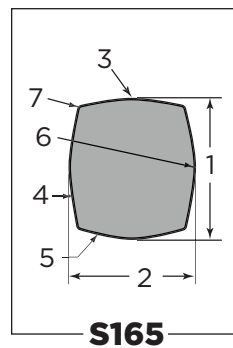
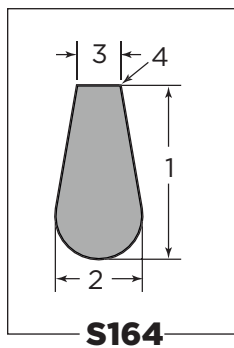
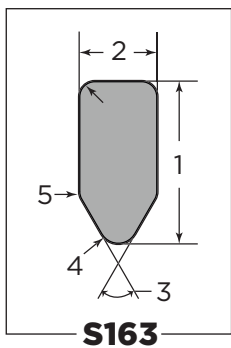
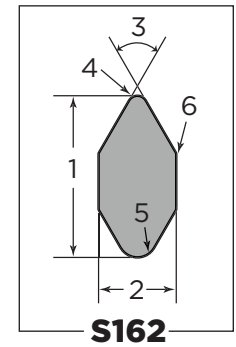
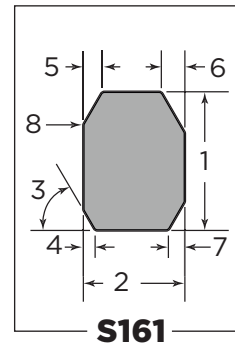
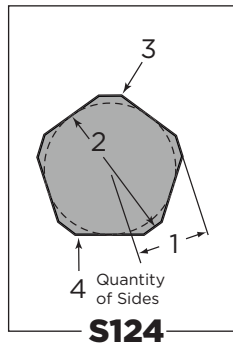
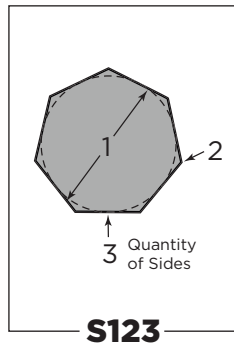
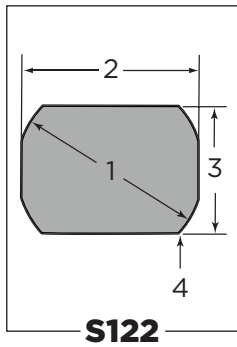
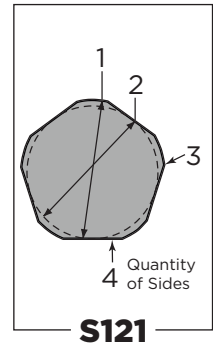
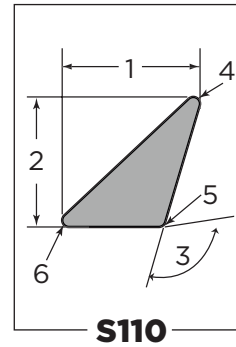
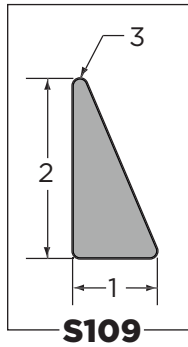
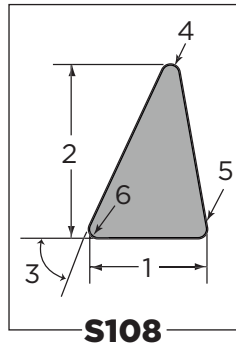
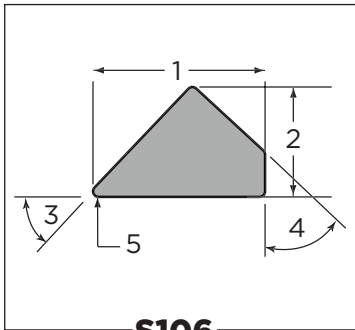
GROUP 'A'



NOTE: Special considerations may alter price and lead time.

SPECIAL SHAPES

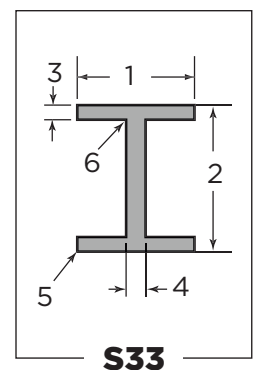
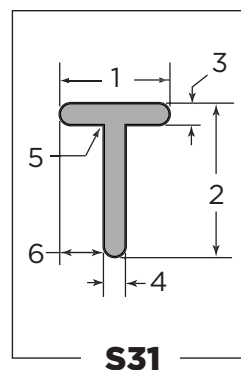
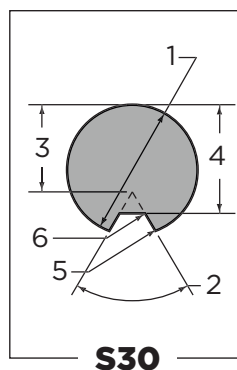
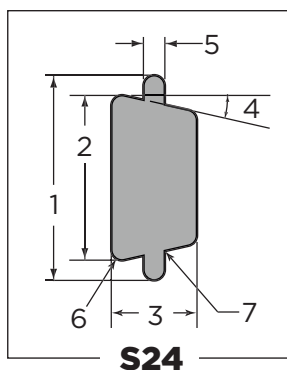
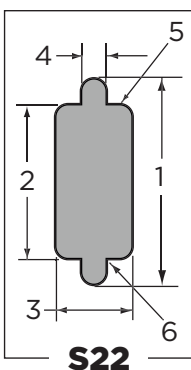
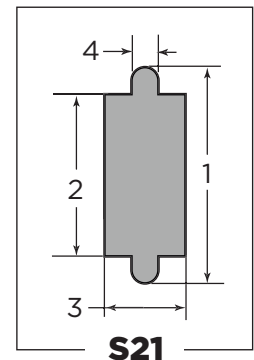
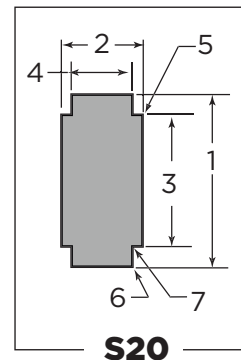
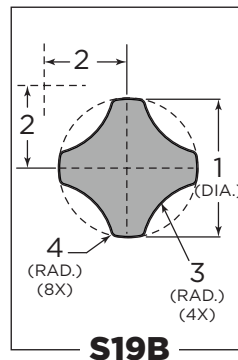
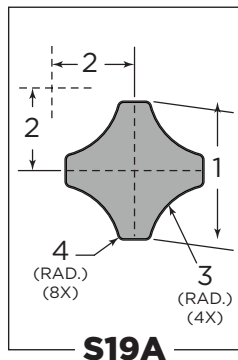
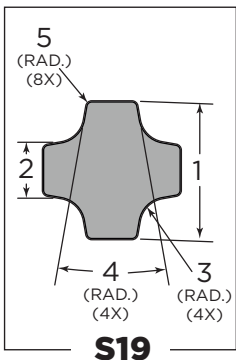
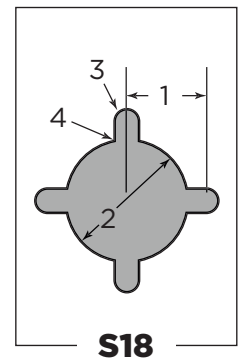
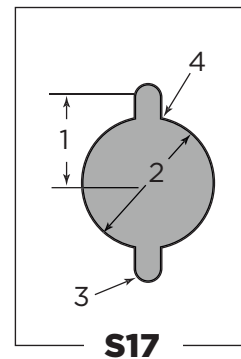
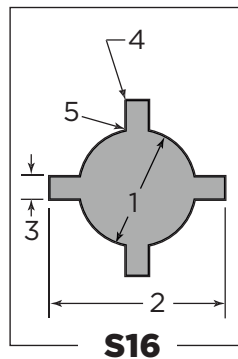
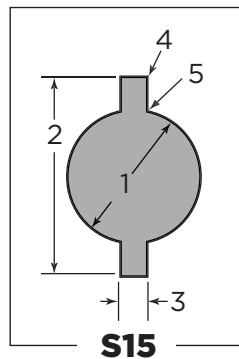
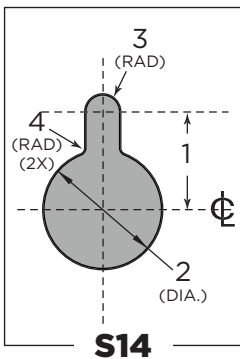
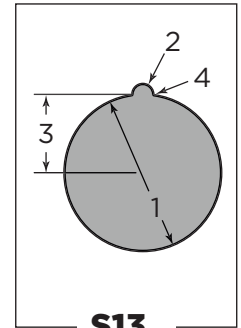
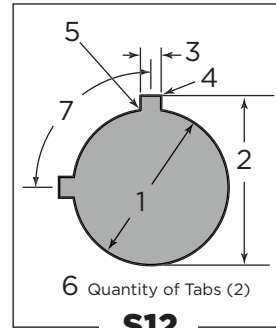
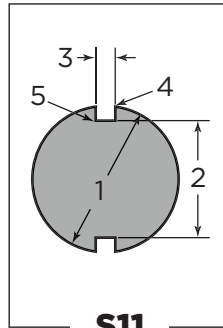
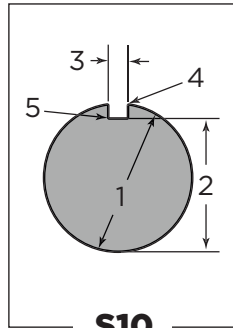
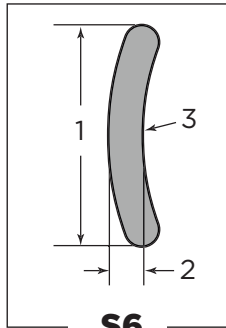
GROUP 'A'



NOTE: Special considerations may alter price and lead time.

SPECIAL SHAPES

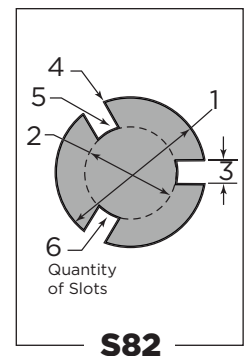
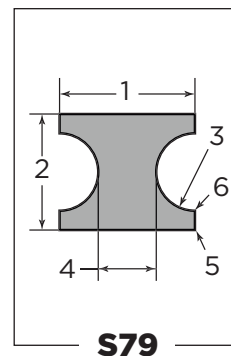
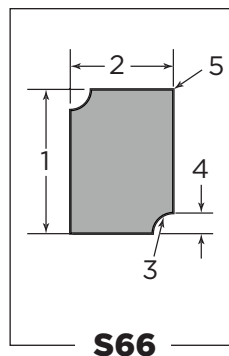
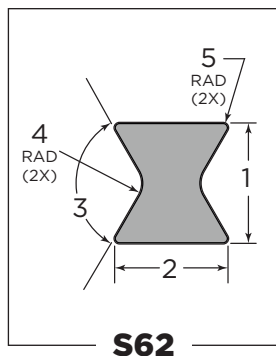
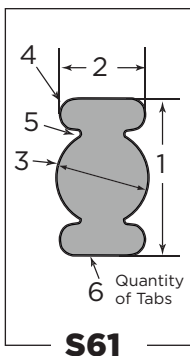
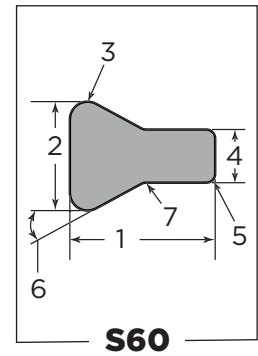
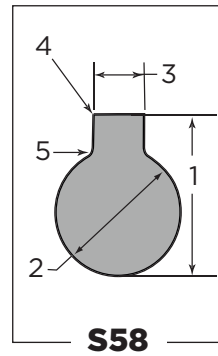
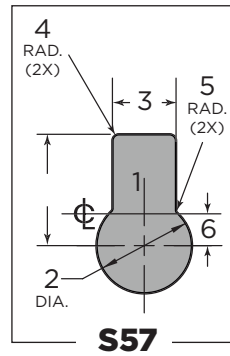
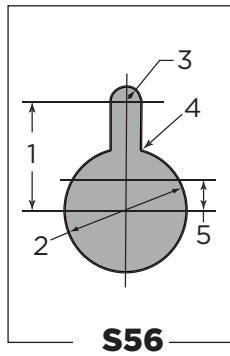
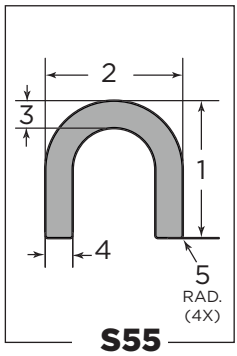
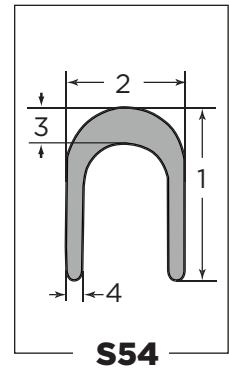
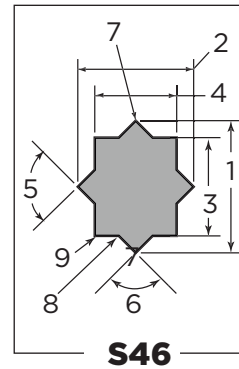
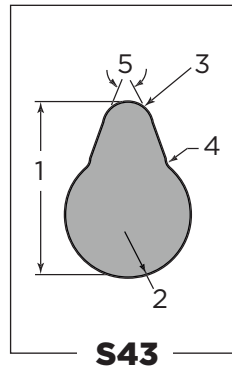
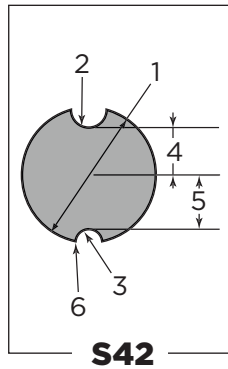
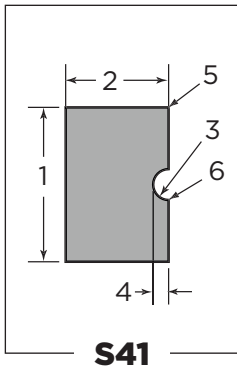
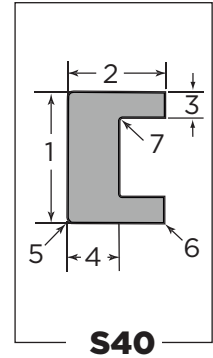
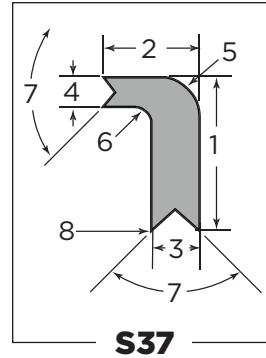
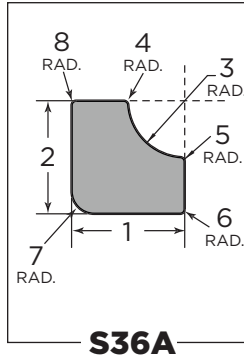
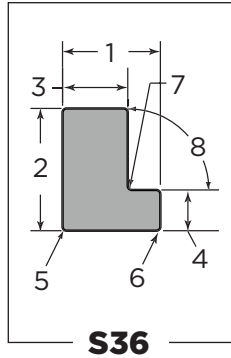
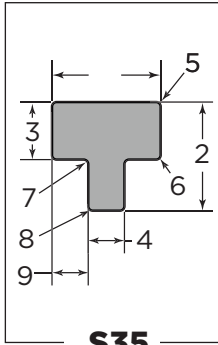
GROUP 'B'



NOTE: Special considerations may alter price and lead time.

SPECIAL SHAPES

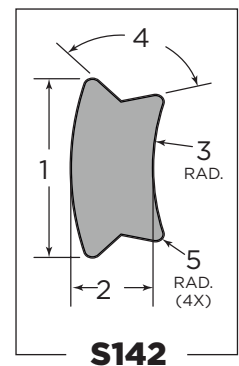
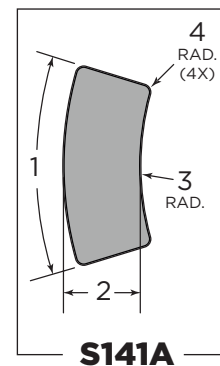
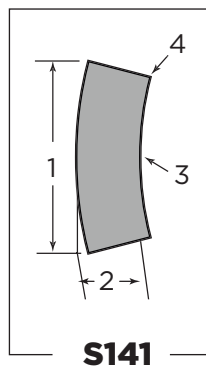
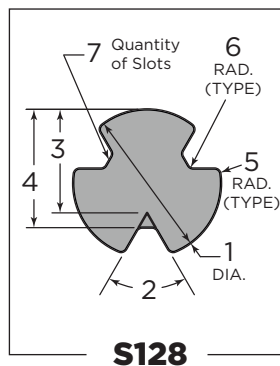
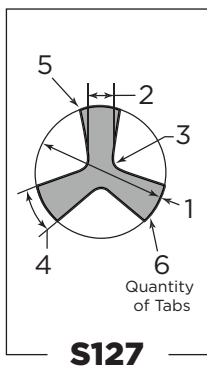
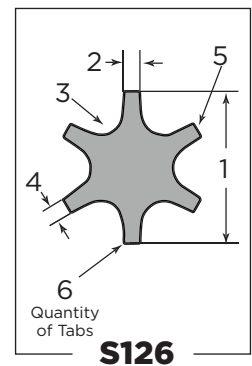
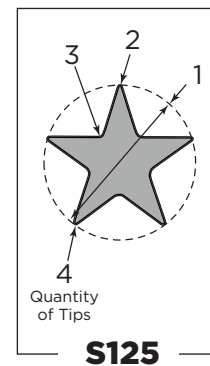
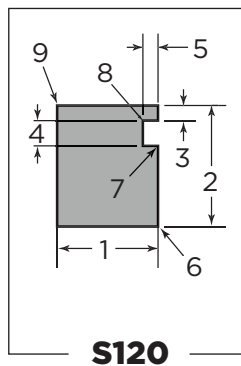
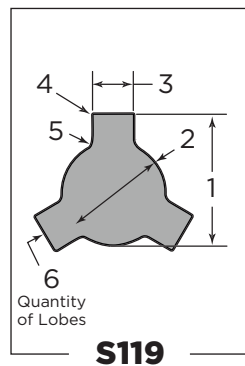
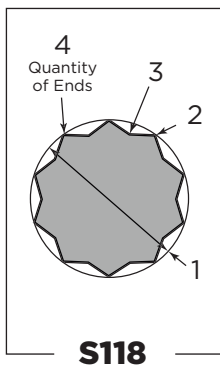
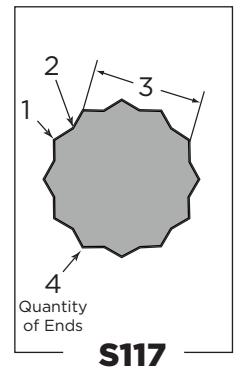
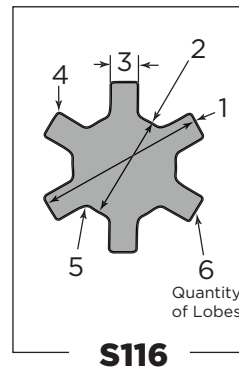
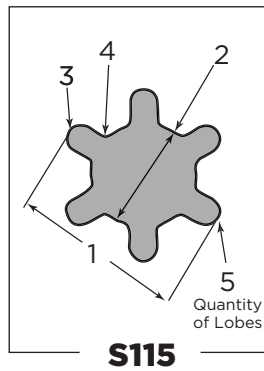
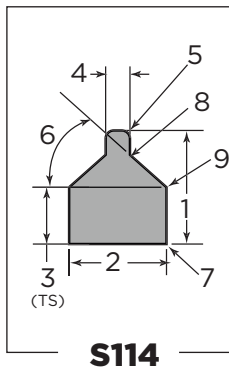
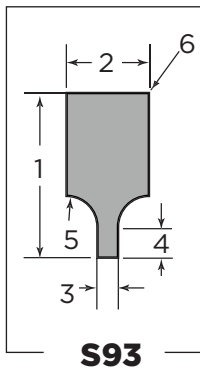
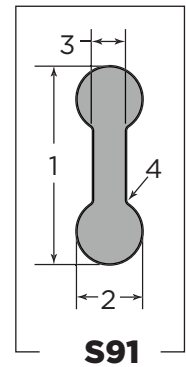
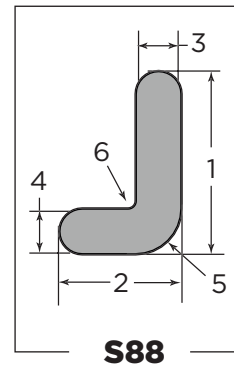
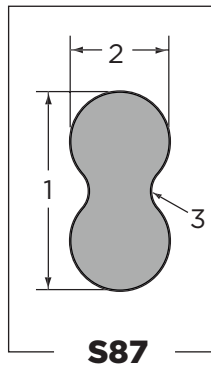
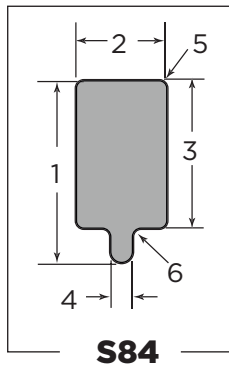
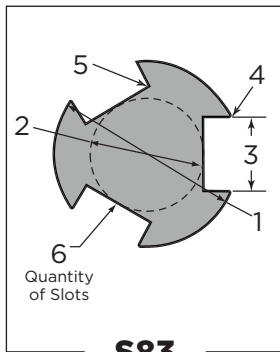
GROUP 'B'



NOTE: Special considerations may alter price and lead time.

SPECIAL SHAPES

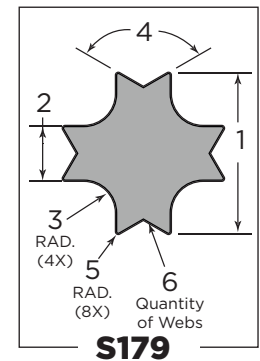
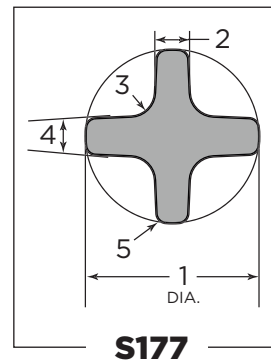
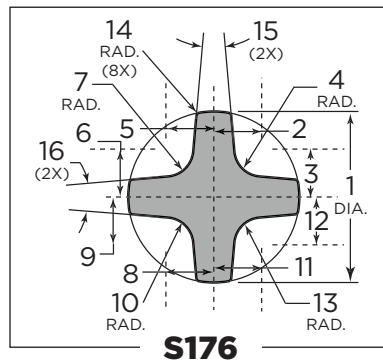
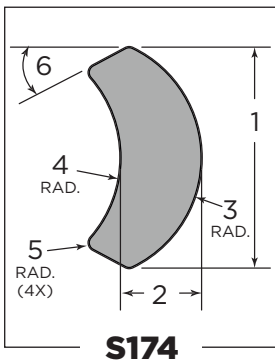
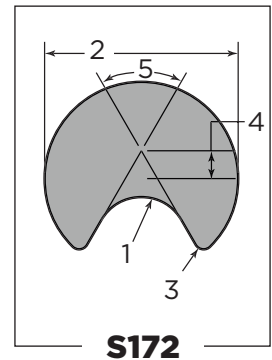
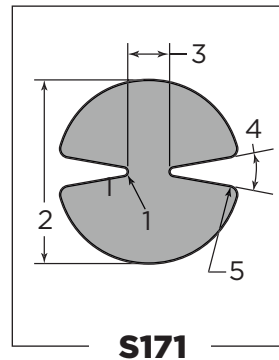
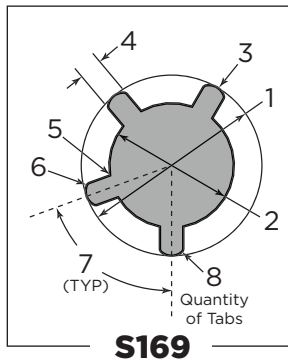
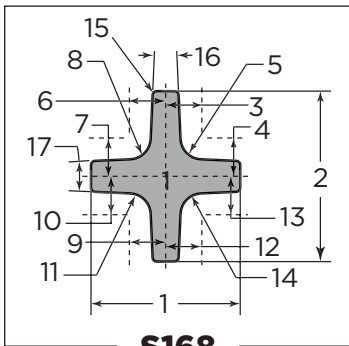
GROUP 'B'



NOTE: Special considerations may alter price and lead time.

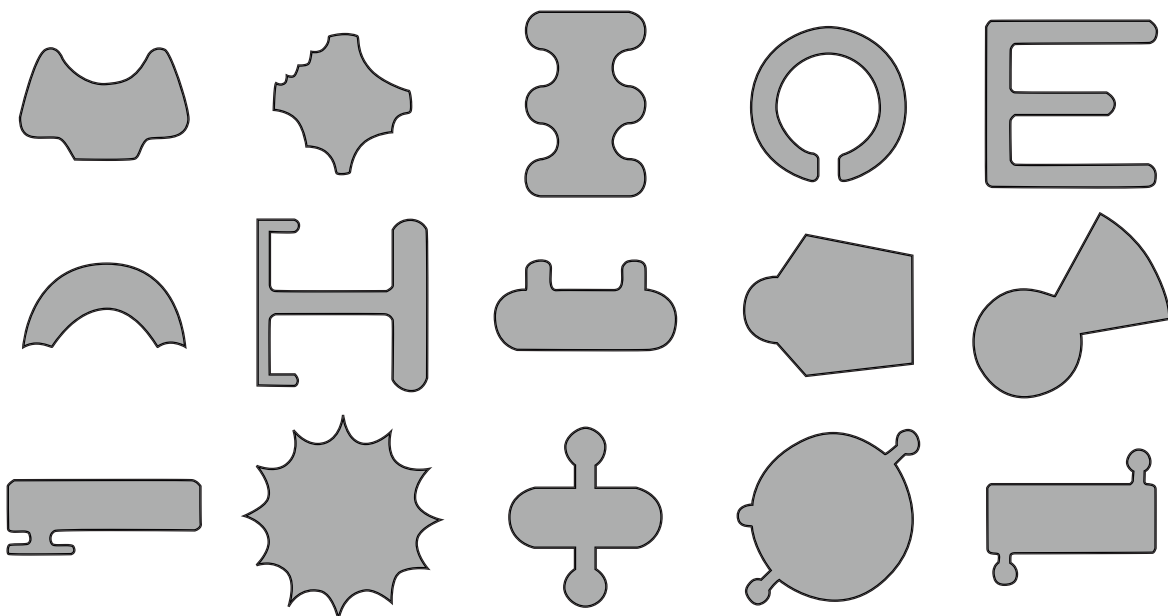
SPECIAL SHAPES

GROUP 'B'



NOTE: Special considerations may alter price and lead time.

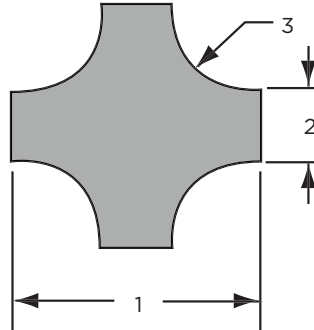
GROUP 'C'



Any complex 2D shape ordered with a DXF file will be priced as a 'B' Group. Electronic file will be validated at the time of ordering.

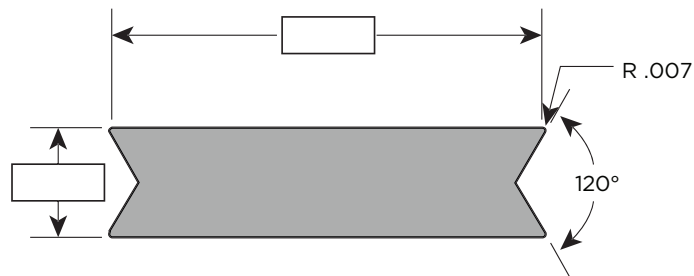
SPECIAL SHAPES

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 [1.58]	.250 [6.35]	.062 [1.58]
.094 [2.39]	.625 [2.39]	.250 [6.35]	.094 [2.39]
.125 [3.18]	.625 [3.18]	.250 [6.35]	.125 [3.18]
.156 [3.96]	.750 [3.96]	.250 [6.35]	.156 [3.96]
.188 [4.78]	.750 [4.78]	.250 [6.35]	.188 [4.78]
.250 [6.35]	.875 [6.35]	.250 [6.35]	.250 [6.35]
.312 [7.93]	1.000 [7.93]	.250 [6.35]	.312 [7.93]
.375 [9.53]	1.125 [9.53]	.250 [6.35]	.375 [9.53]
.500 [12.7]	1.250 [12.7] Ø	.250 [6.35]	.500 [12.7]

INVERTED DIAMOND



ACCESSORIES

CARTRIDGE & DIE PLATE



Magnetic Pad



A-Plus®



Die Plate

- Designed to enhance punch press productivity.
- Lightweight, durable alternative to plastic or steel cartridges.
- Constructed of 6061 T6 aluminum.

Description	Cat. No
Trumpf Cartridge	26838
Trumpf A-Plus® Cartridge	26836
Trumpf GL Die Plate	26731
Cartridge Magnetic Pad (single)	26235
Cartridge Magnetic Pad (5 pack)	26259
Trumpf GL Die Plate Key Assembly Only	26730

*Compatible with Tool Master System

INSERTION TOOL



This tool is used to load punch and stripper in to the cartridge.

Catalog No. 25566

MAGNETIC ID PAD



www.wilsontool.com

Magnetic pad used to mark tooling.

Description	Cat. No
2-4-1 Magnetic ID Pad	26657
2-4-1 Magnetic ID Pad (10 pack)	26687
2-4-1 Magnetic ID Pad – laser marked with punch detail	

ALIGNMENT FIXTURE



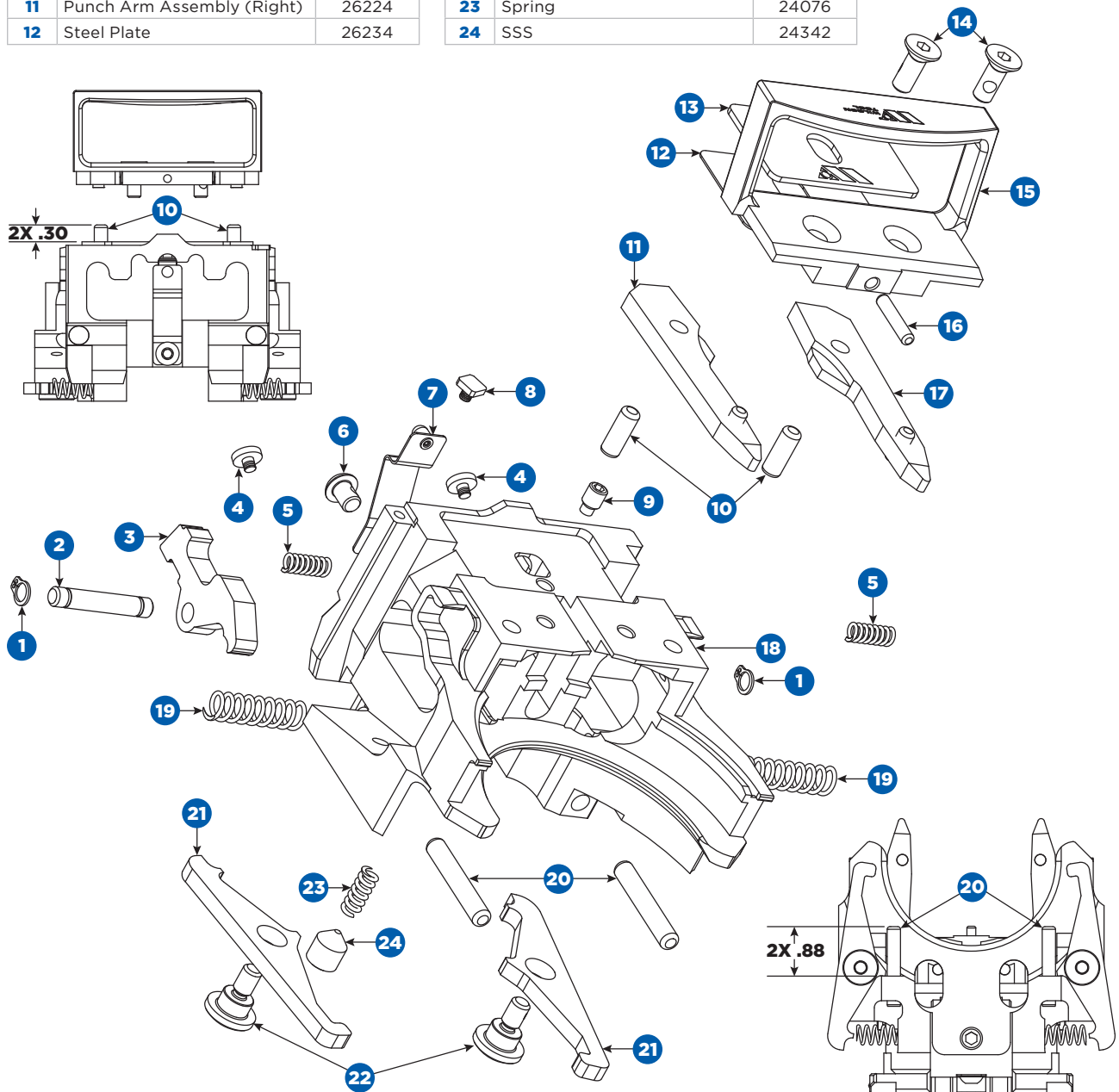
- The fixture can take all types of Trumpf-style collars: Size I, Size II, Minimatic-style, Heavy Duty, Manual, plus forming tools that do not have integral collars.
- Can be used for flat and whisper-style punches.
- Suitable for Trumpf, Pullmax, Omes, Euromac, Kunz and Boschert machines.
- Angle settings of 0° -45° -90°.
- Accurate, portable and durable.

Catalog No. 24186

CARTRIDGE REPLACEMENT PARTS

Description	Cat. No.
1 Retaining Ring (2)	24338
2 Stripper Latch Pin	24337
3 Stripper Hold Down	26232
4 Hardened Insert (2)	26266
5 Spring (2)	24335
6 BHCS	983277
7 Spring Clip	26332
8 Sensor Insert	26366
9 SSS	25213
10 Dowel Pin (2)	970416
11 Punch Arm Assembly (Right)	26224
12 Steel Plate	26234

Description	Cat. No.
13 Magnet	26235
14 FHCS (2)	983278
15 Trumpf Cartridge Handle	26834
16 Dowel Pin	07048
17 Punch Arm Assembly (Left)	26225
18 Main Body	26229
19 Spring (2)	972292
20 Dowel Pin (2)	972294
21 Die Arm	26230
22 SHSS w/Nylok	26231
23 Spring	24076
24 SSS	24342



ACCESSORIES

TOOL STORAGE

Cabinet Specifications

- High-capacity, PVC-lined drawers use an integrated, one-drawer-at-a-time locking system
- Ergonomic design ensures operator safety
- Secure, enclosed storage helps to maintain tool condition
- Stationary cabinets have a 2-inch recessed base to prevent toe kicks
- Mobile base style includes 6-inch casters, a side handle and an integrated lock-in mechanism on drawer handle
- Custom cabinet colors available on request (price to be quoted)

ACCESSORIES

Trumpf-Style Tooling Cabinet (8 Drawers)			
Cat. No.	W x D x H		Est. Weight
989828	30" x 27" x 42"	[76.2 x 68.5 x 106.6cm]	494 lbs.
989829	30" x 27" x 47.5"	[76.2 x 68.5 x 120.6 cm]	510 lbs.
7 Drawers - 4" [101.6mm]			
• Twelve 6" x 8" [152 x 203mm] compartments with 3-1/8" [79mm] of usable height (depth) (per drawer)			
1 Drawers - 8" [203.2mm]			
• Sixteen 6" x 6" [152 x 152mm] compartments with 7-1/16" [179mm] of usable height (depth) (per drawer)			



Trumpf-Style Cartridge Cabinet (7 Drawers)			
Cat. No.	W x D x H		Est. Weight
989830	30" x 27" x 42"	[76.2 x 68.5 x 106.6cm]	428 lbs.
989831	30" x 27" x 47.5"	[76.2 x 68.5 x 120.6 cm]	443 lbs.
3 Drawers - 4" [101.6mm]			
• Twelve 100mm deep compartments (per drawer)			
4 Drawers - 6" [152.4mm]			
• 150mm deep (open layout) (per drawer)			



Punching Cabinet Accessories

Cat. No.	Size	Est. Weight	Description
989833	30" x 27"	25.5 lbs.	Steel Top w/Rubber Mat
989832	30" x 27"	38 lbs.	Laminated Wood Top



989833

989832

CUSTOM COLOR OPTIONS

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

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



XSHARP™ GRINDER

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



ACCESSORIES

XSHARP™ ACCESSORIES	
Description	Cat. No.
Grinding Wheel	55109
Coolant	55367
Dressing Stone	55117

TECHNICAL SPECIFICATIONS*	
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.

ACCESSORIES

MAGNET SQUARE



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

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**

OIL STONE



- 3 square aluminum oxide sharpening stone.
- Catalog No. 6060**

DIAMOND FILE



- Industrial file plated with finely selected diamond powder. Can be used on hardened tool steel.
- Catalog No. 6059**

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**

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**

RUBBERIZED ABRASIVE WHEEL



- For removing galling
 - Measuring range: 0 - 6"
 - Accuracy to 0.001"
- Catalog No. 8050**

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**

GRINDING FIXTURE

SHEAR GRINDING FIXTURE

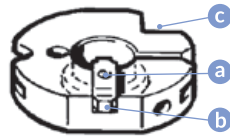


- Easy to adjust angle setting for shear grinding.
- Can be used with your existing surface grinder.
- Easy to use instruction sheet with grinding tips.

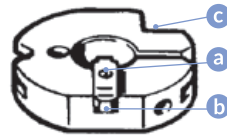
STD / HP FIXTURE & COMPONENTS

Description	Cat. No
Shear Grinding Fixture	6034
Size 1 and 2 Punch Holder	6089
Size 1 Die Holder	25365
Size 2 Die Holder	25366
MT4 Punch Holder	25302
MT4 Die Holder	25304
MT6 Punch Holder	25303
MT6 Die Holder	25305
MT5 Punch Holder	25935
MT5 Die Holder	25936
MT10 Punch Holder	26004
MT10 Die Holder	26021

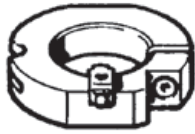
ALIGNMENT COLLARS, PUNCH CHUCKS



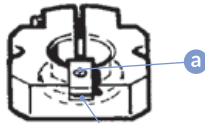
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2



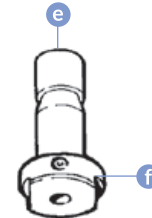
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4



5



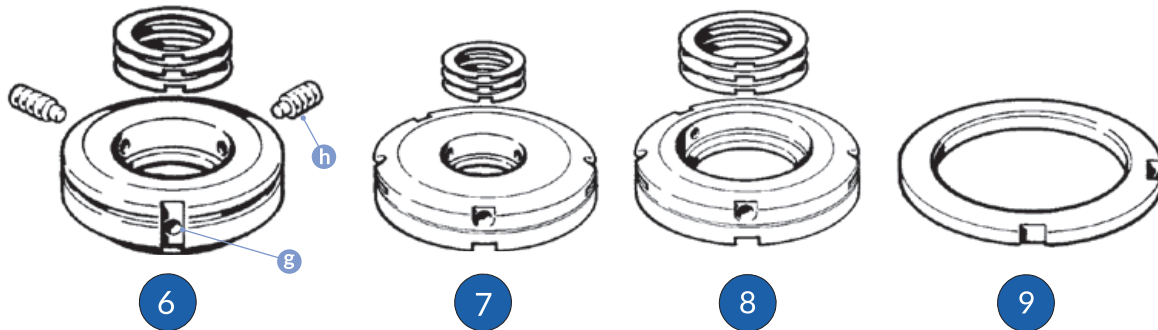
ALIGNMENT COLLARS			
Size		Description	Cat. No.
I	1	Auto-tool change machine groups E/F/G/H/I	25018
II to III	2	Auto-tool change machine groups E/F/G/H/I	25139
I to II	3	For heavy duty punch	25138
I	4	For machine group S	25186
II to III	5	For machine group S	25188

PUNCH CHUCKS		
Size	Description	Cat. No.
0	.000 - .236" [0 - 6.00mm]	25010
	.237 - .413" [6.01 - 10.5mm]	25021

Not recommended for punching stainless steel

	Description	Cat. No.
a	Screw (M3 X 12)	25215
b	Locating Key	25019
c	Adjustment Bolt (M6 X 35)	970453
d	Locating Key	25209
e	M 14 Set Screw	25212
f	M 6 Set Screw	25213

TRUMPF DIE & STRIPPER ADAPTERS, DIE SHIMS



	Description	Cat. No.
g	Dowel Pin	25362
h	Screw (M8 x 12mm)	970398

TRUMPF DIE & STRIPPER ADAPTERS, DIE SHIMS			
Size		Description	Cat. No.
I to II	6	Die Adapter, machine groups F/H/I	25165
	7	Die Adapter, machine groups E & G	25168
I to III	8	Die Adapter, machine groups E & G	25167
	9	Stripper Adapter, machine group G	25155
I		Shim Pack for size I Dies*	25181
II		Shim Pack for size II Dies*	25182

*Includes 1 each of .5 and .3 shims and 2 each of .1mm thick shims

BRUSH DIES



BRUSH DIES		
	Description	Cat. No.
1	Size 1 to 2 Brush Die Adapter	25939
	Brush Ring Insert	25945
	Brush Ring Shim Pack	25948
2	Size 2 Brush Die [56mm max. 'A' Dim.]	26025
3	Size 2 Brush Die [10mm max. width]	26037
4	Parting Tool Brush Die [76mm max.]	25942
5	Parting Tool Brush Die [56mm max.]	25941

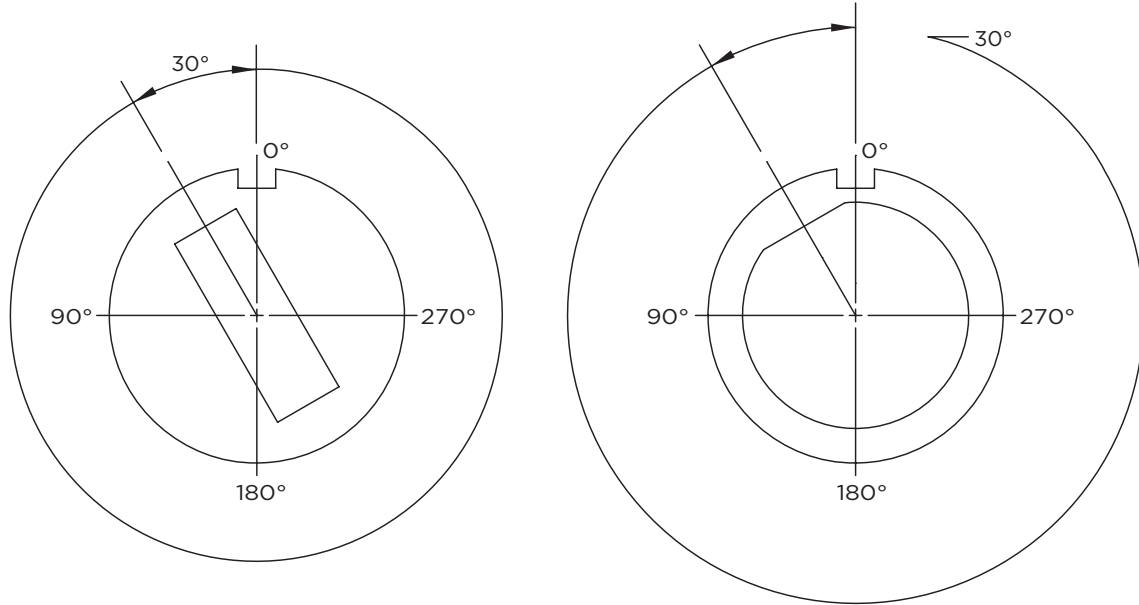


MULTI-TOOL BRUSH DIES		
	Description	Cat. No.
MT4	[1 x 10mm, 4 x 15mm]	25930
MT5	[1 x 15mm, 5 x 10mm]	26026
MT6	[1 x 24mm, 6 x 10mm]	25931
MT10	[1 x 24mm, 10 x 10mm]	26027

REPLACEMENT BRUSH INSERTS & BRUSH SHIMS		
	Description	Cat. No.
	10mm Brush Insert	25924
	15mm Brush Insert	25925
	24mm Brush Insert	25926
	10mm Brush Insert Pack [1 x .1mm, 1 x .3mm]	25927
	15mm Brush Insert Pack [1 x .1mm, 1 x .3mm]	25928
	24mm Brush Insert Pack [1 x .1mm, 1 x .3mm]	25929

KEYING & DIE CLEARANCE

KEYING FOR NON-ROTATIONAL MACHINES



DIE CLEARANCE SELECTION INFORMATION

TOTAL CLEARANCE

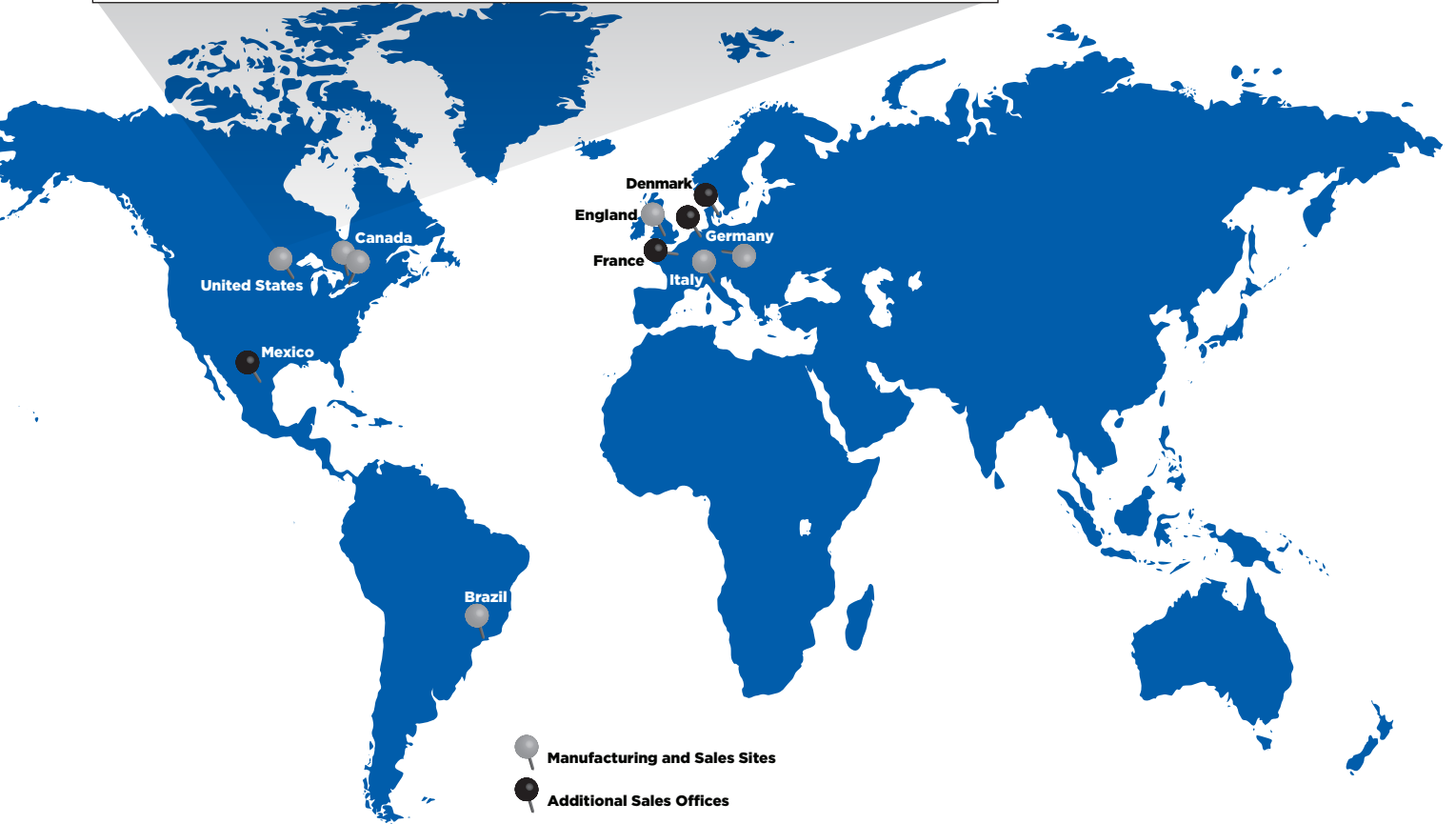
Material	Minimum	Best	Maximum
Copper, 1/2 Hard	8%	12%	16%
Brass, 1/2 Hard	6%	11%	16%
Mild Steel	10%	15%	20%
Steel 0.50C	12%	18%	24%
Aluminum, Soft	5%	10%	15%
Stainless Steel	15%	20%	25%

% x Material Thickness = Total Clearance

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.



P233C (11.2024)
Digital 1.2025