



iSeries THICK TURRET TOOLING SOLUTIONS

Standards, Accessories



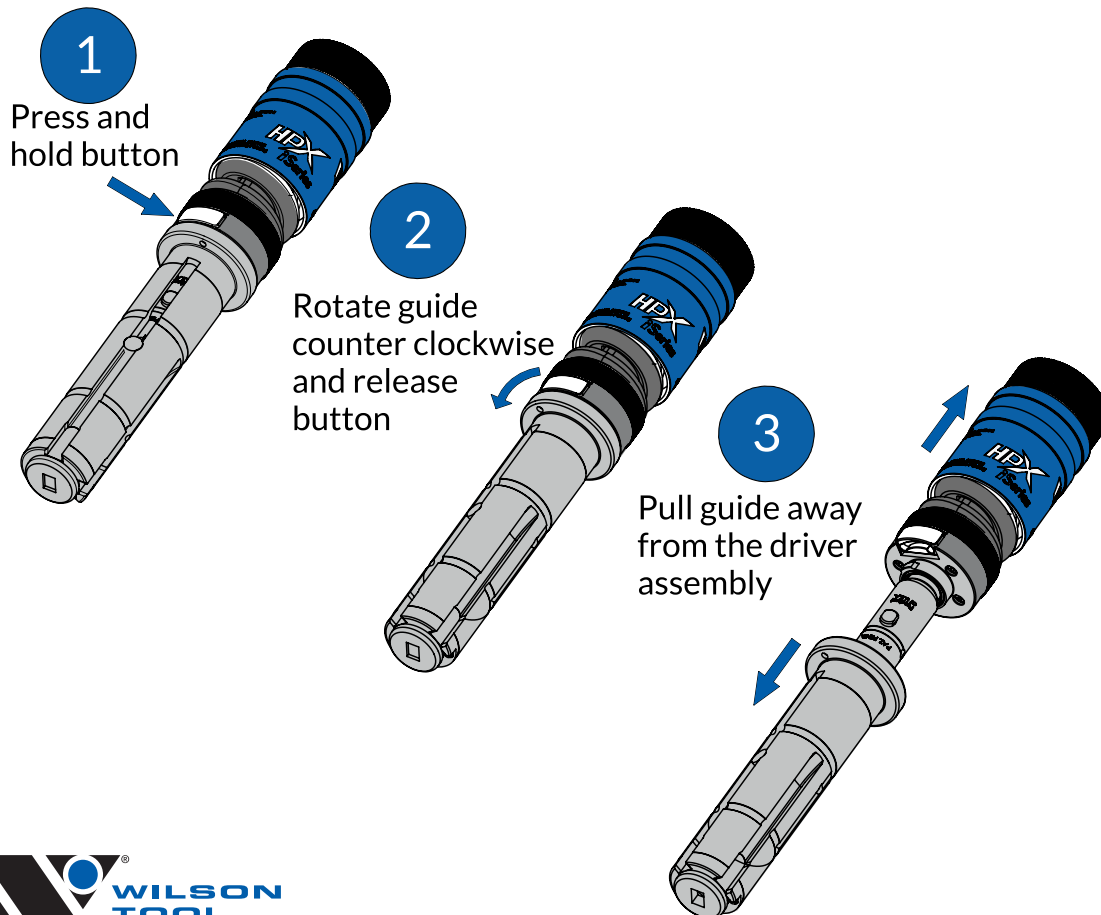
THE WILSON TOOL iSERIES

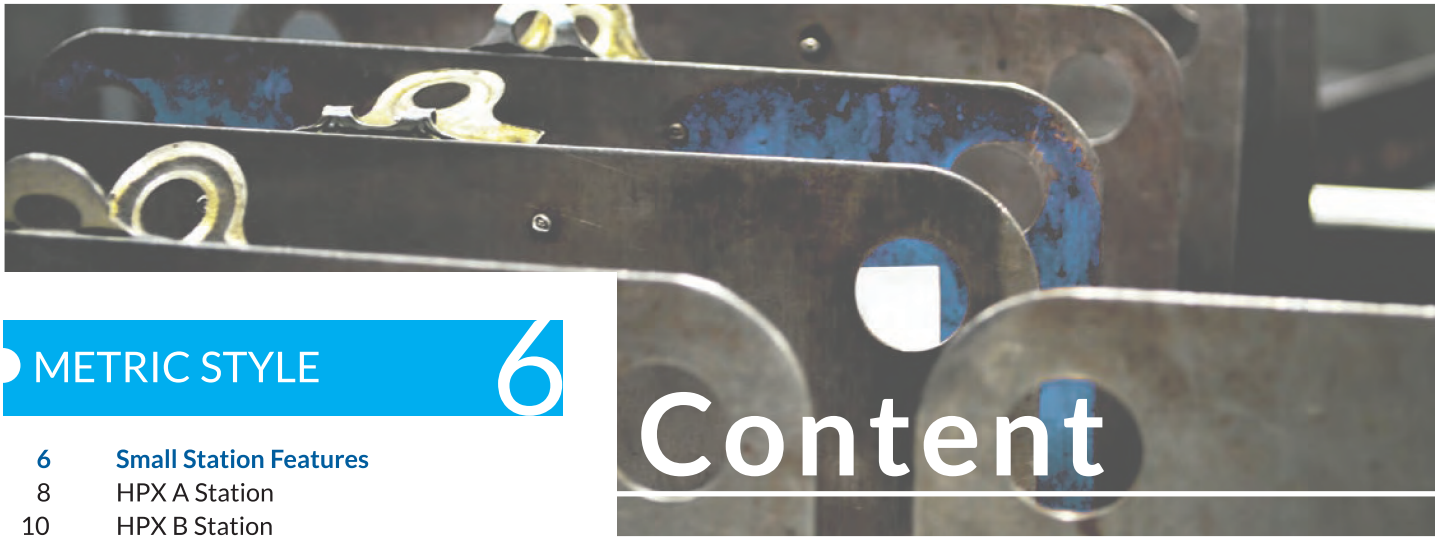
The Wilson Tool iSeries tooling is specially designed to be fully compatible with the AMADA® AITS® tool ID system. All key components will be laser marked with a data matrix code. This code contains a unique serial number for that component. This information is loaded into the machine control when scanned. The proper paperwork needed will accompany all products in their packaging. It will have a code with all the tool characteristics that will also be scanned and loaded into control.

The iSeries small station tooling is available in HPX and Metric HP2. Large station iSeries includes Metric HP and Standard as well as Wilson HP. These products have some added features to ensure they work seamlessly with the AITS and auto load system. The iSeries A and B station HPX & HP2 assemblies now have a push button guide release. This design allows the spring pack to be mechanically attached to the guide so there is no risk of it separating during loading.



PUSH BUTTON GUIDE RELEASE





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Prices and product availability are subject to change without notice.

THE WILSON TOOL DIFFERENCE

COMPANY OVERVIEW

From very humble beginnings in a small manufacturing facility in St. Paul, Minnesota, Wilson Tool has added manufacturing facilities and sales channels around the world to better serve our thousands of global customers. Throughout our International 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.

The products included in this catalog represent the results of over 50 years of helping customers resolve their most challenging fabrication issues. Don't be concerned if the challenge you are currently facing can't be resolved with a product included in this catalog – give us a call and 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, as always, if you are not happy with the final solution we provide, we will either find a way to help you succeed or we will refund your money.

From all of us at Wilson Tool, thank you for the trust you have placed in us to provide you with products and services that support your business. We look forward to the continuation of our partnership into the future.

Sincerely,

Brian Robinson
Wilson Enterprises

The Wilson Tool Punching Division continues to drive the industry with new levels of quality, delivery, service and innovation.

From the early days of Series 80 tooling to Wilson Wheels to innovative EXP® technology, our punching division has been the leading innovation driver in the industry. When combined with the most experienced customer support professionals in the industry, the solutions offered from Wilson Tool continue to raise the bar on performance and innovation. Thick turret, Trumpf, Salvagnini, or any other style of punch press you may be using, Wilson Tool offers the most complete line of tooling solutions available today.

PUNCHING



BENDING

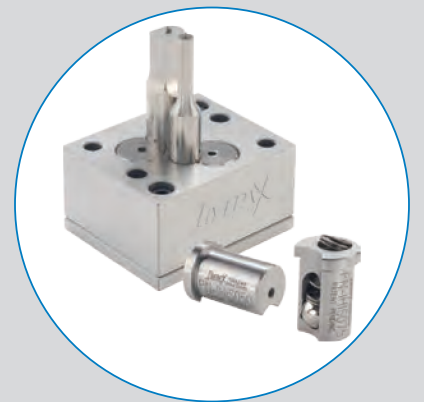
Wilson Tool's Bending Division delivers the most complete line of tooling and clamping solutions available anywhere. Period.

Whether you use American, European, or Wila/Trumpf style precision tooling or conventional style tooling, Wilson Tool has a solution for you. Our clamping options cover these styles as well. With hydraulic push button options, quick release mechanical options, or standard manual clamps, Wilson Tool has a clamping solution for any style of machine or budget. And our custom tooling manufacturing capabilities have quickly become the envy of the industry with innovative solutions for very 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.

Wilson Tool's Stamping division (aka Impax Tooling Solutions®) offers high quality punch and die components 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.

STAMPING



ACCESSORIES

Whether you need tool sharpening grinders, tooling storage systems, or other types of related supplies, our accessory products offer a wide range of solutions to help you be more productive.

From small to large items, our accessories will help your shop be more organized and efficient.





HPX



H/P2



METRIC STYLE TOOLING SOLUTIONS

SMALL STATION ADVANTAGES	HPX	HP2
Compatible with Amada® AITS® System	●	●
Hardened guides for increased durability	●	●
Simple tool-less stripper change	●	●
Relieved strippers for extended guide life	●	●
Internal and external tool lubrication	●	●
Machine lubrication capability (ABS/WLS only, all HPX)	●	●
OEM compatible	●	●
Optima® coated punches available	●	●
Slug Hugger® 2 – maximum slug retention	●	●
In machine adjustment for faster set ups	●	●
Easy click length adjustment – no shims or tooling required	●	●
Maximum available grind life	●	●
Push button guide release	●	●
EXP quick change technology	●	
Made standard from Ultima® premium tool steel	●	
Accepts round or shaped punches in the same assembly	●	



PUNCH AND GUIDE ASSEMBLY



GUIDE



EXP PUNCH



STRIPPER



DIE



SHIM

PUNCH AND GUIDE ASSEMBLY		CAT. NO.	PRICE
Round		14026i	
Shape		14012i	
Optima® Coating			
SPRING PACK ASSEMBLY		CAT. NO.	PRICE
Spring Pack Assembly only		14366i	
GUIDE		CAT. NO.	PRICE
Round		14076i	
Shape 0°		14077i	
Shape 0° & 45°		14079i	
Shape 0° & 90°		14078i	
PUNCH		CAT. NO.	PRICE
Round		13904i	
Shape		13905i	
Optima® Coating			
STRIPPER		CAT. NO.	PRICE
Round ABS		13045i	
Shape ABS		13152i	
DIE		CAT. NO.	PRICE
Round Slug Hugger®*		2192i	
Round Standard		1808i	
Shape Slug Hugger® 2*		12959i	
Shape Positive		1817i	
Shape Negative		1818i	
* Slug Hugger dies must be ordered punch size plus clearance. Size restrictions apply.			
DIE SHIM		CAT. NO.	PRICE
.010 [0.25mm]	single	2101	
.030 [0.76mm]	single	2721	
.060 [1.5mm]	single	2104	
.010 [0.25mm]	pack of 25	2208	
.030 [0.76mm]	pack of 25	2722	
.060 [1.5mm]	pack of 25	2172	



See this tool in action on the [Wilson Tool YouTube Channel](#)

Additional charges may apply to non-standard features. See page 56.

DESCRIPTION	A DIMENSION	MAX MATERIAL THICKNESS	NOTES
HPX tooling is Wilson Tool's 'Best' product. It is loaded with all the great features of the HP2 plus the EXP quick change punch system with Ultima® tool steel.	.500" [12.7mm] 	.150" [3.81mm] 	Compatible with ABS and non-ABS machines. Ultima tool steel is standard in EXP punches. Dies are available in Ultima tool steel upon request.

STANDARD SHAPES



HPX A STATION REPLACEMENT PARTS



A

METRIC



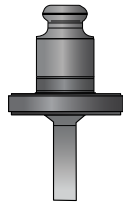
DESCRIPTION	CAT. NO.
1 Dowel Pin [.187" x .312"]	6013
2 Die	See Opposite Page
3 Stripper	See Opposite Page
4 Punch	See Opposite Page
5 Guide	See Opposite Page
6 Punch Holder	14016
7 iSeries Spring Pack	14366i



PUNCH AND GUIDE ASSEMBLY



GUIDE



EXP PUNCH



STRIPPER



DIE



SHIM

PUNCH AND GUIDE ASSEMBLY	CAT. NO.	PRICE
Round	14029i	
Shape	14018i	
Optima® Coating		

SPRING PACK ASSEMBLY	CAT. NO.	PRICE
Spring Pack Assembly only	14367i	

GUIDE	CAT. NO.	PRICE
Round	14084i	
Shape 0°	14085i	
Shape 0° & 45°	14087i	
Shape 0° & 90°	14086i	

PUNCH	CAT. NO.	PRICE
Round	13916i	
Shape	13917i	
Optima® Coating		

STRIPPER	CAT. NO.	PRICE
Round ABS	2433i	
Shape ABS	2432i	

DIE	CAT. NO.	PRICE
Round Slug Hugger®*	2194i	
Round Standard	2021i	
Shape Slug Hugger® 2*	12961i	
Shape Positive	2025i	
Shape Negative	2026i	

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

DIE SHIM	CAT. NO.	PRICE
.010 [0.25mm] single	2097	
.030 [0.76mm] single	2723	
.060 [1.5mm] single	2100	
.010 [0.25mm] pack of 25	2209	
.030 [0.76mm] pack of 25	2724	
.060 [1.5mm] pack of 25	2173	

Additional charges may apply to non-standard features. See page 56.



See this tool in action on the
Wilson Tool YouTube Channel

DESCRIPTION	A DIMENSION	MAX MATERIAL THICKNESS	NOTES
HPX tooling is Wilson Tool's 'Best' product. It is loaded with all the great features of the HP2 plus the EXP quick change punch system with Ultima® tool steel.	1.250" [31.8mm] 	.250" [6.35mm] 	Compatible with ABS and non-ABS machines. Ultima tool steel is standard in EXP punches. Dies are available in Ultima tool steel upon request.

STANDARD SHAPES

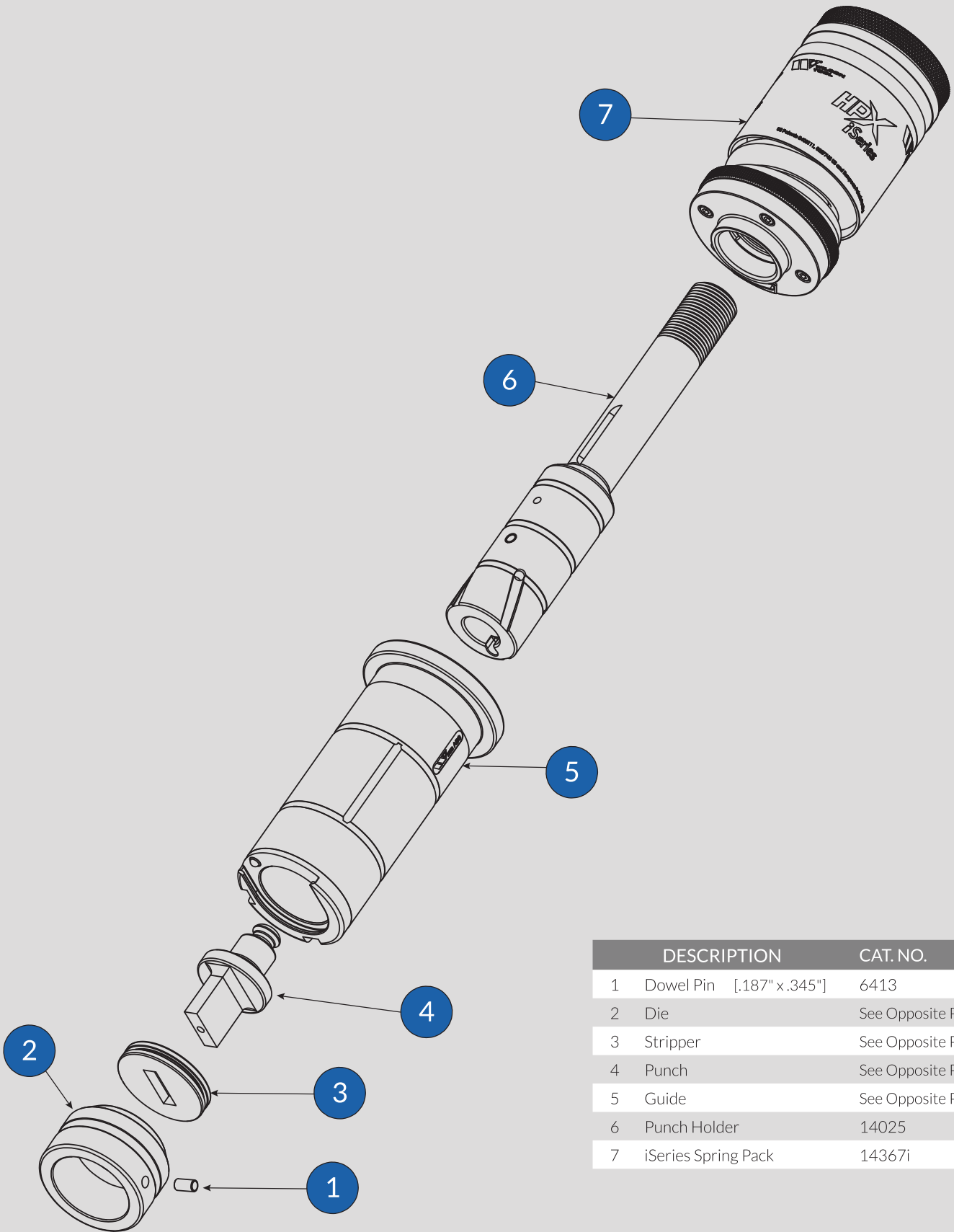


HPX B STATION REPLACEMENT PARTS

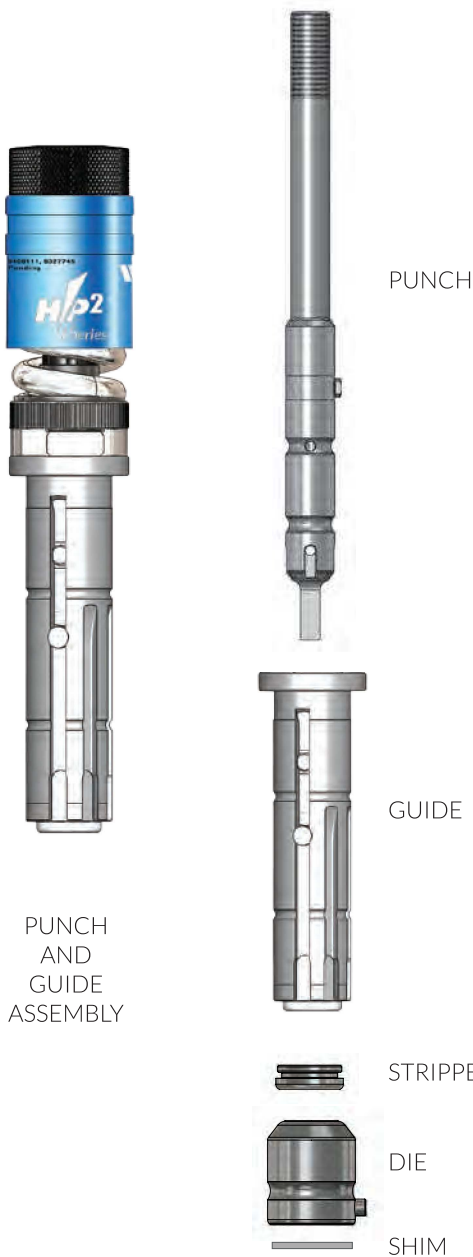


B

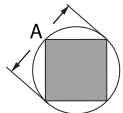
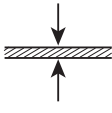
METRIC



	DESCRIPTION	CAT. NO.
1	Dowel Pin [.187" x .345"]	6413
2	Die	See Opposite Page
3	Stripper	See Opposite Page
4	Punch	See Opposite Page
5	Guide	See Opposite Page
6	Punch Holder	14025
7	iSeries Spring Pack	14367i



PUNCH AND GUIDE ASSEMBLY	CAT. NO.	PRICE
Round	14054i	
Shape	14055i	
Optima® Coating		
SPRING PACK ASSEMBLY	CAT. NO.	PRICE
Spring Pack Assembly	14153i	
PUNCH	CAT. NO.	PRICE
Round ABS, pinned **	13869i	
Shape ABS	13870i	
Optima® Coating		
GUIDE	CAT. NO.	PRICE
Round	14076i	
Shape 0°	14077i	
Shape 0° & 45°	14079i	
Shape 0° & 90°	14078i	
STRIPPER	CAT. NO.	PRICE
Round ABS	13045i	
Shape ABS	13152i	
DIE	CAT. NO.	PRICE
Round Slug Hugger®*	2192i	
Round Standard	1808i	
Shape Slug Hugger® 2*	12959i	
Shape Positive	1817i	
Shape Negative	1818i	
* Slug Hugger dies must be ordered punch size plus clearance. Size restrictions apply.		
DIE SHIM	CAT. NO.	PRICE
.010 [0.25mm] single	2101	
.030 [0.76mm] single	2721	
.060 [1.5mm] single	2104	
.010 [0.25mm] pack of 25	2208	
.030 [0.76mm] pack of 25	2722	
.060 [1.5mm] pack of 25	2172	
Additional charges may apply to non-standard features. See page 56.		

DESCRIPTION	A DIMENSION	MAX MATERIAL THICKNESS	NOTES
HP2 is Wilson Tool's 'Better' product. It offers a great value with standard features like easy click length adjustment, high grade tool steel, ABS/WLS compatible.	.500" [12.7mm] 	.150" [3.81mm] 	**HP2 assemblies require a pinned round punch. Dies are available in Ultima® tool steel upon request.

STANDARD SHAPES

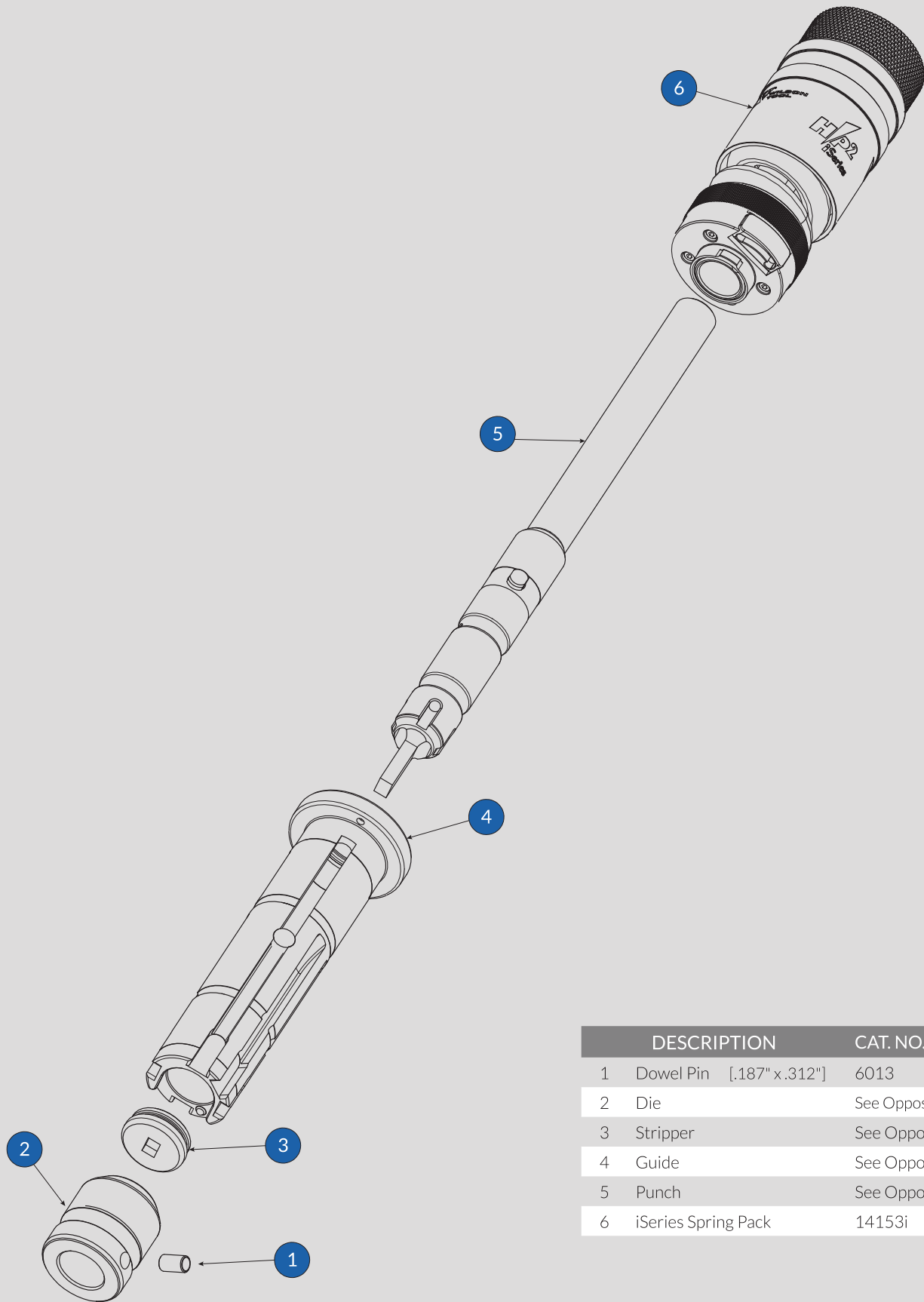


HP2 A STATION REPLACEMENT PARTS



A

METRIC



	DESCRIPTION	CAT. NO.
1	Dowel Pin [.187" x .312"]	6013
2	Die	See Opposite Page
3	Stripper	See Opposite Page
4	Guide	See Opposite Page
5	Punch	See Opposite Page
6	iSeries Spring Pack	14153i



PUNCH AND GUIDE ASSEMBLY



PUNCH



GUIDE



STRIPPER



DIE



SHIM

PUNCH AND GUIDE ASSEMBLY	CAT. NO.	PRICE
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Round	14058i	
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Shape	14059i	
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Optima® Coating		
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SPRING PACK ASSEMBLY	CAT. NO.	PRICE
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Spring Pack Assembly	14172i	
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PUNCH	CAT. NO.	PRICE
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Round ABS, pinned **	13871i	
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Shape ABS	13872i	
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Optima® Coating		
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GUIDE	CAT. NO.	PRICE
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Round	14084i	
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Shape 0°	14085i	
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Shape 0° & 45°	14087i	
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Shape 0° & 90°	14086i	
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STRIPPER	CAT. NO.	PRICE
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Round ABS	2433i	
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Shape ABS	2432i	
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DIE	CAT. NO.	PRICE
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Round Slug Hugger®*	2194i	
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Round Standard	2021i	
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Shape Slug Hugger® 2*	12961i	
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Shape Positive	2025i	
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Shape Negative	2026i	
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* Slug Hugger dies must be ordered punch size plus clearance. Size restrictions apply.

DIE SHIM	CAT. NO.	PRICE
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.010 [0.25mm] single	2097	
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.030 [0.76mm] single	2723	
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.060 [1.5mm] single	2100	
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.010 [0.25mm] pack of 25	2209	
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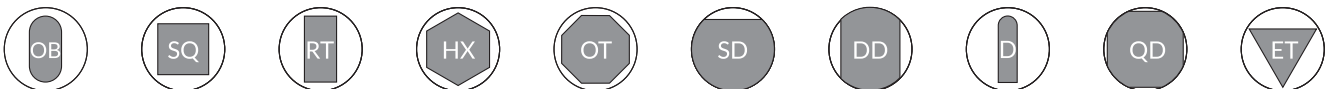
.030 [0.76mm] pack of 25	2724	
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.060 [1.5mm] pack of 25	2173	
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Additional charges may apply to non-standard features. See page 56.

DESCRIPTION	A DIMENSION	MAX MATERIAL THICKNESS	NOTES
HP2 is Wilson Tool's 'Better' product. It offers a great value with standard features like easy click length adjustment, high grade tool steel, ABS/WLS compatible.	1.250" [31.75mm] 	.250" [6.35mm] 	**HP2 assemblies require a pinned round punch. Dies are available in Ultima® tool steel upon request.

STANDARD SHAPES

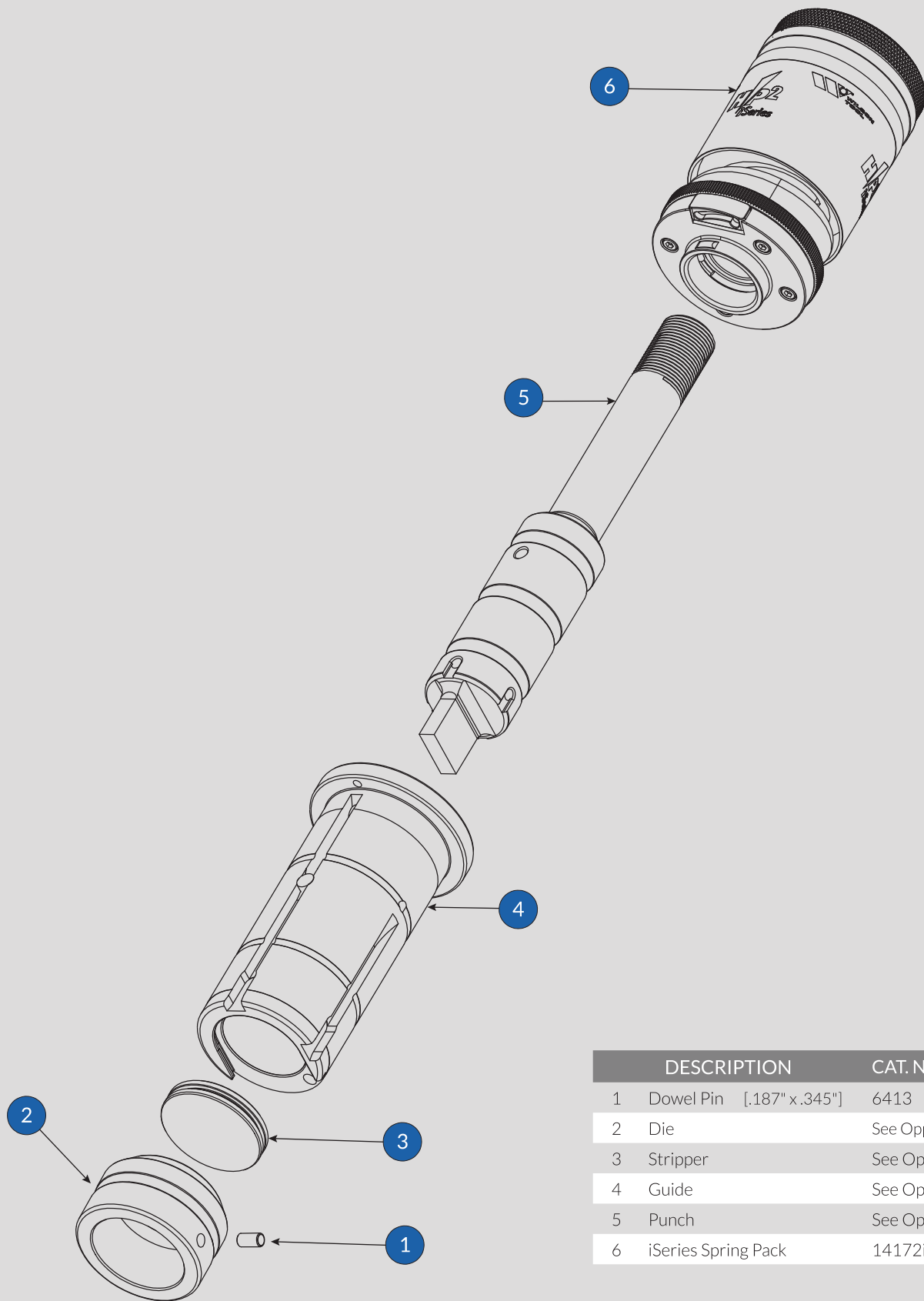


HP2 B STATION REPLACEMENT PARTS



B

METRIC



	DESCRIPTION	CAT. NO.
1	Dowel Pin [.187" x .345"]	6413
2	Die	See Opposite Page
3	Stripper	See Opposite Page
4	Guide	See Opposite Page
5	Punch	See Opposite Page
6	iSeries Spring Pack	14172i



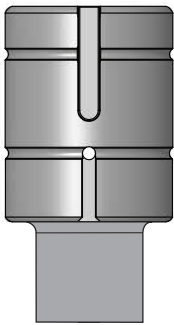


METRIC STYLE TOOLING SOLUTIONS

LARGE STATION ADVANTAGES	HP	STANDARD
Compatible with Amada® AITS® System	●	●
Up to 50% more bearing surface to reduce side loading	●	●
Internal and external lubrication	●	●
External keyways at 0°, 90° and 225°	●	●
OEM compatible	●	●
Punches made from premium hardened tool steel	●	●
Optima® coated punches available	●	●
Relieved strippers for maximum grind life	●	●
Made from hardened tool steel for increased durability	●	●
Optima® coated keys for superior wear resistance	●	●
ABS machine lubrication capability	●	●
Fast and simple push button length adjustment	●	●
Push button lock release for quick stripper plate removal	●	



GUIDE ASSEMBLY



PUNCH



STRIPPER



DIE



SHIM

PUNCH AND GUIDE ASSEMBLY	CAT. NO.	PRICE
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Round Assembly	14270i	
Shape Assembly	14264i	

PUNCH	CAT. NO.	PRICE
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Round ABS M14 Thread	13614i	
Shape ABS M14 Thread	13615i	

Optima® Coating

STRIPPER	CAT. NO.	PRICE
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Round ABS	5150i	
Shape ABS	5151i	

DIE	CAT. NO.	PRICE
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Round Slug Hugger®*	2196i	
Round Standard	1850i	
Shape Slug Hugger® 2*	12964i	
Shape Positive	1855i	
Shape Negative	1856i	

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

DIE SHIM	CAT. NO.	PRICE
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.010 [0.25mm] single	2089	
.030 [0.76mm] single	2725	
.060 [1.5mm] single	2092	
.010 [0.25mm] pack of 10	2210	
.030 [0.76mm] pack of 10	2726	
.060 [1.5mm] pack of 10	2174	

Additional charges may apply to non-standard features. See page 56.

DESCRIPTION	MAX A DIMENSION	MAX MATERIAL THICKNESS	NOTES
<p>HP has a push button release for quick stripper plate removal.</p> <p>Guide assemblies are keyed for shapes at 0°, 90° and 225°.</p>	<p>2.000" [50.8mm]</p>	<p>.250" [6.35mm]</p>	<p>All punches shipped with no shear unless specified.</p> <p>Dies are available in Ultima® tool steel upon request.</p>

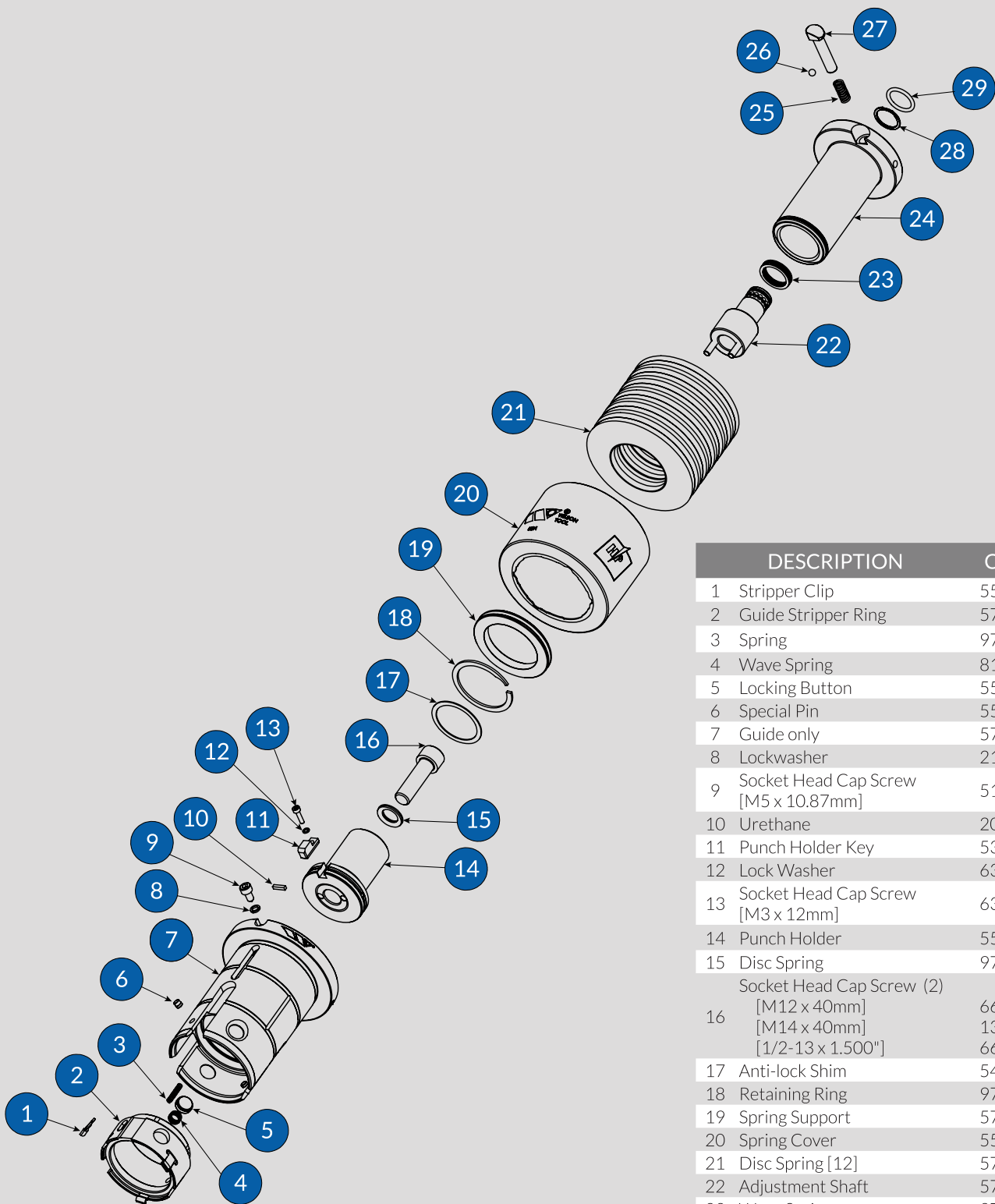
STANDARD SHAPES



HP C STATION REPLACEMENT PARTS



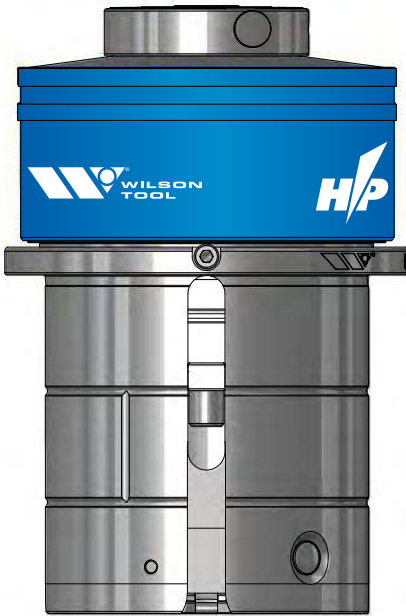
METRIC



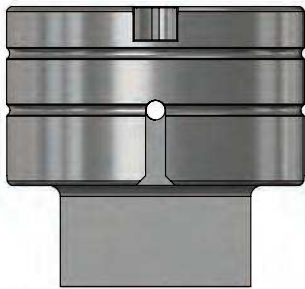
DESCRIPTION	CAT. NO.
1 Stripper Clip	5521
2 Guide Stripper Ring	5780
3 Spring	971694
4 Wave Spring	8155
5 Locking Button	5519
6 Special Pin	5522
7 Guide only	5779
8 Lockwasher	2112
9 Socket Head Cap Screw [M5 x 10.87mm]	5197
10 Urethane	2020643
11 Punch Holder Key	5373
12 Lock Washer	6327
13 Socket Head Cap Screw [M3 x 12mm]	6326
14 Punch Holder	5556
15 Disc Spring	971690
Socket Head Cap Screw (2)	
[M12 x 40mm]	6605
[M14 x 40mm]	13843
[1/2-13 x 1.500"]	6606
17 Anti-lock Shim	5412
18 Retaining Ring	972570
19 Spring Support	5748
20 Spring Cover	5517
21 Disc Spring [12]	5744
22 Adjustment Shaft	5735
23 Wave Spring	971692
24 Punch Driver	5736
25 Spring	972396
26 Adjustment Locking Ball	972420
27 Driver Lock Button	10539
28 Retaining Ring	972441
29 O-Ring	972430

Cat. No. 5782i Guide Unit Assembly includes:
1, 2, 3, 5, 6, 7, 8 & 9

Cat. No. 5724i Driver Assembly includes:
18, 19, 20, 21, 22, 23, 24, 25, 26, 27, 28 & 29



GUIDE ASSEMBLY



PUNCH



STRIPPER



DIE



SHIM

PUNCH AND GUIDE ASSEMBLY	CAT. NO.	PRICE
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Round Assembly	14272i	
Shape Assembly	14266i	

PUNCH	CAT. NO.	PRICE
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Round ABS M14 Thread	13616i	
Shape ABS M14 Thread	13617i	
Optima® Coating		

STRIPPER	CAT. NO.	PRICE
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Round ABS	5152i	
Shape ABS	5153i	

DIE	CAT. NO.	PRICE
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Round Slug Hugger®*	2198i	
Round Standard	1865i	
Shape Slug Hugger® 2*	12965i	
Shape Positive	1870i	
Shape Negative	1871i	

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

DIE SHIM	CAT. NO.	PRICE
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.010 [0.25mm] single	2081	
.030 [0.76mm] single	2727	
.060 [1.5mm] single	2084	
.010 [0.25mm] pack of 5	2211	
.030 [0.76mm] pack of 5	2728	
.060 [1.5mm] pack of 5	2175	

Additional charges may apply to non-standard features. See page 56.

DESCRIPTION	MAX A DIMENSION	MAX MATERIAL THICKNESS	NOTES
<p>HP has a push button release for quick stripper plate removal.</p> <p>Guide assemblies are keyed for shapes at 0°, 90° and 225°.</p>	<p>3.500" [88.9mm]</p>	<p>.250" [6.35mm]</p>	<p>.062" [1.6mm] rooftop shear is given to all punches with 'A' dimension > 2.000" [50.8mm] and width > .250" [6.35mm].</p> <p>Dies available in Ultima® tool steel upon request.</p>

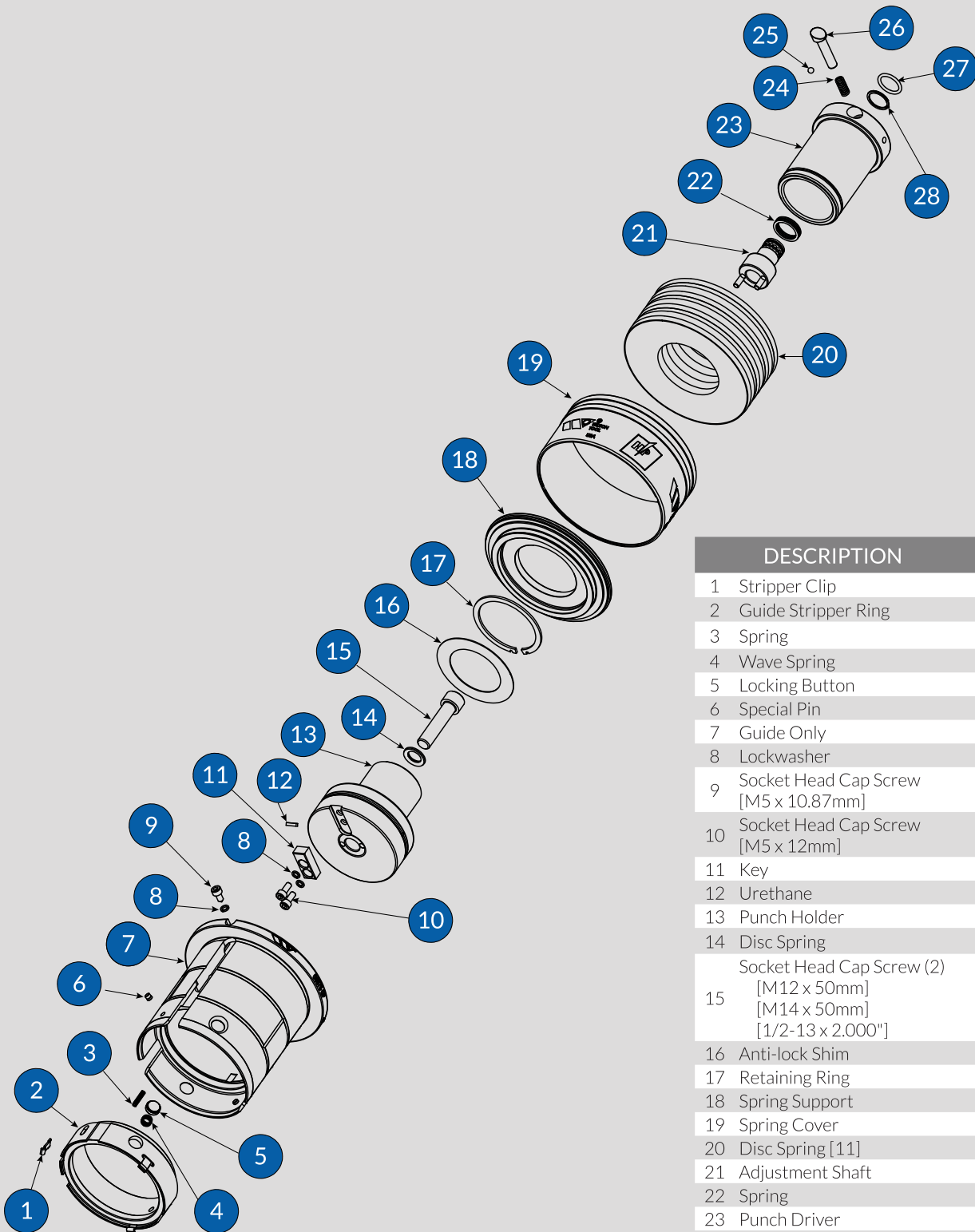
STANDARD SHAPES



HP D STATION REPLACEMENT PARTS



METRIC



Cat. No. 5524i Guide Unit Assembly includes:
1, 2, 3, 5, 6, 7, 8 & 9

Cat. No. 5730i Driver Assembly includes:
17, 18, 19, 20, 21, 22, 23, 24, 25, 26, 27 & 28

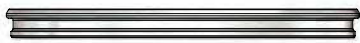
DESCRIPTION	CAT. NO.
1 Stripper Clip	5521
2 Guide Stripper Ring	5528
3 Spring	971694
4 Wave Spring	8155
5 Locking Button	5519
6 Special Pin	5522
7 Guide Only	5527
8 Lockwasher	2112
9 Socket Head Cap Screw [M5 x 10.87mm]	5197
10 Socket Head Cap Screw [M5 x 12mm]	6110
11 Key	1862
12 Urethane	2020643
13 Punch Holder	5556
14 Disc Spring	971690
15 Socket Head Cap Screw (2) [M12 x 50mm] [M14 x 50mm] [1/2-13 x 2.000"]	970467 13844 6325
16 Anti-lock Shim	5413
17 Retaining Ring	5747
18 Spring Support	5748
19 Spring Cover	5561
20 Disc Spring [11]	5449
21 Adjustment Shaft	5739
22 Spring	971692
23 Punch Driver	5740
24 Spring	972396
25 Adjustment Locking Ball	972420
26 Index Button	5737
27 O-Ring	972430
28 Retaining Ring	972441



GUIDE ASSEMBLY



PUNCH



STRIPPER



DIE



SHIM

PUNCH AND GUIDE ASSEMBLY	CAT. NO.	PRICE
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Round Assembly	14274i	
Shape Assembly	14268i	

PUNCH	CAT. NO.	PRICE
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Round ABS M14 Thread	13618i	
Shape ABS M14 Thread	13619i	

Optima® Coating

STRIPPER	CAT. NO.	PRICE
----------	----------	-------

Round ABS	5154i	
Shape ABS	5155i	

DIE	CAT. NO.	PRICE
-----	----------	-------

Round Slug Hugger®*	2200i	
Round Standard	1878i	
Shape Slug Hugger® 2*	12967i	
Shape Positive	1883i	
Shape Negative	1884i	

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

DIE SHIM	CAT. NO.	PRICE
----------	----------	-------

.010 [0.25mm] single	2073	
.030 [0.76mm] single	2729	
.060 [1.5mm] single	2076	
.010 [0.25mm] pack of 5	2212	
.030 [0.76mm] pack of 5	2730	
.060 [1.5mm] pack of 5	2176	

Additional charges may apply to non-standard features. See page 56.

DESCRIPTION	MAX A DIMENSION	MAX MATERIAL THICKNESS	NOTES
<p>HP has a push button release for quick stripper plate removal.</p> <p>Guide assemblies are keyed for shapes at 0°, 90° and 225°.</p>	<p>4.500" [114.3mm]</p>	<p>.250" [6.35mm]</p>	<p>.062" [1.6mm] rooftop shear is given to all punches with 'A' dimension > 2.000" [50.8mm] and width > .250" [6.35mm].</p> <p>Dies available in Ultima® tool steel upon request.</p>

STANDARD SHAPES

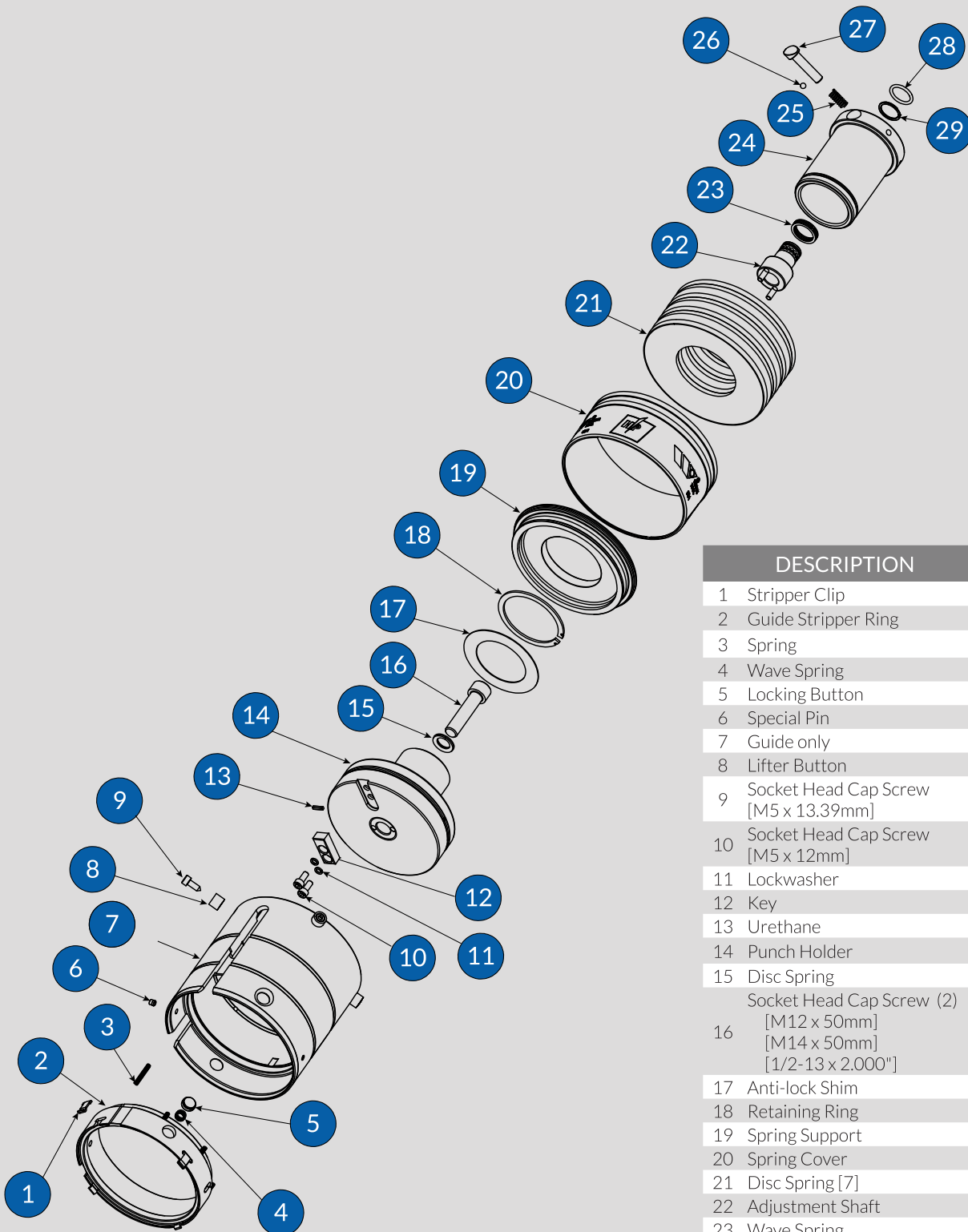


HP E STATION REPLACEMENT PARTS



E

METRIC



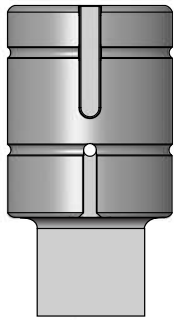
DESCRIPTION	CAT. NO.
1 Stripper Clip	5521
2 Guide Stripper Ring	5528
3 Spring	971694
4 Wave Spring	8155
5 Locking Button	5519
6 Special Pin	5522
7 Guide only	5537
8 Lifter Button	5209
9 Socket Head Cap Screw [M5 x 13.39mm]	5210
10 Socket Head Cap Screw [M5 x 12mm]	6110
11 Lockwasher	2112
12 Key	1862
13 Urethane	2020643
14 Punch Holder	5560
15 Disc Spring	971690
Socket Head Cap Screw (2)	
16 [M12 x 50mm]	970467
[M14 x 50mm]	13844
[1/2-13 x 2.000"]	6325
17 Anti-lock Shim	5413
18 Retaining Ring	5747
19 Spring Support	5741
20 Spring Cover	5561
21 Disc Spring [7]	5449
22 Adjustment Shaft	5739
23 Wave Spring	971692
24 Punch Driver	5742
25 Spring	972396
26 Adjustment Locking Ball	972420
27 Index Button	5737
28 O-Ring	972430
29 Retaining Ring	972441

Cat. No. 5534i Guide Unit Assembly includes:
1, 2, 3, 5, 6, 7, 8 & 9

Cat. No. 5731i Driver Assembly includes:
18, 19, 20, 21, 22, 23, 24, 25, 26, 27, 28 & 29



GUIDE ASSEMBLY



PUNCH



STRIPPER



DIE



SHIM

PUNCH AND GUIDE ASSEMBLY	CAT. NO.	PRICE
--------------------------	----------	-------

Round Assembly	14271i	
Shape Assembly	14265i	

PUNCH	CAT. NO.	PRICE
-------	----------	-------

Round ABS M14 Thread	13614i	
Shape ABS M14 Thread	13615i	

Optima® Coating

STRIPPER	CAT. NO.	PRICE
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Round ABS	5150i	
Shape ABS	5151i	

DIE	CAT. NO.	PRICE
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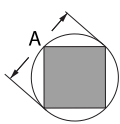
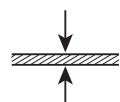
Round Slug Hugger®*	2196i	
Round Standard	1850i	
Shape Slug Hugger® 2*	12964i	
Shape Positive	1855i	
Shape Negative	1856i	

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

DIE SHIM	CAT. NO.	PRICE
----------	----------	-------

.010 [0.25mm] single	2089	
.030 [0.76mm] single	2725	
.060 [1.5mm] single	2092	
.010 [0.25mm] pack of 10	2210	
.030 [0.76mm] pack of 10	2726	
.060 [1.5mm] pack of 10	2174	

Additional charges may apply to non-standard features. See page 56.

DESCRIPTION	MAX A DIMENSION	MAX MATERIAL THICKNESS	NOTES
Standard assembly strippers are held in by a stripper ring or clips. Guide assemblies are keyed for shapes at 0°, 90° and 225°.	2.000" [50.8mm] 	.250" [6.35mm] 	All punches shipped with no shear unless specified. Full assemblies ship with guide stripper ring installed. Spring clips are also included. Dies available in Ultima® tool steel upon request.

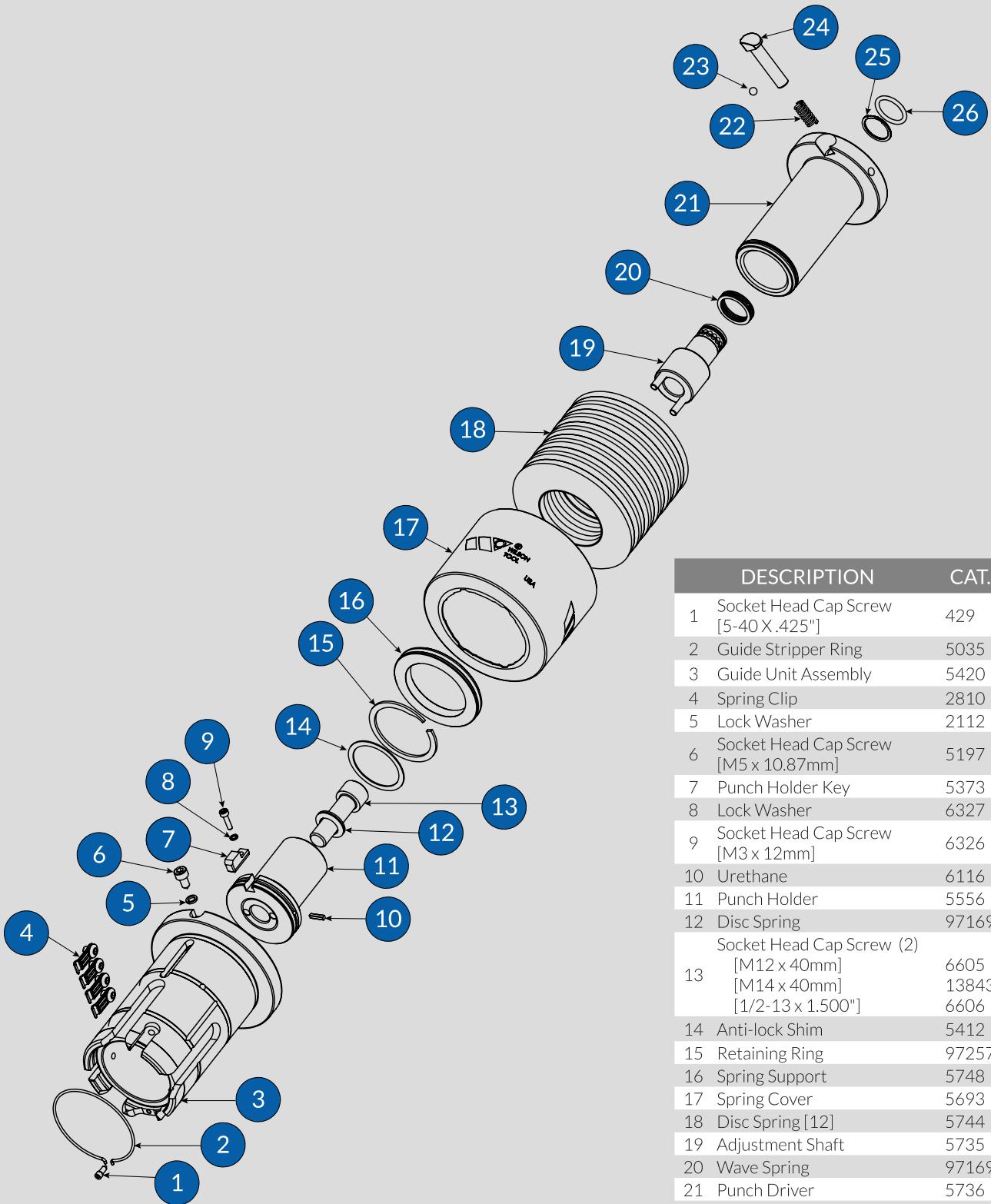
STANDARD SHAPES



STANDARD C STATION REPLACEMENT PARTS



METRIC



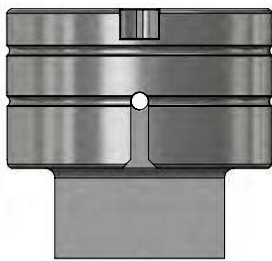
	DESCRIPTION	CAT. NO.
1	Socket Head Cap Screw [5-40 X .425"]	429
2	Guide Stripper Ring	5035
3	Guide Unit Assembly	5420
4	Spring Clip	2810
5	Lock Washer	2112
6	Socket Head Cap Screw [M5 x 10.87mm]	5197
7	Punch Holder Key	5373
8	Lock Washer	6327
9	Socket Head Cap Screw [M3 x 12mm]	6326
10	Urethane	6116
11	Punch Holder	5556
12	Disc Spring	971690
13	Socket Head Cap Screw (2) [M12 x 40mm] [M14 x 40mm] [1/2-13 x 1.500"]	6605 13843 6606
14	Anti-lock Shim	5412
15	Retaining Ring	972570
16	Spring Support	5748
17	Spring Cover	5693
18	Disc Spring [12]	5744
19	Adjustment Shaft	5735
20	Wave Spring	971692
21	Punch Driver	5736
22	Spring	972396
23	Adjustment Locking Ball	972420
24	Driver Lock Button	10539
25	Retaining Ring	972441
26	O-Ring	972430

Cat. No. 5420i Guide Unit Assembly includes:
1, 2, 3, 5, & 6

Cat. NO. 5729i Driver Assembly includes:
14, 15, 16, 17, 18, 19, 20, 21, 22, 23, 24, & 25



GUIDE ASSEMBLY



PUNCH



STRIPPER



DIE



SHIM

PUNCH AND GUIDE ASSEMBLY	CAT. NO.	PRICE
--------------------------	----------	-------

Round Assembly	14273i	
Shape Assembly	14267i	

PUNCH	CAT. NO.	PRICE
-------	----------	-------

Round ABS M14 Thread	13616i	
Shape ABS M14 Thread	13617i	
Optima® Coating		

STRIPPER	CAT. NO.	PRICE
----------	----------	-------

Round ABS	5152i	
Shape ABS	5153i	

DIE	CAT. NO.	PRICE
-----	----------	-------

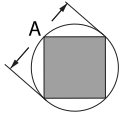
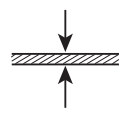
Round Slug Hugger®*	2198i	
Round Standard	1865i	
Shape Slug Hugger® 2*	12965i	
Shape Positive	1870i	
Shape Negative	1871i	

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

DIE SHIM	CAT. NO.	PRICE
----------	----------	-------

.010 [0.25mm] single	2081	
.030 [0.76mm] single	2727	
.060 [1.5mm] single	2084	
.010 [0.25mm] pack of 5	2211	
.030 [0.76mm] pack of 5	2728	
.060 [1.5mm] pack of 5	2175	

Additional charges may apply to non-standard features. See page 56.

DESCRIPTION	MAX A DIMENSION	MAX MATERIAL THICKNESS	NOTES
Standard assembly strippers are held in by a stripper ring or clips. Guide assemblies are keyed for shapes at 0°, 90° and 225°.	3.500" [88.9mm] 	.250" [6.35mm] 	.062" [1.6mm] rooftop shear is given to all punches with 'A' dimension > 2.000" [50.8mm] and width > .250" [6.35mm]. Dies available in Ultima® tool steel upon request.

STANDARD SHAPES

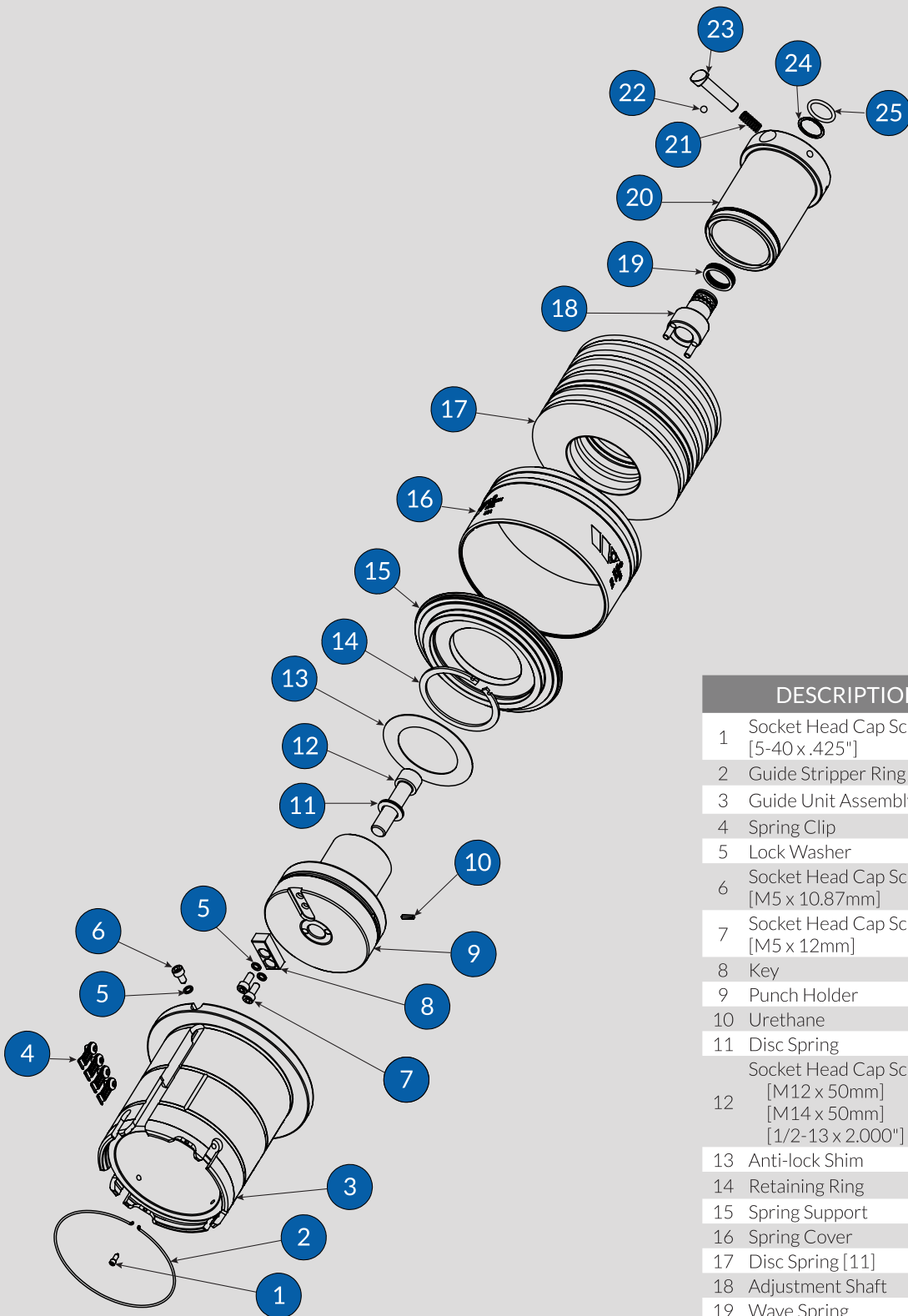


STANDARD D STATION REPLACEMENT PARTS



D

METRIC



Cat. No. 5430i Guide Unit Assembly includes:
1, 2, 3, 5, & 6

Cat. No. 5730i Driver Assembly includes:
14, 15, 16, 17, 18, 19, 20, 21, 22, 23, 24, & 25

	DESCRIPTION	CAT. NO.
1	Socket Head Cap Screw [5-40 x .425"]	429
2	Guide Stripper Ring	5036
3	Guide Unit Assembly	5430
4	Spring Clip	2810
5	Lock Washer	2112
6	Socket Head Cap Screw [M5 x 10.87mm]	5197
7	Socket Head Cap Screw [M5 x 12mm]	6110
8	Key	1862
9	Punch Holder	5558
10	Urethane	6116
11	Disc Spring	971690
	Socket Head Cap Screw (2)	
12	[M12 x 50mm]	970467
	[M14 x 50mm]	13844
	[1/2-13 x 2.000"]	6325
13	Anti-lock Shim	5413
14	Retaining Ring	5747
15	Spring Support	5738
16	Spring Cover	5423
17	Disc Spring [11]	5449
18	Adjustment Shaft	5739
19	Wave Spring	971692
20	Punch Driver	5740
21	Spring	972396
22	Adjustment Locking Ball	972420
23	Index Button	5737
24	Retaining Ring	972441
25	O-Ring	972430



GUIDE ASSEMBLY



PUNCH



STRIPPER



DIE

SHIM

PUNCH AND GUIDE ASSEMBLY	CAT. NO.	PRICE
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Round Assembly	14275i	
Shape Assembly	14269i	

PUNCH	CAT. NO.	PRICE
-------	----------	-------

Round ABS M14 Thread	13618i	
Shape ABS M14 Thread	13619i	
Optima® Coating		

STRIPPER	CAT. NO.	PRICE
----------	----------	-------

Round ABS	5154i	
Shape ABS	5155i	

DIE	CAT. NO.	PRICE
-----	----------	-------

Round Slug Hugger®*	2200i	
Round Standard	1878i	
Shape Slug Hugger® 2*	12967i	
Shape Positive	1883i	
Shape Negative	1884i	

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

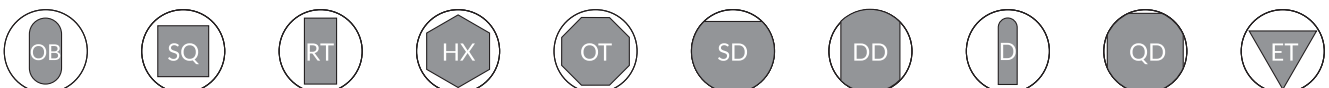
DIE SHIM	CAT. NO.	PRICE
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.010 [0.25mm] single	2073	
.030 [0.76mm] single	2729	
.060 [1.5mm] single	2076	
.010 [0.25mm] pack of 5	2212	
.030 [0.76mm] pack of 5	2730	
.060 [1.5mm] pack of 5	2176	

Additional charges may apply to non-standard features. See page 56.

DESCRIPTION	MAX A DIMENSION	MAX MATERIAL THICKNESS	NOTES
Standard assembly strippers are held in by a stripper ring or clips. Guide assemblies are keyed for shapes at 0°, 90° and 225°.	4.500" [114.3mm] 	.250" [6.35mm] 	.062" [1.6mm] rooftop shear is given to all punches with 'A' dimension > 2.000" [50.8mm] and width > .250" [6.35mm]. Dies available in Ultima® tool steel upon request.

STANDARD SHAPES

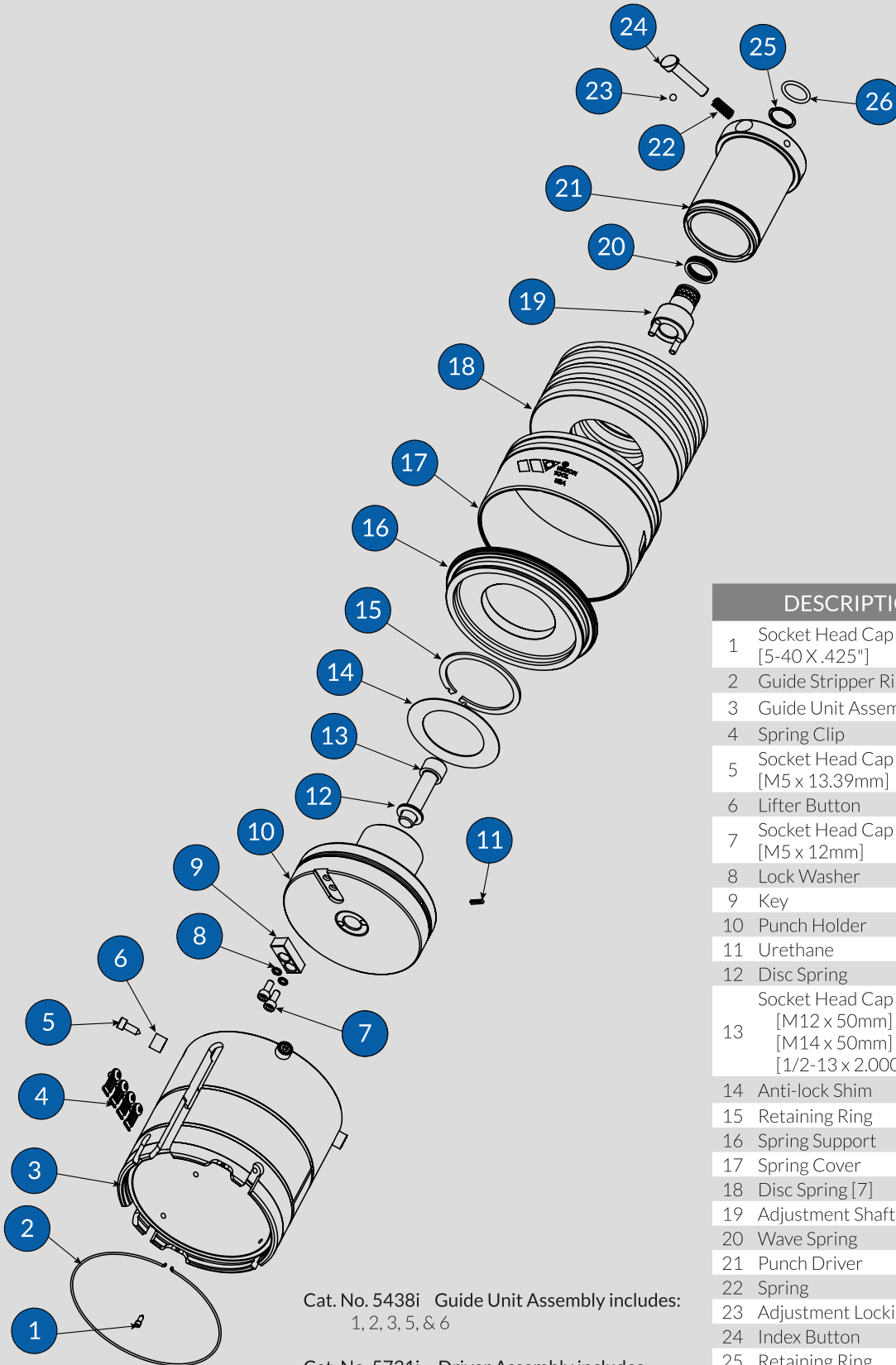


STANDARD E STATION REPLACEMENT PARTS



E

METRIC



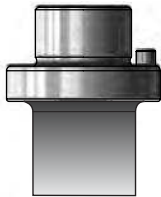
Cat. No. 5438i Guide Unit Assembly includes:
1, 2, 3, 5, & 6

Cat. No. 5731i Driver Assembly includes:
18, 19, 20, 21, 22, 23, 24, 25 & 26

	DESCRIPTION	CAT. NO.
1	Socket Head Cap Screw [5-40 X .425"]	429
2	Guide Stripper Ring	5037
3	Guide Unit Assembly	5438
4	Spring Clip	2810
5	Socket Head Cap Screw [M5 x 13.39mm]	5210
6	Lifter Button	5209
7	Socket Head Cap Screw [M5 x 12mm]	6110
8	Lock Washer	2112
9	Key	1862
10	Punch Holder	5560
11	Urethane	6116
12	Disc Spring	971690
13	Socket Head Cap Screw (2) [M12 x 50mm] [M14 x 50mm] [1/2-13 x 2.000"]	970467 13844 6325
14	Anti-lock Shim	5413
15	Retaining Ring	5747
16	Spring Support	5741
17	Spring Cover	5423
18	Disc Spring [7]	5449
19	Adjustment Shaft	5739
20	Wave Spring	971692
21	Punch Driver	5742
22	Spring	972396
23	Adjustment Locking Ball	972420
24	Index Button	5737
25	Retaining Ring	972441
26	O-Ring	972430



GUIDE ASSEMBLY



PUNCH



STRIPPER



DIE



SHIM

PUNCH AND GUIDE ASSEMBLY	CAT. NO.	PRICE
Round ABS /WLS Assembly	5769i	
Shape ABS /WLS Assembly	5768i	

PUNCH	CAT. NO.	PRICE
Round	5026i	
Shape	5025i	
Optima® Coating		

HEAVY DUTY PUNCH	CAT. NO.	PRICE
Round .500-1.250 [12.7 - 31.75mm]	5117i	
Round 1.251 - 1.625 [31.77 - 41.27mm]	5120i	
Shape .500-1.250 [12.7 - 31.75mm]	5118i	
Shape 1.251 - 1.625 [31.77 - 41.27mm]	5119i	

STRIPPER	CAT. NO.	PRICE
Round ABS	5150i	
Shape ABS	5151i	

DIE	CAT. NO.	PRICE
Round Slug Hugger®*	2196i	
Round Standard	1850i	
Shape Slug Hugger® 2*	12964i	
Shape Positive	1855i	
Shape Negative	1856i	

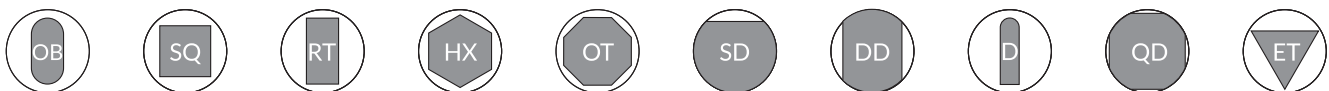
* Slug Hugger dies must be ordered punch size plus clearance. Size restrictions apply.

DIE SHIM	CAT. NO.	PRICE
.010 [0.25mm] single	2089	
.030 [0.76mm] single	2725	
.060 [1.5mm] single	2092	
.010 [0.25mm] pack of 10	2210	
.030 [0.76mm] pack of 10	2726	
.060 [1.5mm] pack of 10	2174	

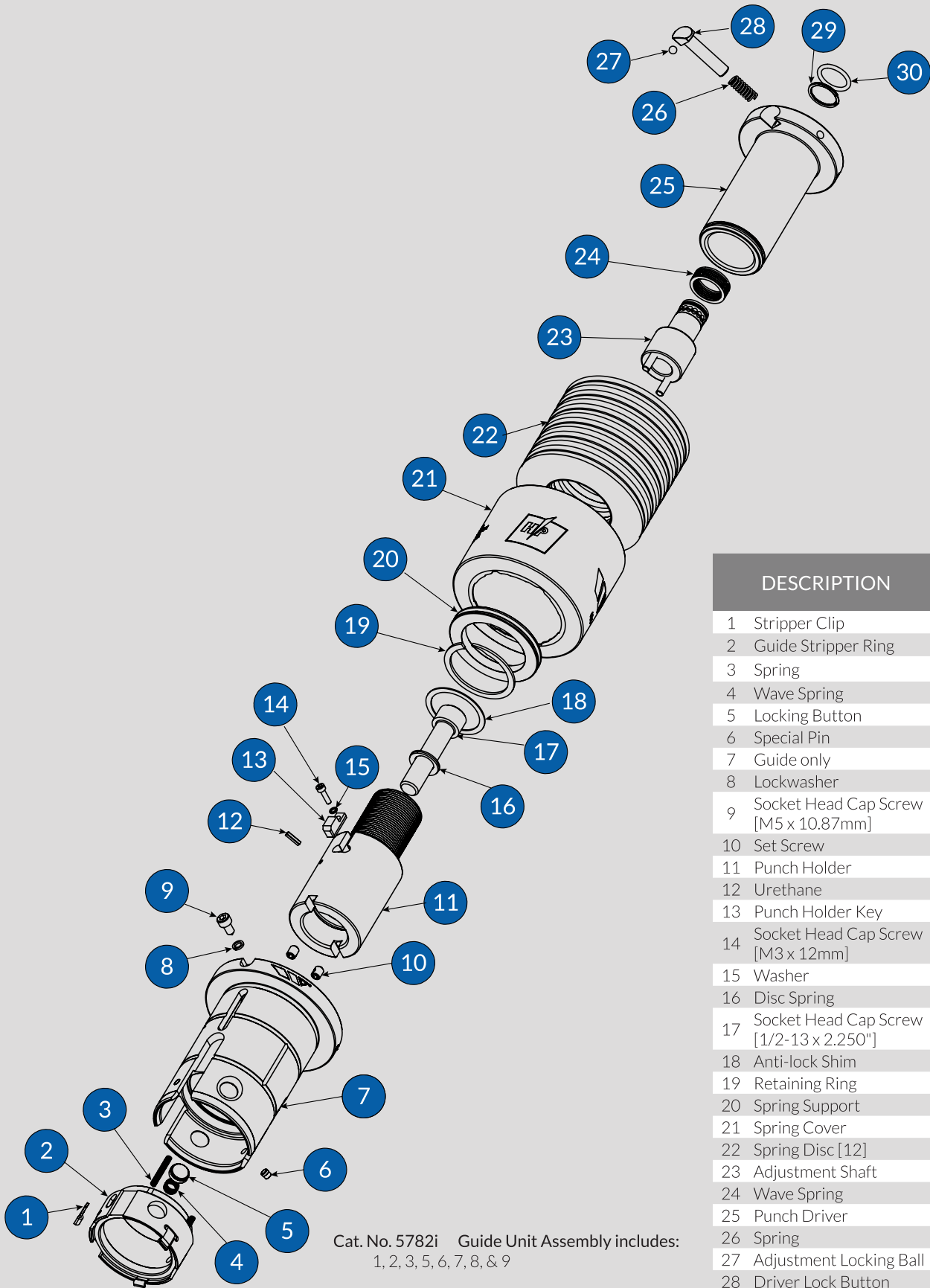
Additional charges may apply to non-standard features. See page 56.

DESCRIPTION	MAX A DIMENSION	MAX MATERIAL THICKNESS	NOTES
Guide assemblies achieve angles of 0°, 45°, 90°, 180°, 225° and 270°.	2.000" [50.8mm] 	.250" [6.35mm] 	All punches will be shipped with no shear, unless specified. Use heavy duty punches for material thickness > .250" [6.35mm]. HP punches and dies are available in Ultima tool steel upon request.

STANDARD SHAPES



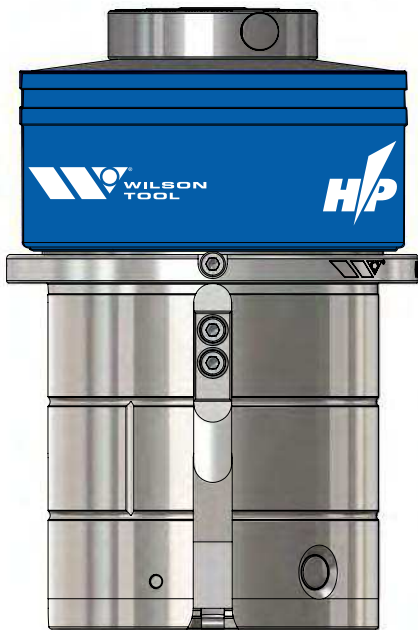
WILSON HP C STATION REPLACEMENT PARTS



Cat. No. 5782i Guide Unit Assembly includes:
1, 2, 3, 5, 6, 7, 8, & 9

Cat. No. 5724i Driver Assembly includes:
19, 20, 21, 22, 23, 24, 25, 26, 27, 28, 29 & 30

DESCRIPTION	CAT. NO.
1 Stripper Clip	5521
2 Guide Stripper Ring	5780
3 Spring	971694
4 Wave Spring	8155
5 Locking Button	5519
6 Special Pin	5522
7 Guide only	5579
8 Lockwasher	2112
9 Socket Head Cap Screw [M5 x 10.87mm]	5197
10 Set Screw	6298
11 Punch Holder	5510
12 Urethane	2020643
13 Punch Holder Key	5373
14 Socket Head Cap Screw [M3 x 12mm]	6326
15 Washer	6327
16 Disc Spring	971690
17 Socket Head Cap Screw [1/2-13 x 2.250"]	6002
18 Anti-lock Shim	5412
19 Retaining Ring	972570
20 Spring Support	5748
21 Spring Cover	5517
22 Spring Disc [12]	5744
23 Adjustment Shaft	5735
24 Wave Spring	971692
25 Punch Driver	5736
26 Spring	972396
27 Adjustment Locking Ball	972420
28 Driver Lock Button	10539
29 Retaining Ring	972441
30 O-Ring [.687 x .094"]	972430



GUIDE ASSEMBLY



PUNCH

STRIPPER

DIE

SHIM

PUNCH AND GUIDE ASSEMBLY	CAT. NO.	PRICE
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Round ABS/WLS Assembly	5771i	
Shape ABS/WLS Assembly	5770i	

PUNCH	CAT. NO.	PRICE
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Round	5028i	
Shape	5027i	
Optima® Coating		

STRIPPER	CAT. NO.	PRICE
----------	----------	-------

Round ABS	5152i	
Shape ABS	5153i	

DIE	CAT. NO.	PRICE
-----	----------	-------

Round Slug Hugger®*	2198i	
Round Standard	1865i	
Shape Slug Hugger® 2*	12965i	
Shape Positive	1870i	
Shape Negative	1871i	

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

DIE SHIM	CAT. NO.	PRICE
----------	----------	-------

.010 [0.25mm] single	2081	
.030 [0.76mm] single	2727	
.060 [1.5mm] single	2084	
.010 [0.25mm] pack of 5	2211	
.030 [0.76mm] pack of 5	2728	
.060 [1.5mm] pack of 5	2175	

Additional charges may apply to non-standard features. See page 56.

DESCRIPTION	MAX A DIMENSION	MAX MATERIAL THICKNESS	NOTES
Guide assemblies achieve angles of 0°, 45°, 90°, 180°, 225° and 270°.	3.500" [88.9mm] 	.250" [6.35mm] 	.062" [1.6mm] rooftop shear is given to all punches with 'A' dimension > 2.000" [50.8mm] and width > .250" [6.35mm]. Ultima® Premium tool steel available for punches and dies.

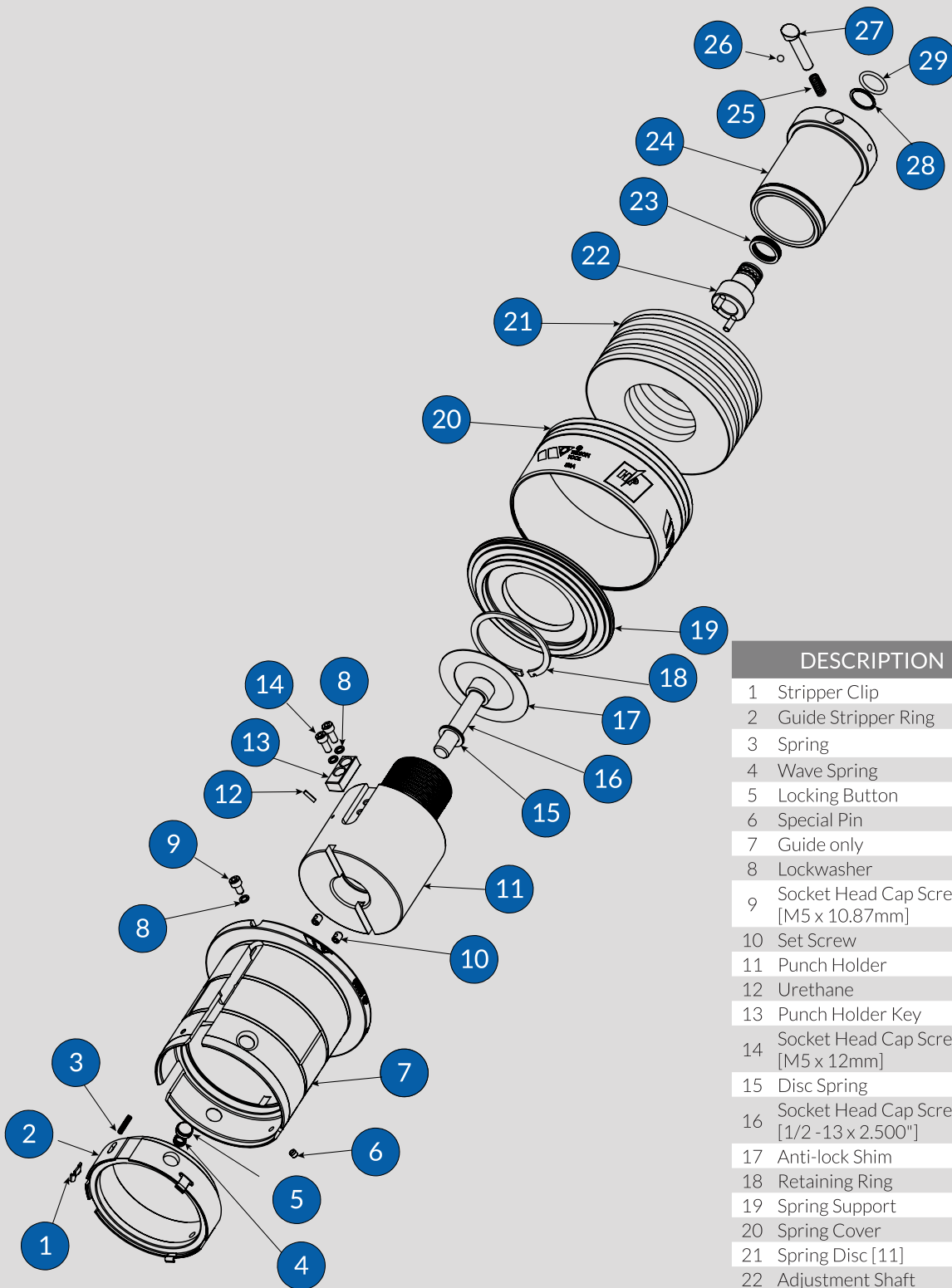
STANDARD SHAPES



WILSON HP D STATION REPLACEMENT PARTS



WILSON



	DESCRIPTION	CAT. NO.
1	Stripper Clip	5521
2	Guide Stripper Ring	5528
3	Spring	971694
4	Wave Spring	8155
5	Locking Button	5519
6	Special Pin	5522
7	Guide only	5527
8	Lockwasher	2112
9	Socket Head Cap Screw [M5 x 10.87mm]	5197
10	Set Screw	6298
11	Punch Holder	5525
12	Urethane	2020643
13	Punch Holder Key	1862
14	Socket Head Cap Screw [M5 x 12mm]	6110
15	Disc Spring	971690
16	Socket Head Cap Screw [1/2 -13 x 2.500"]	6566
17	Anti-lock Shim	5413
18	Retaining Ring	5747
19	Spring Support	5738
20	Spring Cover	5561
21	Spring Disc [11]	5449
22	Adjustment Shaft	5739
23	Wave Spring	971692
24	Punch Driver	5740
25	Spring	972396
26	Adjustment Locking Ball	972420
27	Index Button	5737
28	Retaining Ring	972441
29	O-Ring	972430

Cat. No. 5524i Guide Unit Assembly includes:
1, 2, 3, 5, 6, 7, 8, & 9

Cat. No. 5725i Driver Assembly includes:
19, 20, 21, 22, 23, 24, 25, 26, 27, 28, 29 & 30



GUIDE ASSEMBLY

PUNCH AND GUIDE ASSEMBLY CAT. NO. PRICE

Round ABS/WLS Assembly	5773i	
Shape ABS/WLS Assembly	5772i	

PUNCH CAT. NO. PRICE

Round	5030i	
Shape	5029i	
Optima® Coating		

STRIPPER CAT. NO. PRICE

Round ABS	5154i	
Shape ABS	5155i	

DIE CAT. NO. PRICE

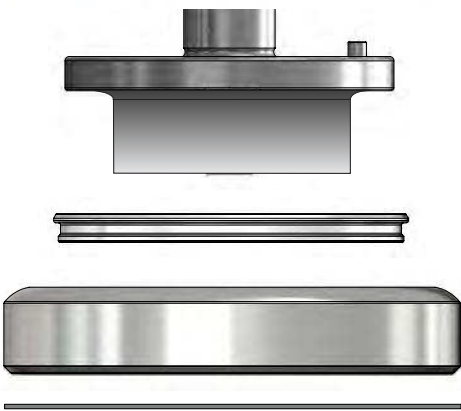
Round Slug Hugger®*	2200i	
Round Standard	1878i	
Shape Slug Hugger® 2*	12967i	
Shape Positive	1883i	
Shape Negative	1884i	

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

DIE SHIM CAT. NO. PRICE

.010 [0.25mm]	single	2073
.030 [0.76mm]	single	2729
.060 [1.5mm]	single	2076
.010 [0.25mm]	pack of 5	2212
.030 [0.76mm]	pack of 5	2730
.060 [1.5mm]	pack of 5	2176

Additional charges may apply to non-standard features. See page 56.



PUNCH

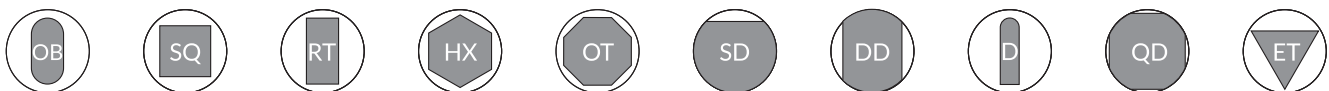
STRIPPER

DIE

SHIM

DESCRIPTION	MAX A DIMENSION	MAX MATERIAL THICKNESS	NOTES
Guide assemblies achieve angles of 0°, 45°, 90°, 180°, 225° and 270°.	4.500" [114.3mm] 	.250" [6.35mm] 	.062" [1.6mm] rooftop shear is given to all punches with 'A' dimension > 2.000" [50.8mm] and width > .250" [6.35mm]. Ultima® Premium tool steel available for punches and dies.

STANDARD SHAPES

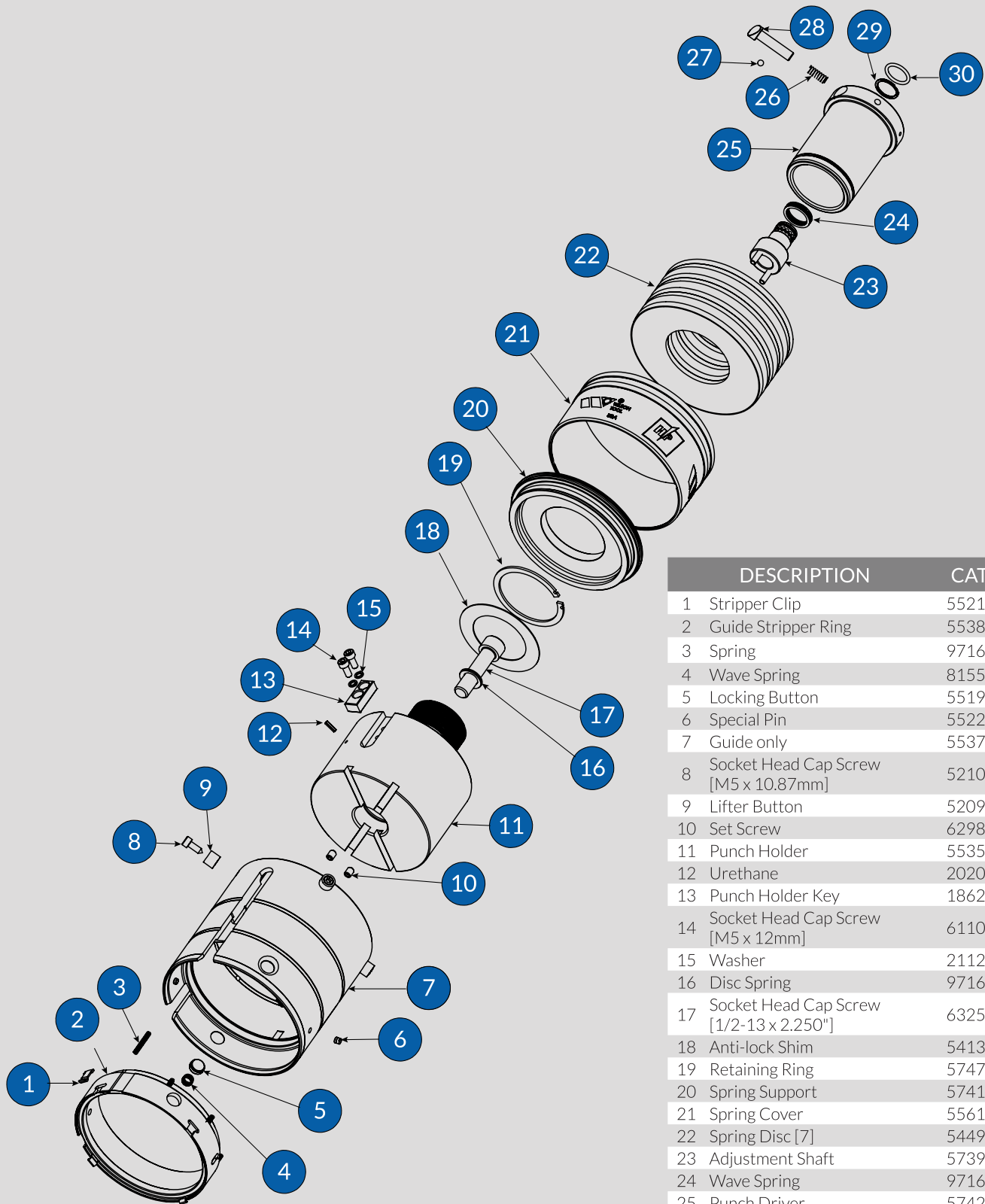


WILSON HP E STATION REPLACEMENT PARTS



E

WILSON



	DESCRIPTION	CAT. NO.
1	Stripper Clip	5521
2	Guide Stripper Ring	5538
3	Spring	971694
4	Wave Spring	8155
5	Locking Button	5519
6	Special Pin	5522
7	Guide only	5537
8	Socket Head Cap Screw [M5 x 10.87mm]	5210
9	Lifter Button	5209
10	Set Screw	6298
11	Punch Holder	5535
12	Urethane	2020643
13	Punch Holder Key	1862
14	Socket Head Cap Screw [M5 x 12mm]	6110
15	Washer	2112
16	Disc Spring	971690
17	Socket Head Cap Screw [1/2-13 x 2.250"]	6325
18	Anti-lock Shim	5413
19	Retaining Ring	5747
20	Spring Support	5741
21	Spring Cover	5561
22	Spring Disc [7]	5449
23	Adjustment Shaft	5739
24	Wave Spring	971692
25	Punch Driver	5742
26	Spring	972396
27	Adjustment Locking Ball	972420
28	Index Button	5737
29	Retaining Ring	972441
30	O-Ring	972430

Cat. No. 5534i Guide Unit Assembly includes:
1, 2, 3, 5, 6, 7, 8, & 9

Cat. No. 5726i Driver Assembly includes:
19, 20, 21, 22, 23, 24, 25, 26, 27, 28, 29 & 30

ULTIMA® PREMIUM TOOL STEEL IMPROVES DURABILITY AND PERFORMANCE

Available exclusively from Wilson Tool, this advanced steel is engineered to increase wear resistance by up to an astounding 100% over conventional tool steels.

A New Level of Performance

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

Remarkable Downtime Reductions

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

Ultima premium steel punches and dies are especially useful for the toughest applications, but are effective for any job.



EXP punches shown

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 the HP DuraBlade® and Dura-Die parting products specifically to maximize your productivity for these applications.

HP DuraBlade features a simple push button adjustment and replaceable cutting blade insert made with Ultima® premium tool steel to significantly increase grind life. The punch blades are supplied flat, or with rooftop shear upon request at no additional charge.





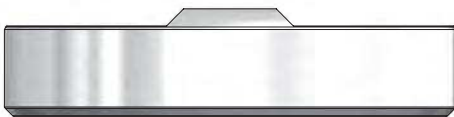
GUIDE ASSEMBLY



PUNCH



STRIPPER

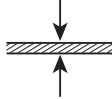


DIE



SHIM

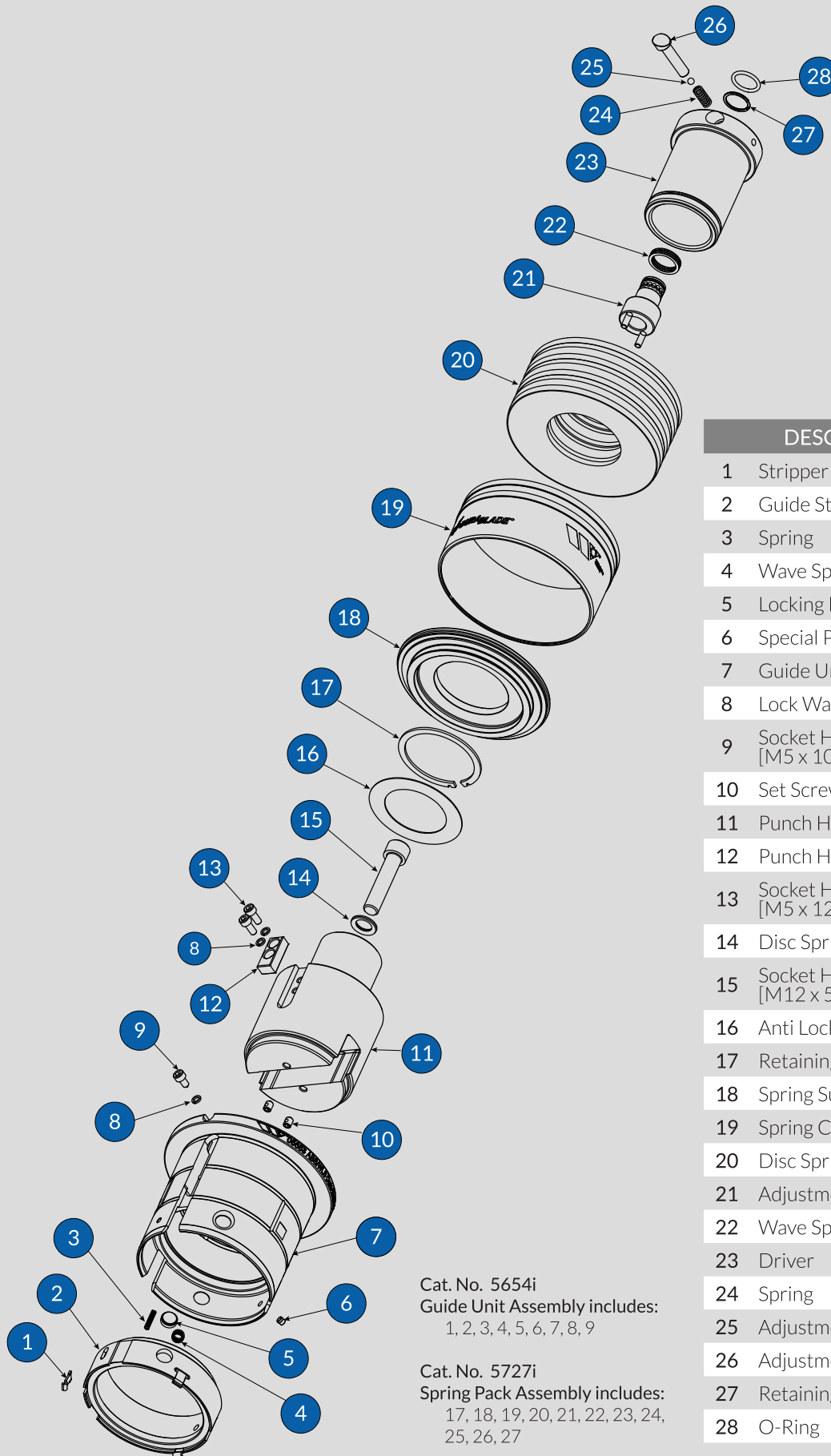
PUNCH AND GUIDE ASSEMBLY	CAT. NO.	PRICE
Assembly ABS/WLS - 2 Sided Relief	5766i	
Assembly ABS/WLS - 1 Sided Relief	5774i	
PUNCH	CAT. NO.	PRICE
Punch Blade Optima® Coating	5657i	
STRIPPER	CAT. NO.	PRICE
ABS 2-Sided Relief	5664i	
ABS 1-Sided Relief	5666i	
DIE	CAT. NO.	PRICE
Slug Hugger® 2* (relief 2 sides, shape at 90°)	5499i	
Slug Hugger® 2* (relief 2 sides, shape at 0°-90°)	5500i	
Slug Hugger® 2* (relief 1 side, shape at 90°)	12966i	
Slug Hugger® 2* (relief 1 side, shape at 0°-90°)	5501i	
Positive (relief 2 sides, shape at 90°)	5101i	
Positive (relief 2 sides, shape at 0°-90°)	5328i	
Positive (relief 1 side, shape at 90°)	2462i	
Positive (relief 1 side, shape at 0°-90°)	5331i	
Negative (relief 2 sides, shape at 90°)	5156i	
Negative (relief 2 sides, shape at 0°-90°)	5329i	
Negative (relief 1 side, shape at 90°)	2463i	
Negative (relief 1 side, shape at 0°-90°)	5332i	
* Slug Hugger dies must be ordered punch size plus clearance. Size restrictions apply.		
DIE SHIM	CAT. NO.	PRICE
.010 [0.25mm] single	2081	
.030 [0.76mm] single	2727	
.060 [1.5mm] single	2084	
.010 [0.25mm] pack of 5	2211	
.030 [0.76mm] pack of 5	2728	
.060 [1.5mm] pack of 5	2175	

DESCRIPTION	MAX WIDTH FOR BLADE INSERT	MAX. MATERIAL THICKNESS	NOTES
HP DuraBlade® guide assemblies are keyed for shapes at 0°, 45° and 90°. Punch blades are Ultima® Premium tool steel.	.750" [19.05mm]	.250" [6.35mm] 	Ultima® Premium tool steel is available on dies.

HP DURABLADE® D STATION REPLACEMENT PARTS



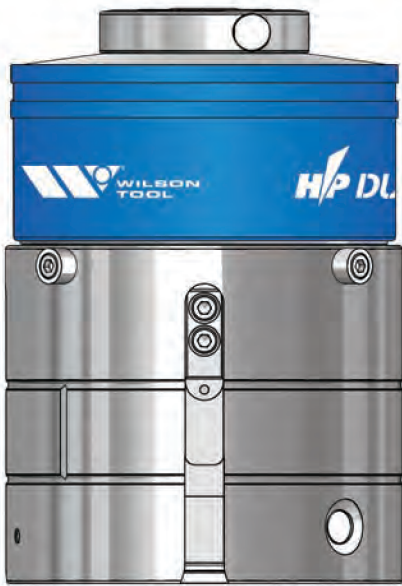
PARTING TOOL



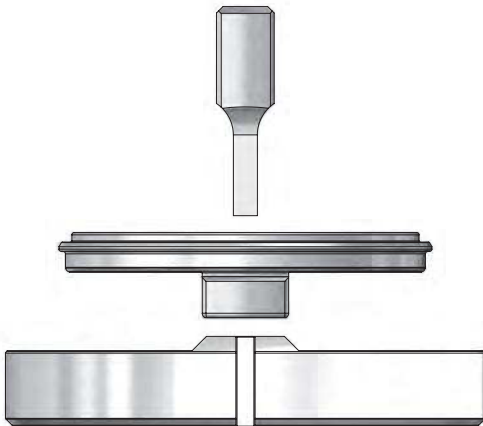
Cat. No. 5654i
 Guide Unit Assembly includes:
 1, 2, 3, 4, 5, 6, 7, 8, 9

Cat. No. 5727i
 Spring Pack Assembly includes:
 17, 18, 19, 20, 21, 22, 23, 24,
 25, 26, 27

	DESCRIPTION	CAT. NO.
1	Stripper Clip	5521
2	Guide Stripper Ring	5528
3	Spring	971694
4	Wave Spring	8155
5	Locking Button	5519
6	Special Pin	5522
7	Guide Unit Only	5659
8	Lock Washer	2112
9	Socket Head Cap Screw [M5 x 10.87mm]	5197
10	Set Screw [M6 x 8mm]	6298
11	Punch Holder with Bushing	5655
12	Punch Holder Key	1862
13	Socket Head Cap Screw [M5 x 12mm]	6110
14	Disc Spring	971690
15	Socket Head Cap Screw [M12 x 55mm]	6026
16	Anti Lock Shim	5413
17	Retaining Ring	5747
18	Spring Support	5738
19	Spring Cover	5679
20	Disc Spring [11]	5449
21	Adjustment Shaft	5739
22	Wave Spring	971692
23	Driver	5740
24	Spring	972396
25	Adjustment Locking Ball	972420
26	Adjustment Button	5737
27	Retaining Ring	972441
28	O-Ring	972430



GUIDE ASSEMBLY



PUNCH

STRIPPER

DIE

SHIM

PUNCH AND GUIDE ASSEMBLY	CAT. NO.	PRICE
Assembly ABS /WLS - 2 Sided Relief	5767i	
Assembly ABS /WLS - 1 Sided Relief	5776i	

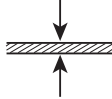
PUNCH	CAT. NO.	PRICE
Punch Blade	5630i	
Optima® Coating		

STRIPPER	CAT. NO.	PRICE
ABS 2-Sided Relief	5640i	
ABS 1-Sided Relief	5642i	

DIE	CAT. NO.	PRICE
Slug Hugger® 2* (relief 2 sides, shape at 90°)	5502i	
Slug Hugger® 2* (relief 2 sides, shape at 0°-90°)	5503i	
Slug Hugger® 2* (relief 1 side, shape at 90°)	12968i	
Slug Hugger® 2* (relief 1 side, shape at 0°-90°)	5504i	
Positive (relief 2 sides, shape at 90°)	5095i	
Positive (relief 2 sides, shape at 0°-90°)	5338i	
Positive (relief 1 side, shape at 90°)	2465i	
Positive (relief 1 side, shape at 0°-90°)	5341i	
Negative (relief 2 sides, shape at 90°)	5158i	
Negative (relief 2 sides, shape at 0°-90°)	5339i	
Negative (relief 1 side, shape at 90°)	2466i	
Negative (relief 1 side, shape at 0°-90°)	5342i	

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

DIE SHIM	CAT. NO.	PRICE
.010 [0.25mm] single	2073	
.030 [0.76mm] single	2729	
.060 [1.5mm] single	2076	
.010 [0.25mm] pack of 5	2212	
.030 [0.76mm] pack of 5	2730	
.060 [1.5mm] pack of 5	2176	

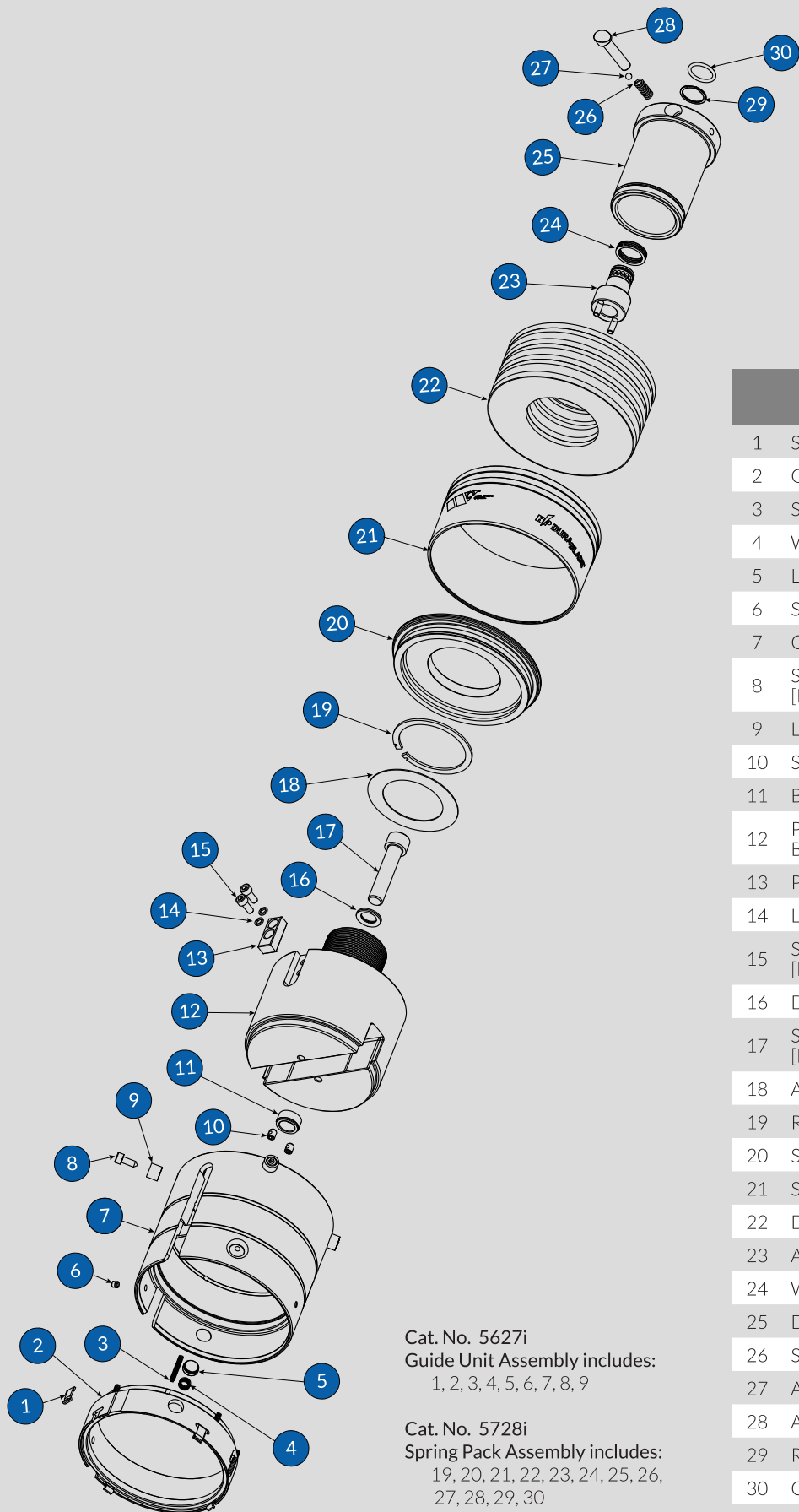
DESCRIPTION	MAX WIDTH FOR BLADE INSERT	MAX. MATERIAL THICKNESS	NOTES
HP DuraBlade® guide assemblies are keyed for shapes at 0°, 45° and 90°. Punch blades are Ultima® Premium tool steel.	.750" [19.05mm]	.250" [6.35mm] 	Ultima® Premium tool steel is available on dies.

HP DURABLADE® E STATION REPLACEMENT PARTS



E

PARTING TOOL



DESCRIPTION	CAT. NO.
1 Stripper Clip	5521
2 Guide Stripper Ring	5538
3 Spring	971694
4 Wave Spring	8155
5 Locking Button	5519
6 Special Pin	5522
7 Guide Unit Only	5632
8 Socket Head Cap Screw [M5 x 13.39mm]	5210
9 Lifter Button	5209
10 Set Screw [M6 x 8mm]	6298
11 Bushing	5631
12 Punch Holder with Bushing	5628
13 Punch Holder Key	1862
14 Lock Washer	2112
15 Socket Head Cap Screw [M5 x 12mm]	6110
16 Disc Spring	971690
17 Socket Head Cap Screw [M12 x 55mm]	6026
18 Anti Lock Shim	5413
19 Retaining Ring	5747
20 Spring Support	5741
21 Spring Cover	5679
22 Disc Spring [7]	5449
23 Adjustment Shaft	5739
24 Wave Spring	971692
25 Driver	5742
26 Spring	972396
27 Adjustment Locking Ball	972420
28 Adjustment Button	5737
29 Retaining Ring	972441
30 O-Ring	972430

Cat. No. 5627i
 Guide Unit Assembly includes:
 1, 2, 3, 4, 5, 6, 7, 8, 9

Cat. No. 5728i
 Spring Pack Assembly includes:
 19, 20, 21, 22, 23, 24, 25, 26,
 27, 28, 29, 30

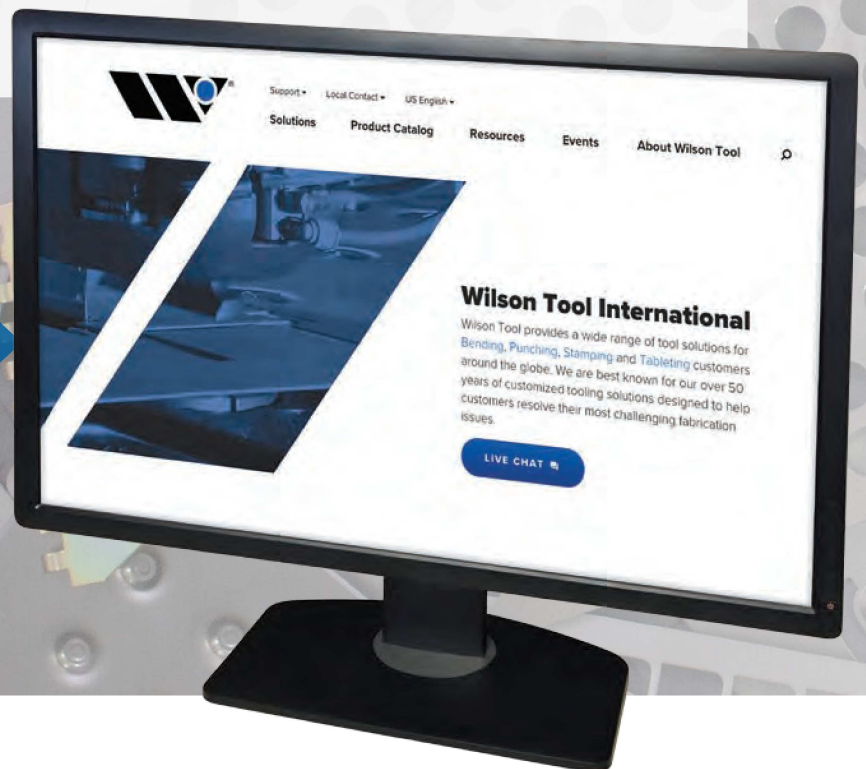
EDUCATIONAL OPPORTUNITIES

TOOLS FOR YOUR SUCCESS

While this catalog certainly contains many of the physical tools you may need to be successful, we at Wilson Tool also equip you with a variety of educational opportunities that are designed to help drive your success.

We encourage you to take advantage of the many free resources offered by some of our leading technical experts covering a wide variety of topics.

For more information about our educational opportunities, ask your Sales Engineer or visit WILSONTOOL.COM



PROBLEM SOLVING NEWSLETTERS



Sign up for our e-newsletters, which deliver troubleshooting articles, application tips and tricks, industry highlights and more to your email inbox.

EDUCATIONAL WEBINARS



Designed to help resolve specific fabrication and stamping issues, our webinars offer practical material to help solve real-world problems. And they are recorded so if you miss a live event, you can always go back and view the recording later.

IN-PERSON SEMINARS



From seminars on implementing a Lean program at your facility to Fabrication Forums that offer an entire day of solution-based content, our seminars always receive high marks from the attendees for not only the information provided but also in the way it is presented.

MAGNET SQUARE

Press Brake Compatible
Punch Press Compatible



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

Cat. No. 974150

EXP® PUNCH REMOVAL KEY

Press Brake Compatible
Punch Press Compatible



This wrench is designed for
use with EXP punches.

Cat. No. 6989

OIL STONE

Press Brake Compatible
Punch Press Compatible



3-sided aluminum oxide
sharpening stone.

Cat. No. 6060

DIAMOND FILE

Press Brake Compatible
Punch Press Compatible



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

Cat. No. 6059

T-HANDLE EXTRACTOR

Press Brake Compatible
Punch Press Compatible



Used for large station guide
assemblies.

Cat. No. 6483

SAE HEX KEY WRENCH SET

Press Brake Compatible
Punch Press Compatible



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" and 3/8".

Cat. No. 6057

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.

Cat. No. 6105



METRIC HEX KEY WRENCH SET

Press Brake Compatible
Punch Press Compatible

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

Cat. No. 6106



SOFT FACE HAMMER

Press Brake Compatible
Punch Press Compatible

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

Cat. No. 6056



TRU-ARC PLIERS

Press Brake Compatible
Punch Press Compatible

Adjustable 'c' hook wrench for
removing B Station Thick Turret
and 1/4" Station Thin Turret/
Strippit punch heads.

Cat. No. 6058



SPANNER WRENCH

Press Brake Compatible
Punch Press Compatible

TOOL KIT

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

Cat. No. 6091



TOOL KIT

Press Brake Compatible
Punch Press Compatible

DIGITAL ANGLE CUBE

Press Brake Compatible
Punch Press Compatible



The compact size of the Digital Cube allows you to quickly read bend angles of work material.

- Real time display of angle comparison
- Magnets on three sides
- Self rotating display for 180° readings

Cat. No. 974119

DIGITAL PROTRACTOR SET

Press Brake Compatible
Punch Press Compatible



Lightweight, easy-to-use, highly accurate protractors measure angles from 0° to 360°.

- Accuracy: ± .01 degree
- Set angles in .05 degree increments
- Front locking lever to hold the arm position
- Hold function and reverse reading capability

Cat. No. 980065

DIGITAL THICKNESS GAUGE

Press Brake Compatible
Punch Press Compatible



- Compact size with spring loaded jaw mechanism
- Accuracy to 0.002"
- Readings in millimeters, inches and fractions

Cat. No. 974117

ZIP-MAR ADHESIVE DISCS

Press Brake Compatible
Punch Press Compatible

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



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

One tool is required to align each station.

STATION	UPPER CAT. NO	LOWER CAT. NO
A [1/2"]	2597	2598
B [1-1/4"]	2599	495



SINGLE TRACK MACHINE ALIGNMENT TOOLS

Press Brake Compatible
Punch Press Compatible

Two tools are required to align each station – one in front of the station and one in back.

STATION	CAT. NO
A [1/2"]	2601
B [1-1/4"]	2602



MULTIPLE TRACK MACHINE ALIGNMENT TOOLS

Press Brake Compatible
Punch Press Compatible

One tool is required to align each station.

STATION	UPPER CAT. NO	LOWER CAT. NO
C [2"]	1840	1841
D [3-1/2"]	1947	1948
E [4-1/2"]	1949	1950
F [6"]	2290	2291



ALIGNMENT TOOLS

Press Brake Compatible
Punch Press Compatible

A **Ball riding die** consists of a spring loaded ball designed to help eliminate sheet hang-up from material running into a higher die, sheet deformation from punching next to dies of different heights and damage to die inserts when the die cap receives uneven loading.

STATION	BALL RIDING CAT. NO	BRUSH CAT. NO
A [1/2"]	2375	2760
B [1-1/4"]	10685	2761
C [2"]	14591	2762
D [3-1/2"]	14582	2763
E [4-1/2"]	14583	2764



BALL RIDING AND BRUSH DIE

Press Brake Compatible
Punch Press Compatible

Brush dies are primarily used in applications where any marking that might be caused by ball riding dies is not acceptable.

TOOL STORAGE CABINET

8 DRAWER ARRANGEMENT & CAPACITY:

3 drawers for 'A' station tooling:

- 18 punch & guide assemblies (per drawer)
- 36 dies & 18 additional punches (per drawer)

3 drawers for 'B' station tooling:

- 12 punch & guide assemblies (per drawer)
- 24 dies & 12 additional punches (per drawer)

1 drawer for 'C' & 'D' station tooling:

- 12 - 'C' or 'D' station punches, stripper plates & dies

1 drawer (9 compartments)

- 'E' or 'F' large station guide assemblies

Includes lock with two keys and forklift base.

Overall Dimensions:

- 42" high x 28" wide x 29" deep
- 107cm high x 71cm wide x 74cm deep



CABINET	CAT. NO.
Thick Turret	90001
OPTIONS	CAT. NO.
Plastic Drawer Liners	90002
Mobile Base	90003
Maple Top	90004
Cart Handle (1)	90005
Ribbed Rubber Mat	90006

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
EXP Sharpening Adapter	6990
1/2" Tooling Sleeve Adapter	6043
1-1/4" Tooling Punch and Die Holder	6042
1-1/4" to 1/2" Die Adapter	6088
'Old Style' 2", 3-1/2" & 4-1/2" Tooling Punch Holder – for Standard Thick	6039
HP Thick 2", 3-1/2" & 4-1/2" Tooling Punch Holder	6040
Dura-Blade Grinding Fixture	6932
Pointer [Replacement]	6035
Degree Scale [Replacement]	6036

STD & HP MULTI-TOOL PUNCH & DIE HOLDERS

DESCRIPTION	CAT. NO.
8 Station Punch & Die Holder	6812
8mm Punch & Die Holder	6156
16mm Punch & Die Holder	6157
24mm Punch & Die Holder	6158

DESCRIPTION	CAT. NO.
230 V 3 Phase 30 Amp Grinder	6854
230 V 3 Phase 30 Amp Grinder - Enclosed	6938
460 V 3 Phase 20 Amp Grinder	6855
460 V 3 Phase 20 Amp Grinder - Enclosed	6939
1/2 Gallon Coolant Mix	6856
5 Gallon Coolant Mix	6857
Coolant Filter Pack [50 Sheets]	6858
6" Replacement CBN Wheel	6859
Production Coolant Filtration System	6860
Replacement Filter Roll for Filtration System	6861
Magnetic Chuck with Mounting Ring	6998



PUNCH AND DIE GRINDER

This punch and die grinder includes an integral mist collection unit and provides full containment of the grinding area vs. the standard open air containment shrouding.

- 5 horsepower spindle motor with CBN grinding wheel.
- Dual coolant application. Coolant is supplied both externally and through the spindle for maximum heat removal while grinding.
- Regrind punches up to 10° angle.
- Simple fixturing design. Allows for quick, easy loading and unloading of parts
- Heavy-duty three-jaw chuck standard with auxiliary magnetic chuck.
- Small footprint: 40" x 48" [101 x 122cm]

DESCRIPTION	CAT. NO.
DCM Mini PDG Grinder	6950
1/2 Gallon Coolant Mix	6856
5 Gallon Coolant Mix	6857
Coolant Filter Pack [50 Sheets]	6858
6" Replacement CBN Wheel	6859
DCM Mini Shear Grind Sine Plate	6951
Magnetic Chuck	6952



MINI PUNCH AND DIE GRINDER

An efficient and economical solution for sharpening turret and punch press tooling.

- Rigid z-axis column with dovetail ways.
- Cast iron base.
- Accepts 6" diameter grinding wheel.
- Recirculating coolant system with paper filter media.
- Standard 3 jaw chuck workholding fixture.
- Optional fixturing for angled tool sharpening.
- 1.5 horsepower 3600 RPM grinding spindle motor.
- Heavy-duty three-jaw chuck standard with auxiliary magnetic chuck.
- Dimensions: 33" x 17" x 60"
- Weight 800 lbs.

NYLON VICE JAWS

Press Brake Compatible

 Punch Press Compatible



Used to aid in the assembly and maintenance of A & B Station Thick Turret style punch assemblies.

.....
 Cat. No. 24001

ASSEMBLY FIXTURE

Press Brake Compatible

 Punch Press Compatible



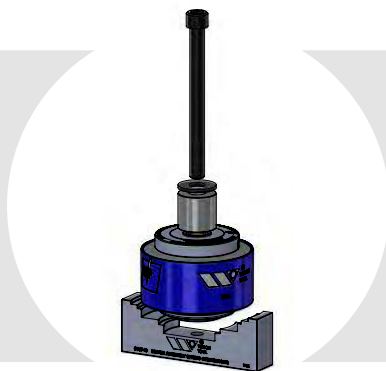
Ideal bench mounted aid for assembling and retaining a variety of assemblies. For C and D Stations.

.....
 Cat. No. 24162

HP SPRING COMPRESSION KIT

Press Brake Compatible

 Punch Press Compatible



Includes spring base, external circlip pliers, spacer sleeve, washer and M-12 bolt.

.....
 Cat. No. 6940
 For old style: Cat. No. 8104

RUBBERIZED ABRASIVE WHEEL

Press Brake Compatible

 Punch Press Compatible



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

.....
 Cat. No. 8050

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

.....
Cat. No. 6055



PUNCH LUBRICANT

.....
Press Brake Compatible
.....
Punch Press Compatible

Xcel 1 Liter Spray Bottle
Cat. No. 24315

.....
Xcel 5 Liter Concentrate
Cat. No. 24316



SHEET LUBRICANT

.....
Press Brake Compatible
.....
Punch Press Compatible

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

.....
Cat. No. 6941



CUT-MAX 570

.....
Press Brake Compatible
.....
Punch Press Compatible

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

.....
Cat. No. 6120



SURE SHOT SPRAYER

.....
Press Brake Compatible
.....
Punch Press Compatible



THICK TURRET 1-1/4" [B] to 1/2" [A] STATION ADAPTER

DESCRIPTION	CAT. NO.
Punch & Guide Assembly Adapter (Keyed at 0° & 180°)	2284
Die Adapter	2220
Screw	2119

THICK TURRET 2" [C] to 1-1/4" [B] STATION ADAPTER

DESCRIPTION	CAT. NO.
Punch & Guide Assembly Adapter	2476
Die Adapter	2475
Screw	6206

THICK TURRET 3-1/2" [D] to 1-1/4" [B] STATION ADAPTER

DESCRIPTION	CAT. NO.
Punch & Guide Assembly Adapter (not shown)	2492
Die Adapter	35058

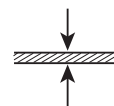


THICK TURRET 4-1/2" [E] to 1-1/4" [B] STATION ADAPTER

DESCRIPTION	CAT. NO.
Punch & Guide Assembly Adapter (not shown)	2680
Die Adapter	2681

MAX. MATERIAL THICKNESS FOR ABOVE ADAPTERS

.135" [3.4mm] mild steel and aluminum
.090" [2.3mm] stainless steel

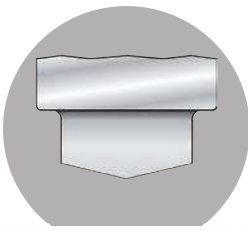


Other style adapters are available, please consult our sales desk.

SHEAR OPTIONS



REFERENCE



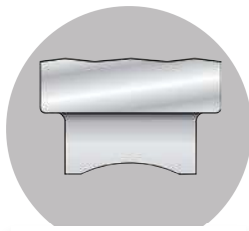
ROOFTOP



Best shear for punching at maximum tonnages.



When nibbling, bite must be 75% of punch dimension or excessive side loading will result.



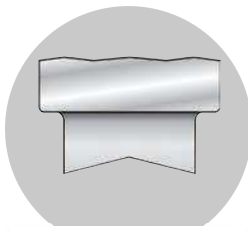
CONCAVE OR DOUBLE CONCAVE



Best shear for nibbling because it inverts stresses.



Less resistant to breakage when punching at high tonnages because of inverted stresses.



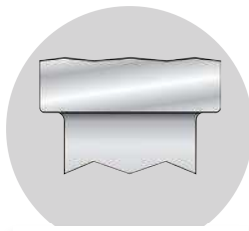
INVERTED ROOFTOP



Good shear for nibbling because it inverts stresses.



More susceptible to breakage because of a sharp focal point for stresses — use great care.



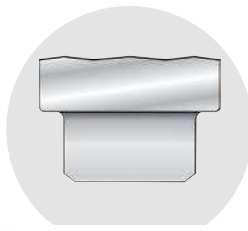
DOUBLE VALLEY



Best shear for nibbling when shape is long and narrow.



Less resistant to breakage when punching at high tonnages because of inverted stresses.



JK SHEAR



A special shear that allows you to punch high strength materials with a reduced risk of breakage.



Can only be used on punches up to 1.000" (25.4mm) diameter or 'A' dimension.

SPECIAL SHEARS

STATION	'A' Dimension	Inverted Rooftop		Double Valley	
		Single Concave	Double Concave	Single Concave	Double Concave
1-1/4" (B)	Within 1.250" [31.75mm]	1/16" [1.6mm]	1/8" [3.2mm]	N/A	N/A
2" (C)	Within 2.000" [50.8mm]				
3-1/2" (D)	Within 3.500" [88.9mm]				
4-1/2" (E)	Within 4.500" [114.3mm]				

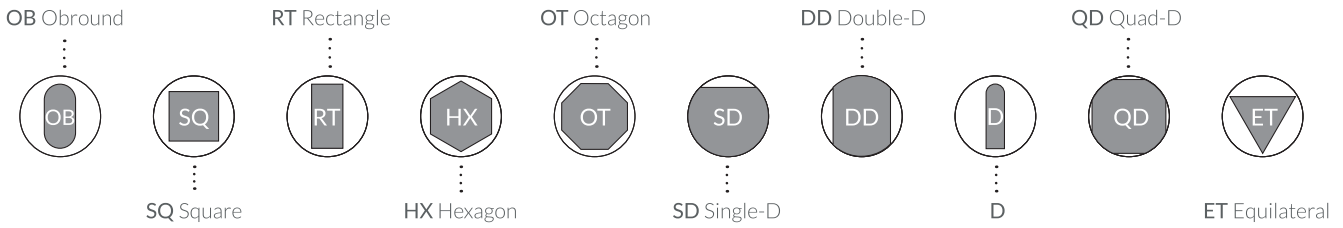
JK SHEAR

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

SHEAR DETAILS	'A' DIMENSION	EXCEPTION
<p>1/16" (1.6mm) rooftop shear is given to all punches with 'A' dimension† greater than 2.000" (50.8mm) and width greater than .250" (6.35mm) at no extra charge.</p> <p>All punches .250" (6.35mm) and under in width will be shipped with no shear unless specified.</p>		<p>In some instances, inverted rooftop is substituted for single and double concave shears.</p>

SPECIAL SHEAR DETAILS
<p>If specified: 1/8" (3.2mm) maximum rooftop shear can be given at N/C for any round or shape in 2"(C), 3-1/2"(D), 4-1/2"(E) or 6"(F) stations.</p> <p>Rooftop shear available on any round or shape in 1/2"(A) or 1-1/4"(B) stations.</p>

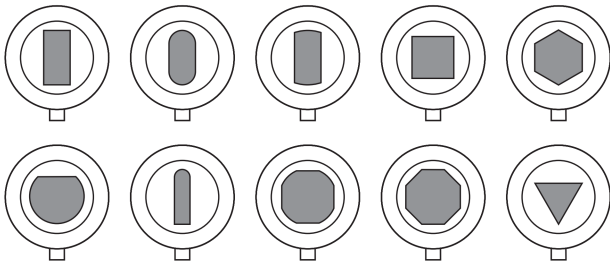
STANDARD SHAPES



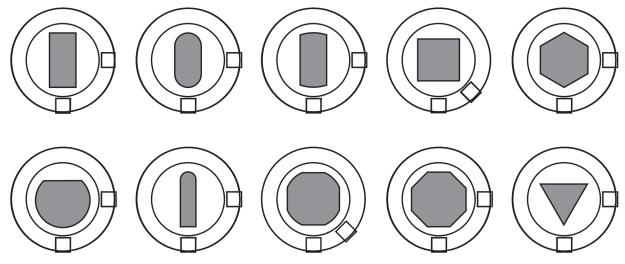
STANDARD KEYING LOCATIONS

DIE VIEW

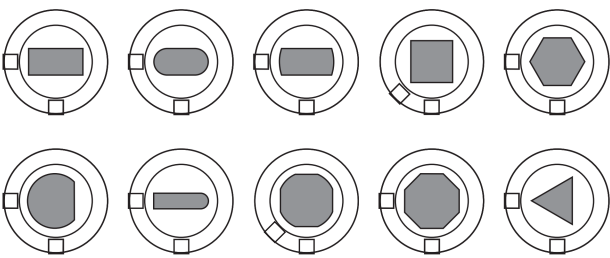
1/2" [A] & 1-1/4" [B] STATION



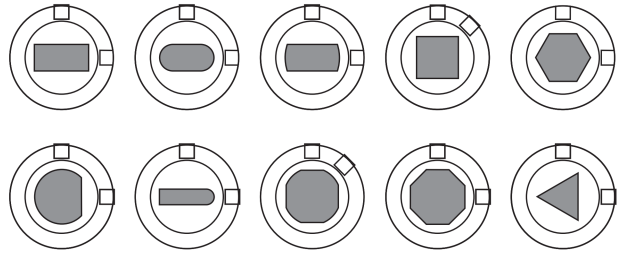
2" [C] STATION



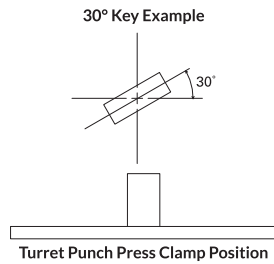
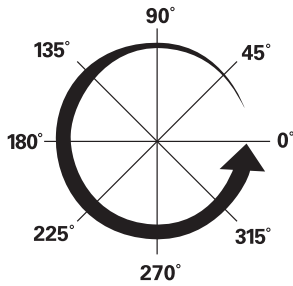
3-1/2" [D] STATION



4-1/2" [E] STATION



iSERIES TOOL KEYING DIAGRAM



Non-Standard Key Locations

The example to the left shows a rectangle shape oriented at 30°. To ensure proper shape orientation, it is important that you refer to non-standard key locations by following this example.

SHAPE at single angles other than standard			
Station	Punch	Die	Guide or Stripper
A	N/C		N/C
B			Not Applicable
C			Not Applicable
D			Not Applicable
E			Not Applicable

No additional charge on A & B stations for shape at 45° increments)

STANDARD keying, plus extra pins or keys for shapes at other than 45° increments			
Station	Punch	Die	Guide or Stripper
A	Not Applicable	Not Applicable	/ key
B	Not Applicable	Not Applicable	/ key
C	/ pin	/ key	Not Applicable
D	/ pin	/ key	Not Applicable
E	/ pin	/ key	Not Applicable

STANDARD keying, plus extra pins or keys for shapes at 45° increments					
Station	PUNCH		DIE		Guide or Stripper
	Available Options	Add On Price	Available Options	Add On Price	
A	Not Available	Not Available	Not Available	Not Available	/ key
B	0° & 45° 0° & 180°		0° & 45° 0° & 180°		/ key
C	45° increments	/ pin	45° increments	/ key	Not Applicable
D	45° increments	/ pin	45° increments	/ key	Not Applicable
E	45° increments	/ pin	45° increments	/ key	Not Applicable

Die Clearance Selection Information			
Material	Total Clearance		
	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

'A' STATION			
Add on for ROUNDS			
Small Diameter	PUNCH	DIE	STRIPPER
.031 - .061" [0.79 - 1.56mm]			N/C
.062 - .092" [1.57 - 2.34mm]		N/C	N/C
Clearance < .004" [.10mm]			N/C
Add on for SHAPES			
Small Width	PUNCH	DIE	STRIPPER
.031 - .039" [0.79 - 1.0mm]			
.040 - .092" [1.01 - 2.34mm]		N/C	
Clearance < .004" [0.10mm]			N/C

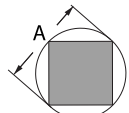
'B' STATION			
Add on for ROUNDS			
Small Diameter	PUNCH	DIE	STRIPPER
.031 - .061" [0.79 - 1.56mm]			N/C
.062 - .092" [1.57 - 2.34mm]		N/C	N/C
.093 - .249" [2.35 - 6.32mm]		N/C	N/C
Clearance < .004" [.10mm]			N/C
Add on for SHAPES			
Small Width	PUNCH	DIE	STRIPPER
.031 - .039" [0.79 - 1.0mm]			
.040 - .092" [1.01 - 2.34mm]		N/C	
'A' Dim < .437" [11.10mm]		N/C	N/C
Clearance < .004" [0.10mm]			N/C

'C' STATION			
Add on for ROUNDS			
Small Diameter	PUNCH	DIE	STRIPPER
<1.000" [25.4mm]		N/C	N/C
Clearance < .004" [.10mm]			N/C
Add on for SHAPES			
Small Width	PUNCH	DIE	STRIPPER
.031 - .039" [0.79 - 1.0mm]			
.040 - .092" [1.01 - 2.34mm]			
'A' Dim < 1.150" [29.21mm]		N/C	N/C
Clearance < .004" [0.10mm]			N/C

'D' STATION			
Add on for ROUNDS			
Small Diameter	PUNCH	DIE	STRIPPER
<1.900" [48.26mm]		N/C	N/C
Clearance < .004" [.10mm]			N/C
Add on for SHAPES			
Small Width	PUNCH	DIE	STRIPPER
.031 - .039" [0.79 - 1.0mm]			
.040 - .092" [1.01 - 2.34mm]			
'A' Dim < 1.150" [29.21mm]		N/C	N/C
Clearance < .004" [0.10mm]			N/C

'E' STATION			
Add on for ROUNDS			
Small Diameter	PUNCH	DIE	STRIPPER
<3.400" [86.36mm]		N/C	N/C
Clearance < .004" [.10mm]			N/C
Add on for SHAPES			
Small Width	PUNCH	DIE	STRIPPER
.031 - .039" [0.79 - 1.0mm]			
.040 - .092" [1.01 - 2.34mm]			
'A' Dim < 1.150" [29.21mm]		N/C	N/C
Clearance < .004" [0.10mm]			N/C

RADIUS OR 45° CHAMFER 4 CORNERS	
RADIUS OR CHAMFER SIZE	PRICE
.001 - .062" [0.02 - 1.57mm]	
Punch .063 - .250" [1.58 - 6.35mm]	
> .25" [.10mm]	
RADIUS OR CHAMFER SIZE	PRICE
Die Any Size	

MAX 'A' DIMENSION	NOTES
	Round or shape punch options: <ul style="list-style-type: none"> • Extra straight before radius • Extra back taper • No back taper

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



Wear-Beater

Wilson Tool's exclusive Wear-Beater coating is a titanium nitride (TiN) coating that helps reduce galling and extends punch life in certain applications.



Optima®

Developed by Wilson Tool engineers in our state-of-the-art coating facility, our revolutionary Optima coating provides significantly longer tool life, more hits between sharpenings, reduced galling, better performance and less downtime. With a surface hardness of 95 Rockwell C, Optima far exceeds the hardness levels that can be achieved with conventional tool steels. It resists galling in stainless and galvanized steel and is unaffected by sharpening. Optima coating will outlast untreated tools by as much as 5-7 times.



Nitrex®

Our exclusive Nitrex high endurance surface enhancement increases punch press tooling life by several times that of ordinary tooling. Wilson Tool's patented process provides a surface hardness of HRC-70, increasing long-term durability. Nitrex is also very effective in reducing punch wear and galling when piercing galvanized materials.



Slip-Max®

Available only from Wilson Tool, our Slip-Max coating has proven effective in some very tough punching and forming applications. The combination of its hardness and lubricity greatly increases punch life and reduces galling when piercing aluminum. Slip-Max is also very effective in resolving even the most challenging stripping problems with punching or forming stainless steel and aluminum.



COATING RECOMMENDATION BY APPLICATION	WEAR-BEATER	OPTIMA	NITREX	SLIP-MAX
Punch wear piercing varied materials	●	★		
Punch or die wear piercing stainless steel	●	★		
Punch wear piercing galvanized	●	▲	★	
Punch or die wear piercing aluminum	●		▲	★
Galling on punch in stainless steel	●	▲		
Galling on punch in galvanized	●	▲	★	
Galling on punch in aluminum	●		▲	★
Stripping problems when forming in stainless steel	●		▲	★
Stripping problems when forming in aluminum	●			★
Stripping problems when piercing in stainless steel	●	★		
Stripping problems when piercing in aluminum	●		▲	★
	● GOOD	▲ BETTER	★ BEST	

SLUG HUGGER® 2 ELIMINATES COSTLY SLUG PULLING

Manufacturers simply cannot afford to have their presses down for any amount of time. At Wilson Tool, our desire to provide innovative tooling solutions for our customers has led us to develop the Slug Hugger® 2 die design which helps eliminate the very costly problem of slug pulling.

The Slug Pulling Solution

For a guaranteed solution to slug pulling problems that will maximize your press time and improve your productivity, turn to Wilson Tool – the leading provider of tooling solutions for the punching industry.

Slug Hugger 2 dies help eliminate scrapped parts, costly downtime, and possible press and tooling damage due to slug pulling. Our unique design helps eliminate unnecessary back-pressure on small punch tips by preventing packed slugs. The Slug Hugger 2 design works on most material types and thicknesses including aluminum and stainless steel.



How Does it Work?

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



WILSON TOOL INTERNATIONAL

WORLD HEADQUARTERS

Wilson Tool International – United States

Tel (Free): 800-328-9646 | Tel: 651-286-6001
Fax (Free): 800-222-0002 | Fax: 651-286-5959
Email: sales@wilsontool.com

NORTH AMERICA

Wilson Tool – Canada

Punching and Stamping Division
Tel: 800-268-5573 | Fax: 800-668-9314
Email: punching@wilsontoolcanada.com

Wilson Tool – Canada

Press Brake Division
Tel: 800-268-4180 | Fax: 905-840-1032
Email: bending@wilsontoolcanada.com

Wilson Tool – Mexico

Tel: 52 (81) 8865-4820 | Fax: 52 (81) 8865-4599
Email: americalatina@wilsontool.com

SOUTH AMERICA

Wilson Tool – Argentina

Tel: +54 114 799 6519
Email: ventassudamerica@wilsontool.com

Milling Ferramentas – Brazil

Tel/Fax: 55 11 5621-2100
Email: vendas@milling.com.br

CHINA / PACIFIC RIM

Wilson Tool – China

Tel: +86 21 51089638 | Fax: +86 21 64422195
Email: sales@wilsontool.cn

EUROPE / MIDEAST / AFRICA

Wilson Tool – United Kingdom

Tel (Free): 0800-373748 | Tel: +44 1793 831818
Fax (Free): 0800-373758 | Fax: +44 1793 831945 or 46
Email: sales@wilsontool.eu.com

Wilson Tool – Germany

Tel (Free): 00800-9457668665 | Tel: +49 5723 7 0
Fax (Free): 00800-945766329 | Fax: +49 5723 747 10
Email: verkauf@wilsontool.eu.com

Wilson Tool – Denmark

Tel (Free): 80 20 20 24 | Tel: +45 44 53 1699
Fax (Free): 80 20 20 26 | Fax: +45 44 53 0607
Email: sales@wilsontool.dk

Wilson Tool – France

Tel: +33 (0) 164 13 47 80 | Fax: +33 (0) 164 13 47 81
Email: ventes@wilsontool.eu.com

Toolspress – Italy

Tel: +39 0521 850510 / 850677
Fax: +39 0521 850796
Email: info@toolspress.com



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