



WILSON TOOL INTERNATIONAL  
**EUROPEAN-STYLE**  
**PRESS BRAKE TOOLING**

# My Account

**Wilson Tool customers can now enjoy 24/7 access their account online! My Account features include:**

- Online Ordering
- Request Quotes
- Access Drawings
- View Invoices
- Track Packages
- View Order History

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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 cancelled, 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.



# EUROPEAN-STYLE PRESS BRAKE TOOLING

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# WILSON TOOL INTERNATIONAL



From humble beginnings in a small manufacturing facility in St. Paul, Minnesota, Wilson Tool International has added innovation, tooling divisions, manufacturing facilities and sales channels around the world to better serve thousands of global customers. Throughout our expansion, our mission has never wavered – we continue to offer products and services that help you, our customers, to be more successful.

Innovation is key at Wilson Tool International. It's true what they say: no two jobs are the same. In manufacturing, change is the only constant. So working with a press brake tooling supplier that's flexible, nimble and knowledgeable is important.

Wilson Tool International continues to invest in your success. We now have more than 50 sales engineers nationwide who are available to answer questions, proactively suggest innovative solutions to save you time and money, and keep you up and running. That's more than all of our North American competitors combined.

Leverage our sales engineers. Challenge them with a problem. Put their knowledge to work for you. You can connect with them in person, by phone and through e-mail.

And be assured, with every order, you'll always get our quality guarantee: *Your success is our priority. If you're ever unsatisfied with a Wilson Tool International product, we'll do everything we can to make it right and keep you up and running.*

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

Sincerely,  
Brian Robinson  
CEO, Wilson Enterprises





## 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.

## TABLETING

**Wilson Tool's Tableting division delivers standard and custom tooling for superior production capability by utilizing the latest innovations in tableting science.**



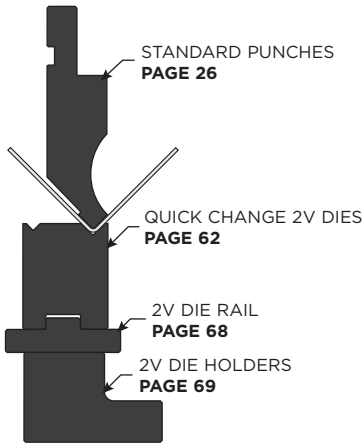
Wilson Tool's punches and dies for the pharmaceutical, nutraceutical, confectionery and related industries provide the best tooling per application. We collaborate with you to create the punch and die most suited to meet the specific needs of your tableting application.

## ACCESSORIES

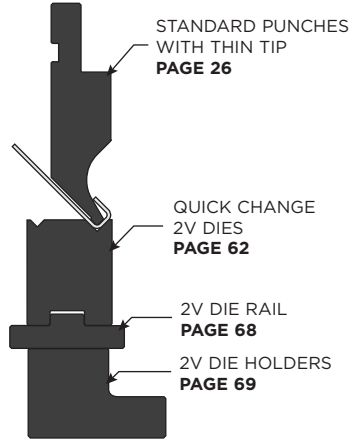
Whether you need storage systems, grinders, urethane rolls, hand tools or related supplies, we offer a wide range of solutions to help you be more productive, organized and efficient.



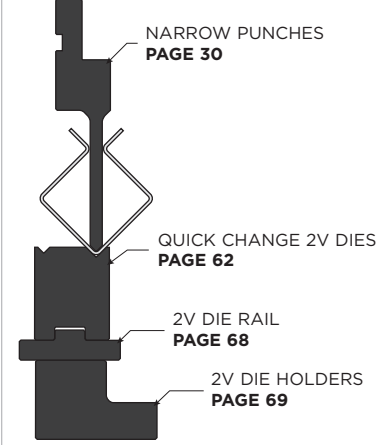
**90° BENDING  
(27 GA - 10 GA)**



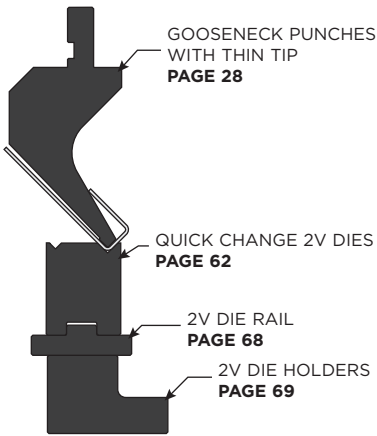
**90° BENDING  
W/THIN TIP PUNCH**



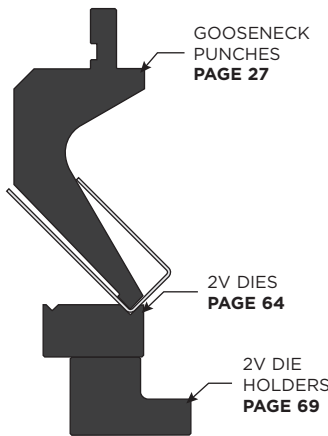
**90° BENDING  
W/NARROW PUNCH**



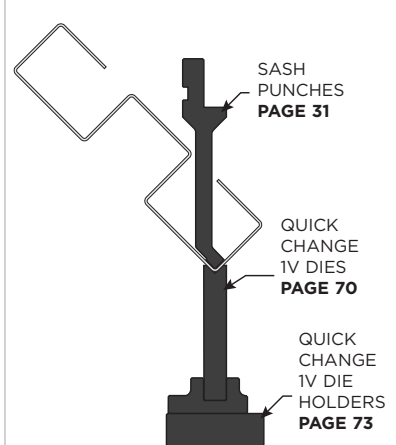
**90° BENDING W/THIN TIP  
GOOSENECK PUNCH**



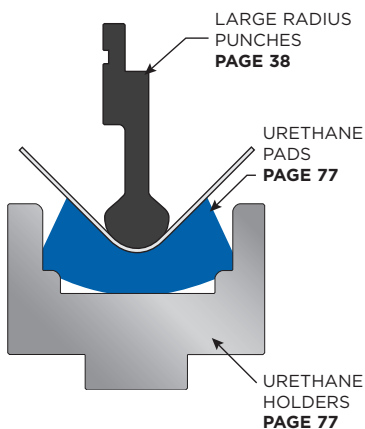
**90° BENDING  
W/GOOSENECK PUNCH**



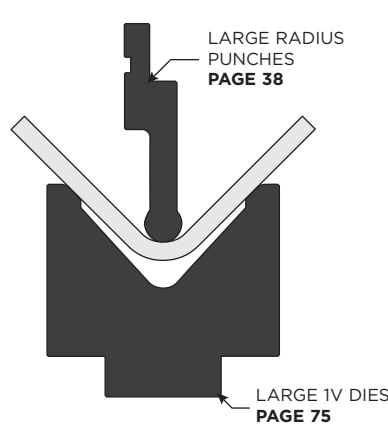
**90° BENDING  
(SASH)**



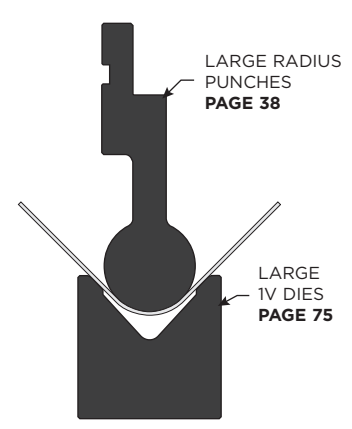
**LARGE RADIUS BENDING  
URETHANE PAD**

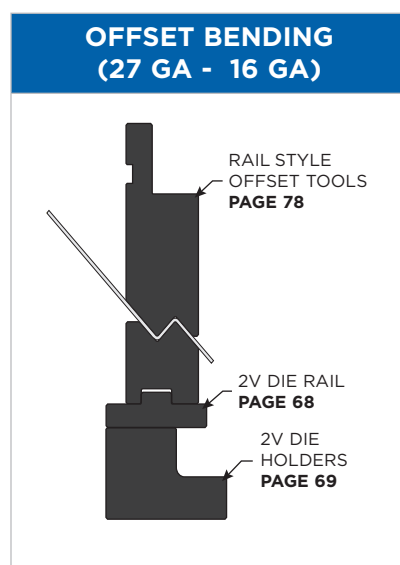
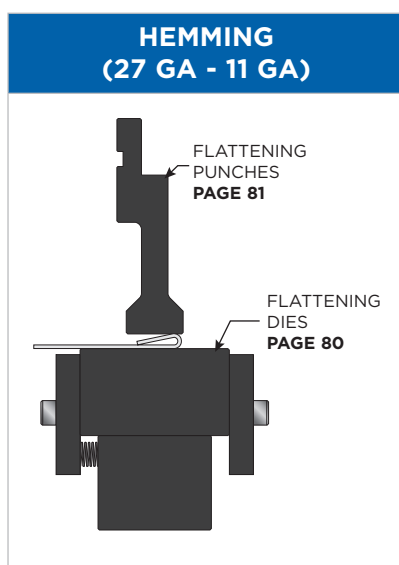
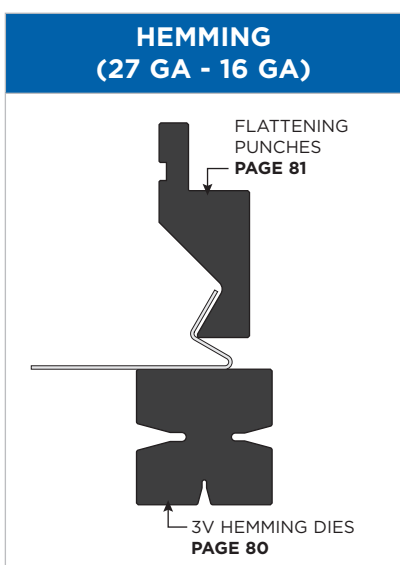
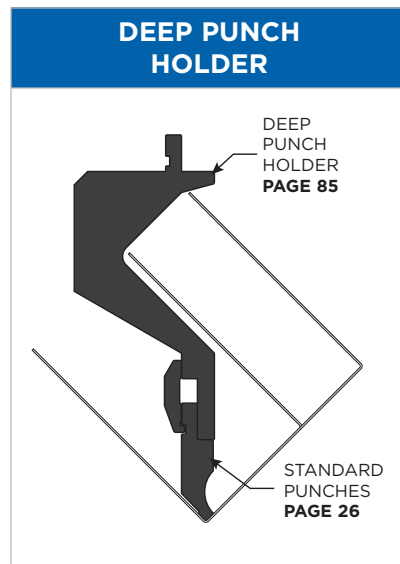
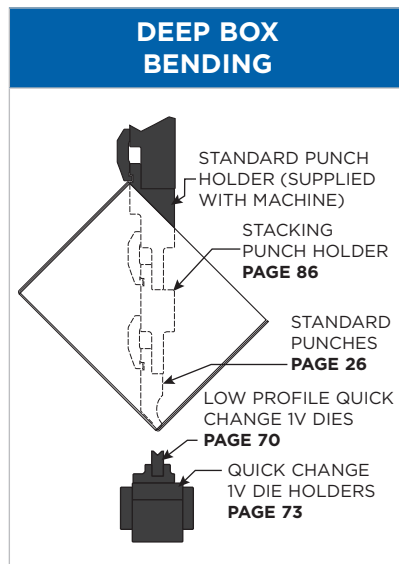
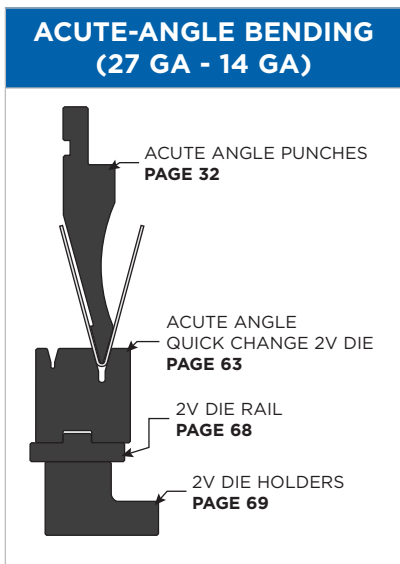
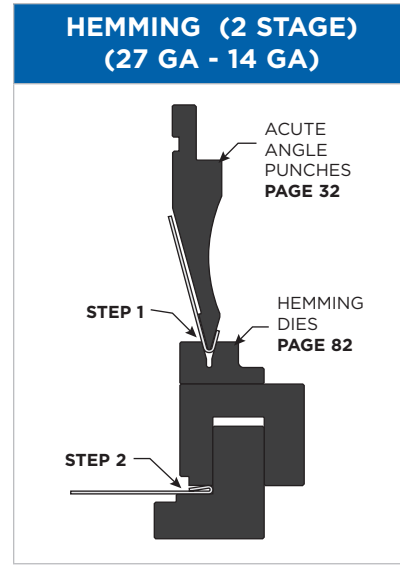
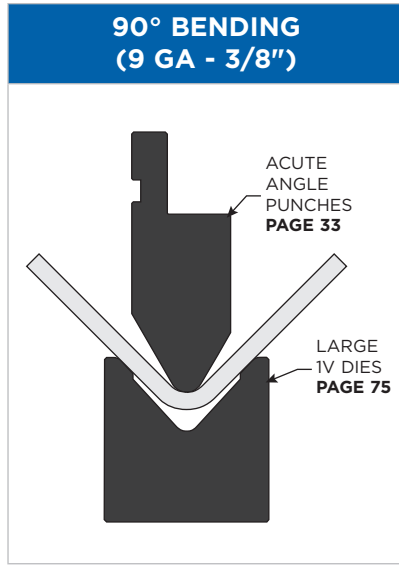
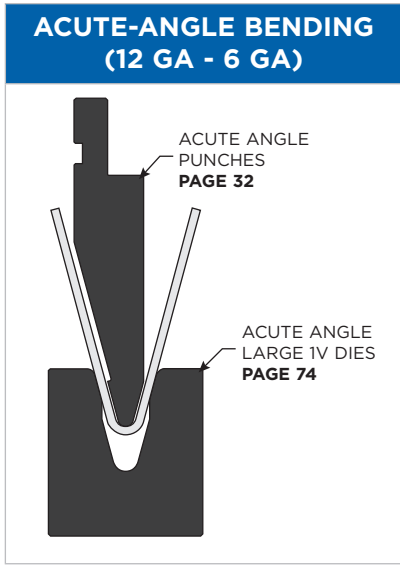


**90° BENDING  
(3/8" - 1/2")**



**LARGE  
RADIUS BENDING**





**BENDING DIAGRAMS**

# FIXED HEIGHT TOOLING

## THE TOOLING YOU NEED WITH WILSON TOOL BENEFITS

Wilson Tool International Fixed Height tooling is optimized for performance and ease of use. All tooling is Nitrex® heat treated to 70HRC for increased strength, durability and lubricity. This ensures longer life and better performance. Each section includes tooling detail in easy-to-read laser marking.

Wilson Tool's Fixed Height line is fully compatible with Amada® machines. It is made in and shipped from the USA with the shortest lead-times available.

### The Customization You Require

As with all Wilson Tool press brake tool styles, Fixed Height tooling can be custom made in special configurations for unique bends. Special tip modifications and cuts are designed and manufactured out of our Minnesota headquarters. We have a team of technically trained sales engineers, tooling technicians, application specialists and designers who can help you to identify the ideal Fixed Height tool for your application.



Amada® is a registered trademark of Amada Co., Ltd. and is used by Amada America, Inc., Amada Capital Corporation and Amada Co., Ltd.



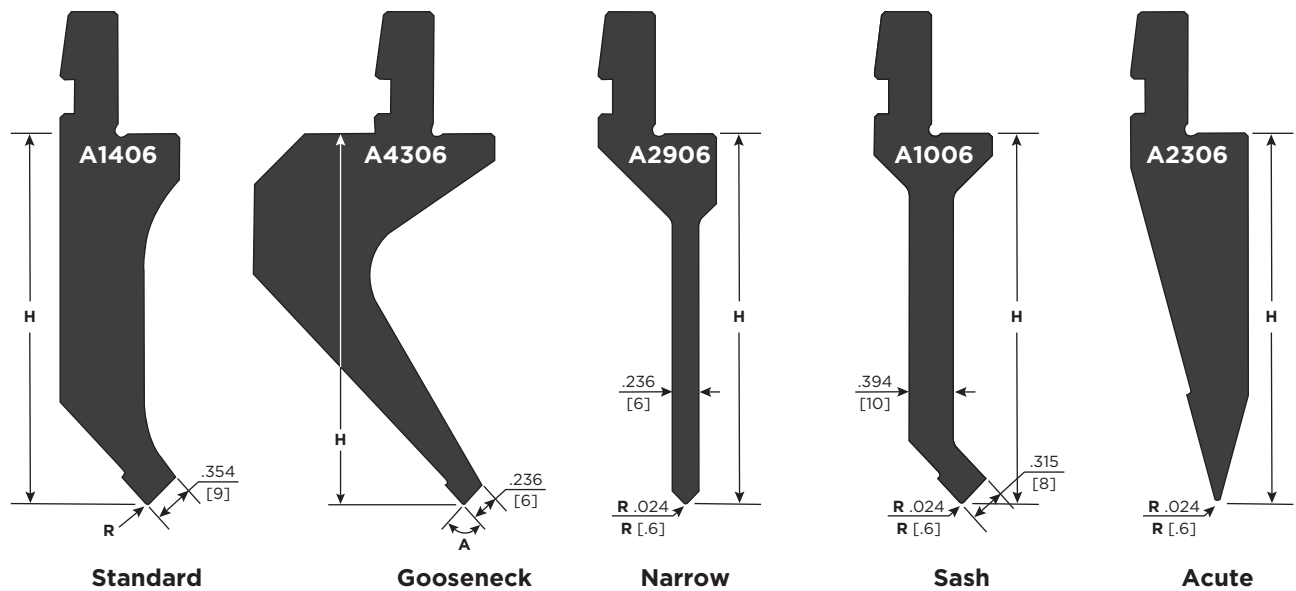


**SECTIONALIZED PUNCH & DIE LENGTHS – Ear section notes only apply to punches**

**L** = 32.87" [835mm]  
**S** = 20.08" [510mm]  
**X** = 14.6" [370mm]  
 X Section Lengths [mm]: 10 (2) | 15 | 20 | 25 | 40 | 50 | 100 Ear Sections (2)  
**100** = 3.93" [100mm]

Featuring the beveled punch tang.

**85mm TALL PUNCHES – FIXED HEIGHT**



Cat. No.	A Angle	R Radius inch [mm]	Height inch [mm]	Max. Ton feet [meter]		Weight lbs/in [kg/mm]	L	S	X	100
				L & S	X		32.87" [835mm]	20.08" [510mm]	14.6" [370mm]	3.93" [100mm]
<b>85mm TALL PUNCHES W/ BEVELED TANG (FIXED HEIGHT)</b>										
A1406	M	.024 [0.6]	3.339 [84.8]	30 [100]	14 [47]	1.01 [.018]				
A4306	M			21 [70]	14 [47]	1.16 [.021]				
A2906	M			15 [50]	3.7 [12]	0.51 [.009]				
A1006	M			9 [30]	5 [17]	0.70 [.012]				
A2306	M	.024 [0.6]	3.339 [84.8]	30 [100]	9 [30]	0.86 [.015]				

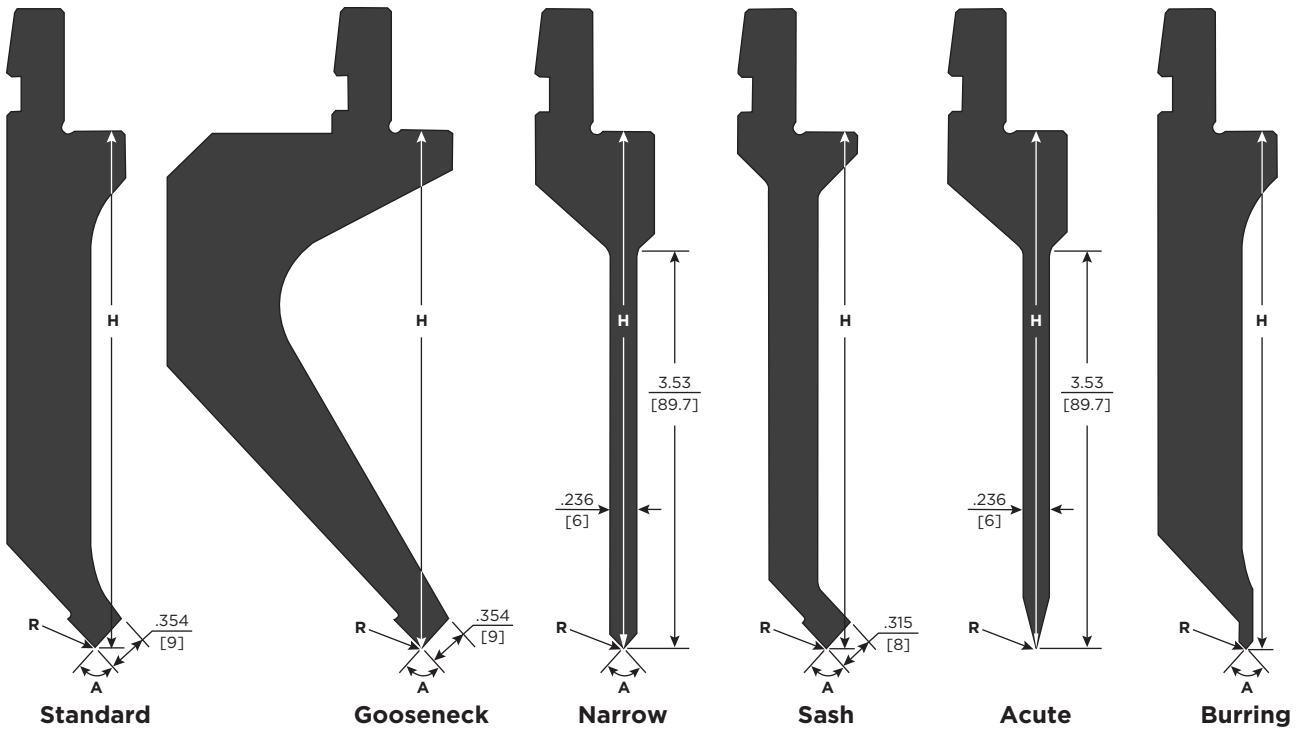
**M** Made To Order

**FIXED HEIGHT TOOLING**



# 120mm TALL PUNCHES – FIXED HEIGHT

FIXED HEIGHT TOOLING



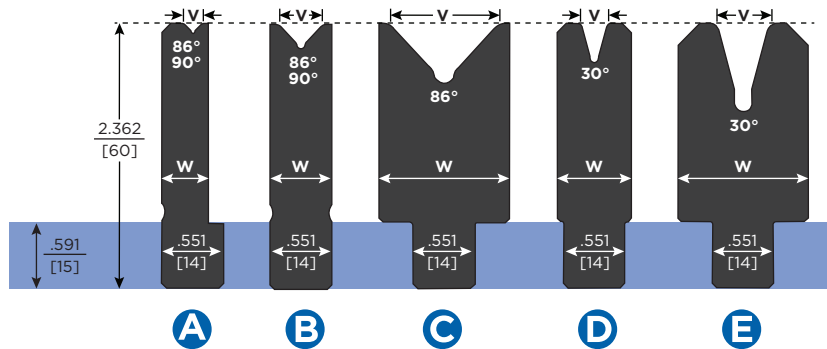
Punch Style	Cat. No.	A Angle	Tip Radius inch [mm]	Height inch [mm]	Max. Ton ft [meter]		Weight lbs/in [kg/mm]	L	S	X	100
					L & S	X		32.87" [835mm]	20.08" [510mm]	14.6" [370mm]	3.93" [100mm]
<b>120mm TALL PUNCHES W/ BEVELED TANG (FIXED HEIGHT)</b>											
Standard	A0402	86°	.008 [0.2]	4.724 [120]	30 [100]	12 [40]	1.29 [.023]				
	A0406		.024 [0.6]	4.717 [119.8]							
	A1602	M 90°	.008 [0.2]	4.724 [120]							
Goose-neck	A4702	86°	.008 [0.2]	4.724 [120]	30 [100]	12 [40]	1.92 [.034]				
	A4706		.024 [0.6]	4.717 [119.8]							
	A4802	M 90°	.008 [0.2]	4.724 [120]							
Narrow	A1902	86°	.008 [0.2]	4.724 [120]	15 [50]	7 [23]	.086 [.015]				
	A1906		.024 [0.6]	4.717 [119.8]							
	A1802	M 90°	.008 [0.2]	4.724 [120]							
Sash	A2002	86°	.008 [0.2]	4.724 [120]	15 [50]	7 [23]	.086 [.015]				
	A2006		.024 [0.6]	4.717 [119.8]							
	A2102	M 90°	.008 [0.2]	4.724 [120]							
Acute	A1302	30°	.008 [0.2]	4.724 [120]	15 [50]	7 [23]	.086 [.015]				
	A1306		.024 [0.6]	4.717 [119.8]							
Burring	A0502	86°	.008 [0.2]	4.724 [120]	15 [50]	7 [23]	1.29 [.023]				
	A0506		.024 [0.6]	4.717 [119.8]							
	A1702	M 90°	.008 [0.2]	4.724 [120]							

M Made To Order

= 30 lbs. / 13.6kg or more



# ACUTE AND BLOCK DIES



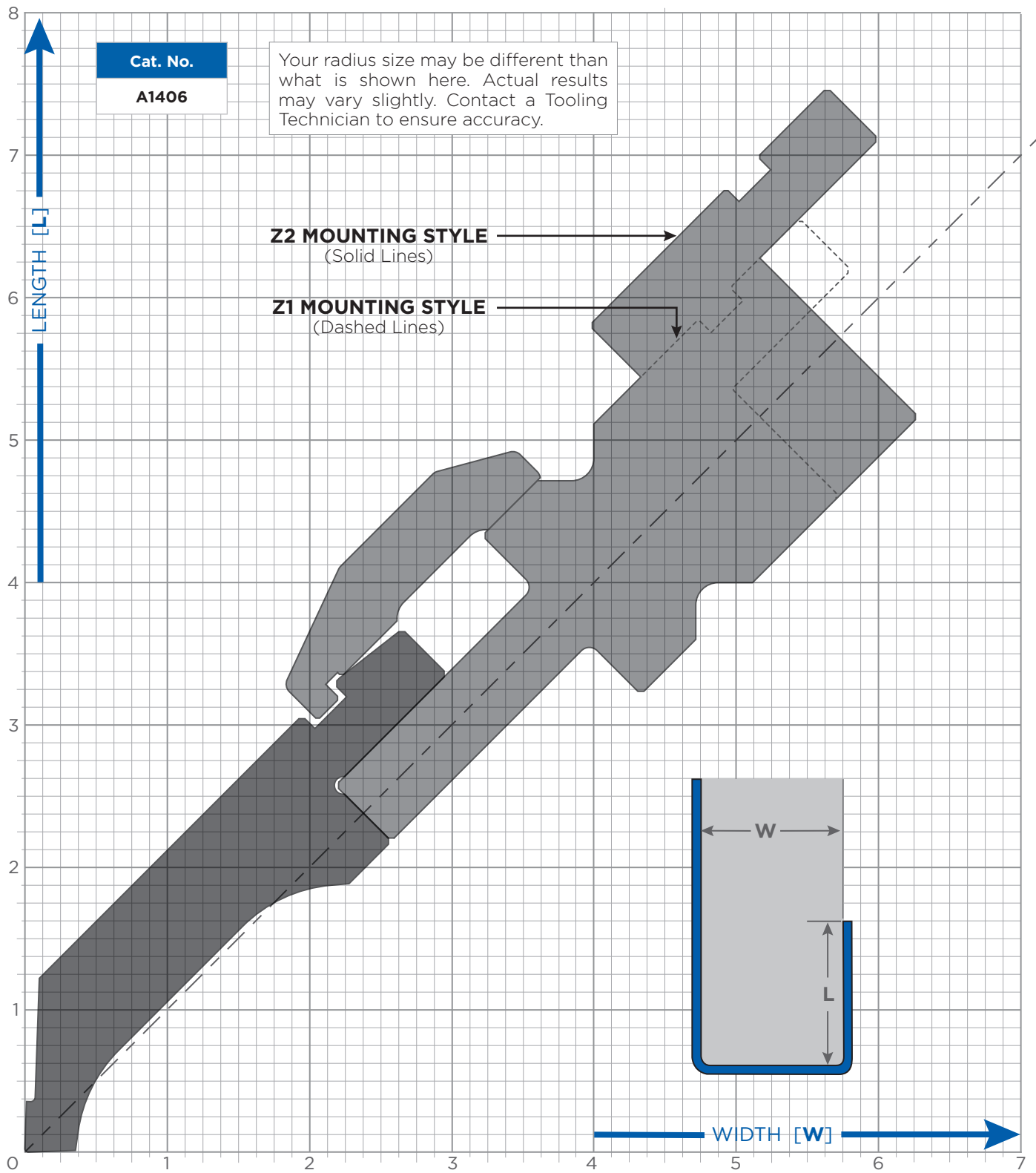
Cat. No.	Angle	V Opening inch [mm]	W Width inch [mm]	Max Ton L, S, X	Weight lbs/in [kg/mm]	L	S	X	100
						32.87" [835mm]	20.08" [510mm]	14.6" [370mm]	3.93" [100mm]
<b>86° &amp; 90° DIES (FIXED HEIGHT)</b>									
A	A8406	.157 [4]	10.0	26 [87]	0.33 [.006]				
A	A8506	.197 [5]	10.5						
A	A7006	.236 [6]	11.0						
A	A8606	.276 [7]	11.5						
A	A7106	.315 [8]	12.0	29 [97]					
B	A7206	.394 [10]	14.0	30 [100]	0.51 [.009]				
B	A7406	.472 [12]	16.0						
B	A7606	.551 [14]	18.0						
B	A7706	.630 [16]	20.0						
B	A7806	.709 [18]	22.0						
B	A7906	.787 [20]	24.4						
C	A8206	.984 [25]	29.5		0.70 [.012]				
A	A8409	.157 [4]	10.5	26 [87]	0.33 [.006]				
A	A8509	.197 [5]	11.0						
A	A7009	.236 [6]	11.5	29 [97]	0.33 [.006]				
A	A8609	.276 [7]	12.0						
A	A7109	.315 [8]	12.5						
B	A7209	.394 [10]	14.0	30 [100]	0.51 [.009]				
B	A7409	.472 [12]	16.0						
<b>30° DIES (FIXED HEIGHT)</b>									
D	A8403	.157 [4]	14.0	5 [17]	0.33 [.006]				
D	A7003	.236 [6]	17.0	6 [20]	0.51 [.009]				
D	A7103	.315 [8]	20.0						
E	A7403	.472 [12]	30.0	9 [30]					

**M** Made To Order

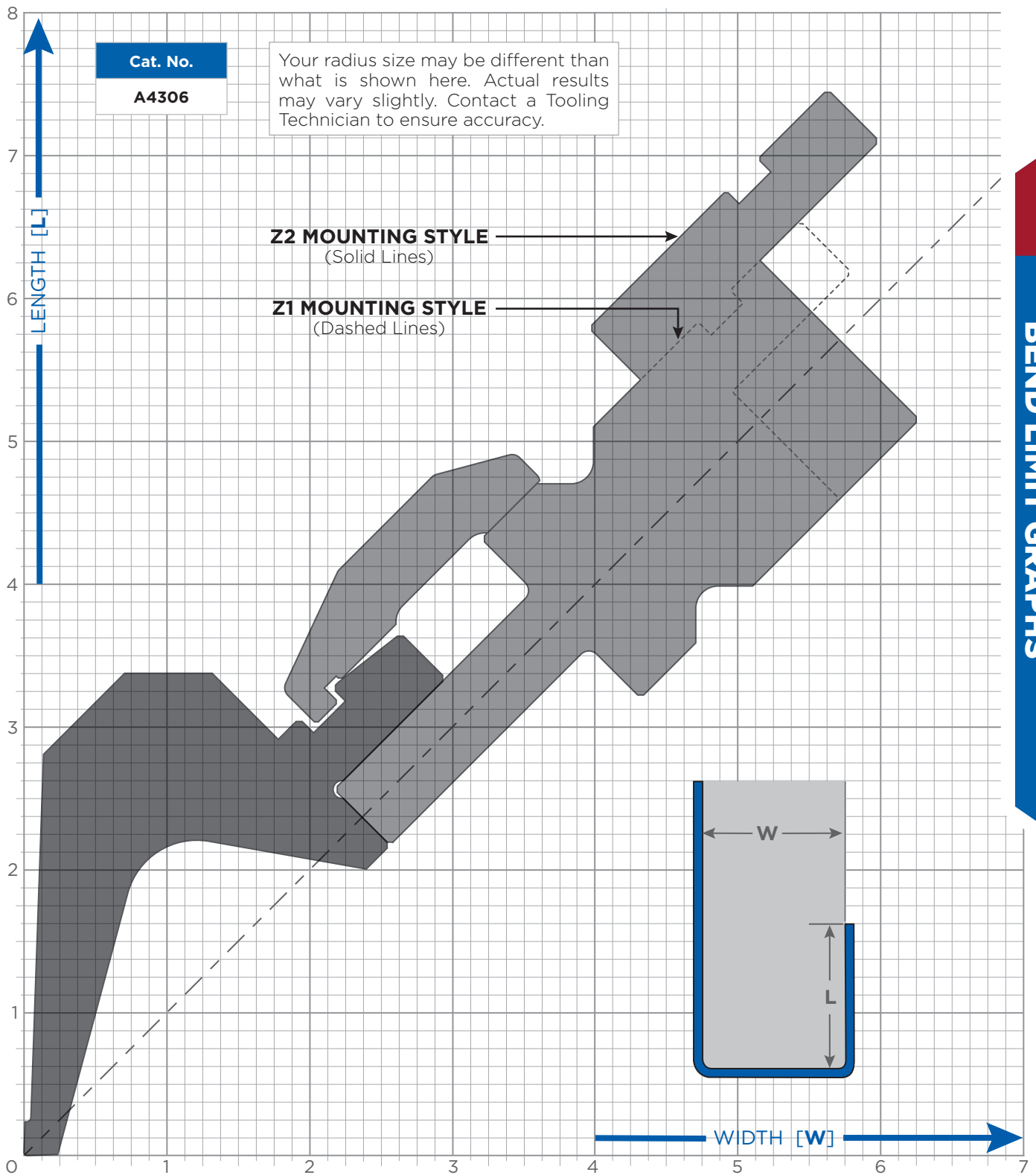
FIXED HEIGHT TOOLING

# STANDARD PUNCH (FIXED HEIGHT) 86°

BEND LIMIT GRAPHS



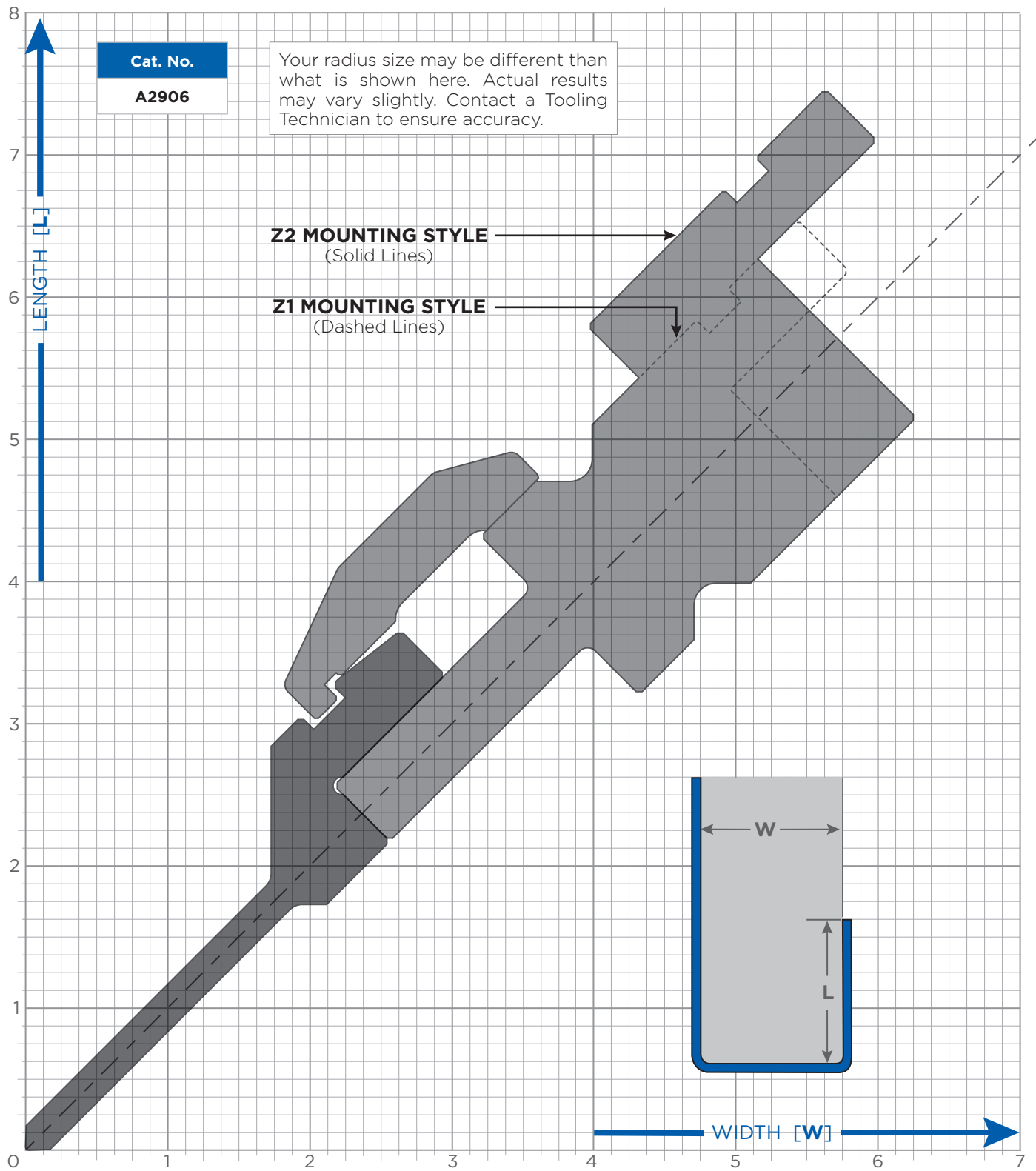
# GOOSENECK PUNCH (FIXED HEIGHT) 86°



# NARROW PUNCH (FIXED HEIGHT)

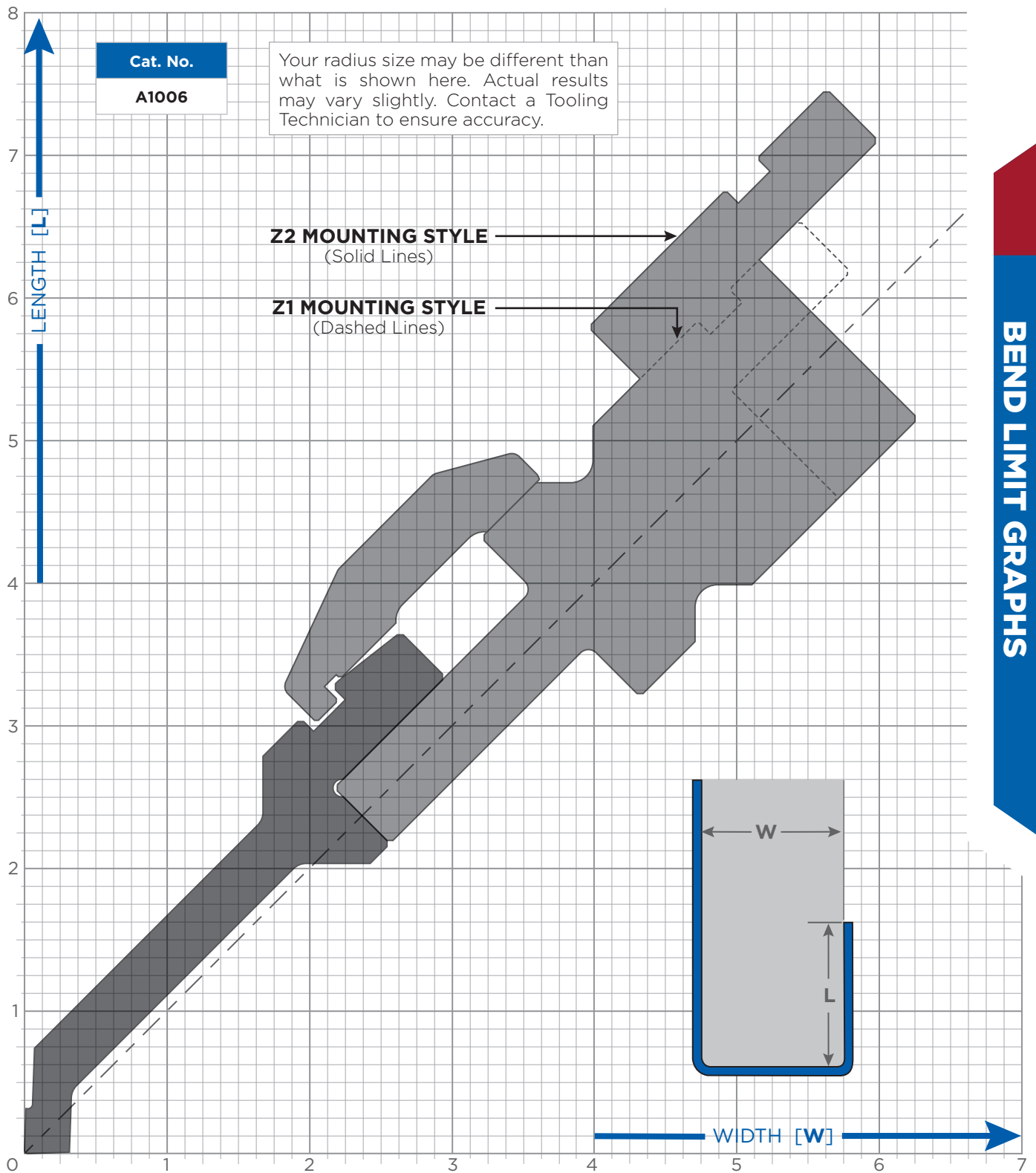
## 30°

BEND LIMIT GRAPHS





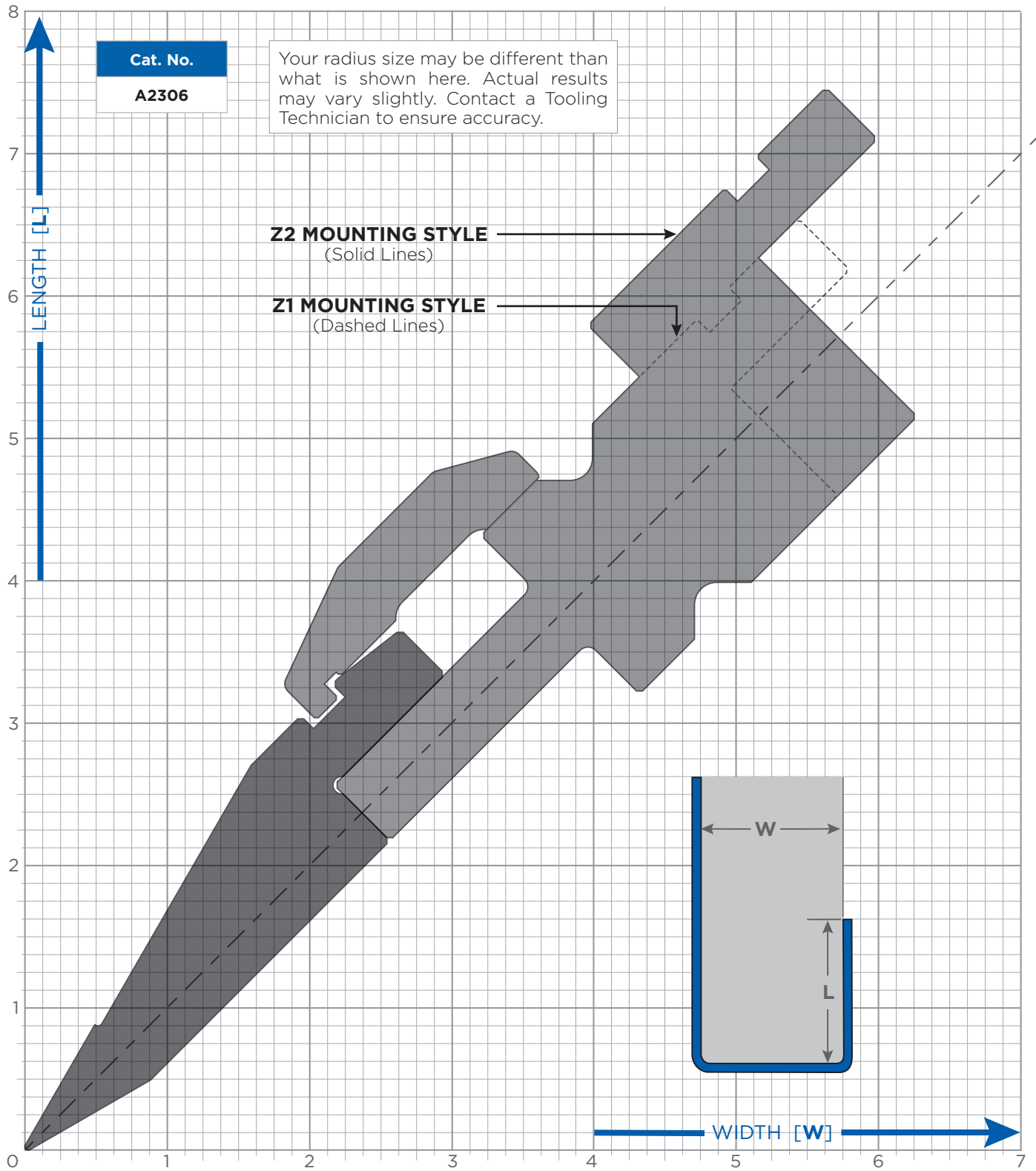
# SASH PUNCH (FIXED HEIGHT) 86°



**BEND LIMIT GRAPHS**

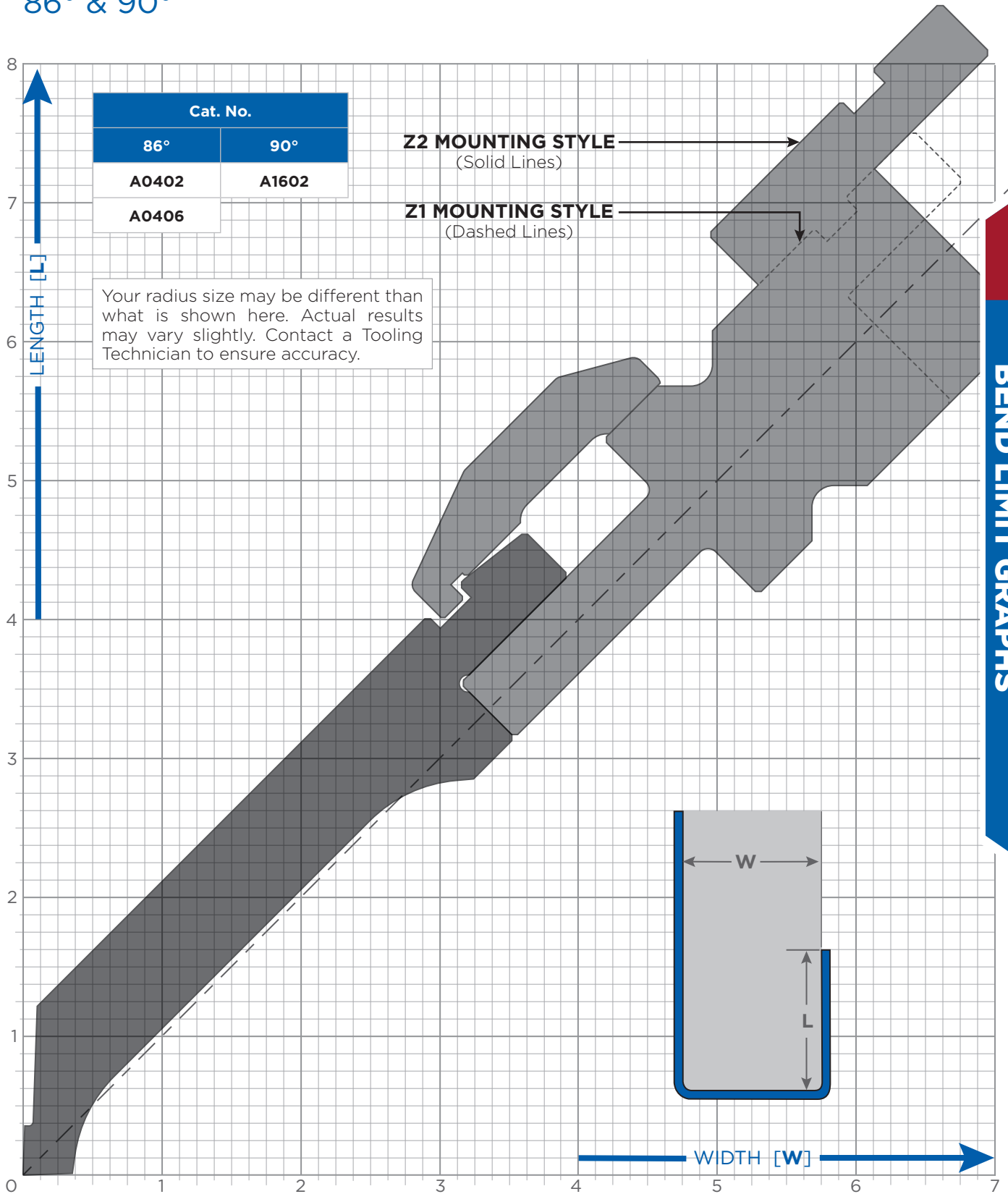
# ACUTE PUNCH (FIXED HEIGHT) 30°

BEND LIMIT GRAPHS



# STANDARD PUNCH (FIXED HEIGHT)

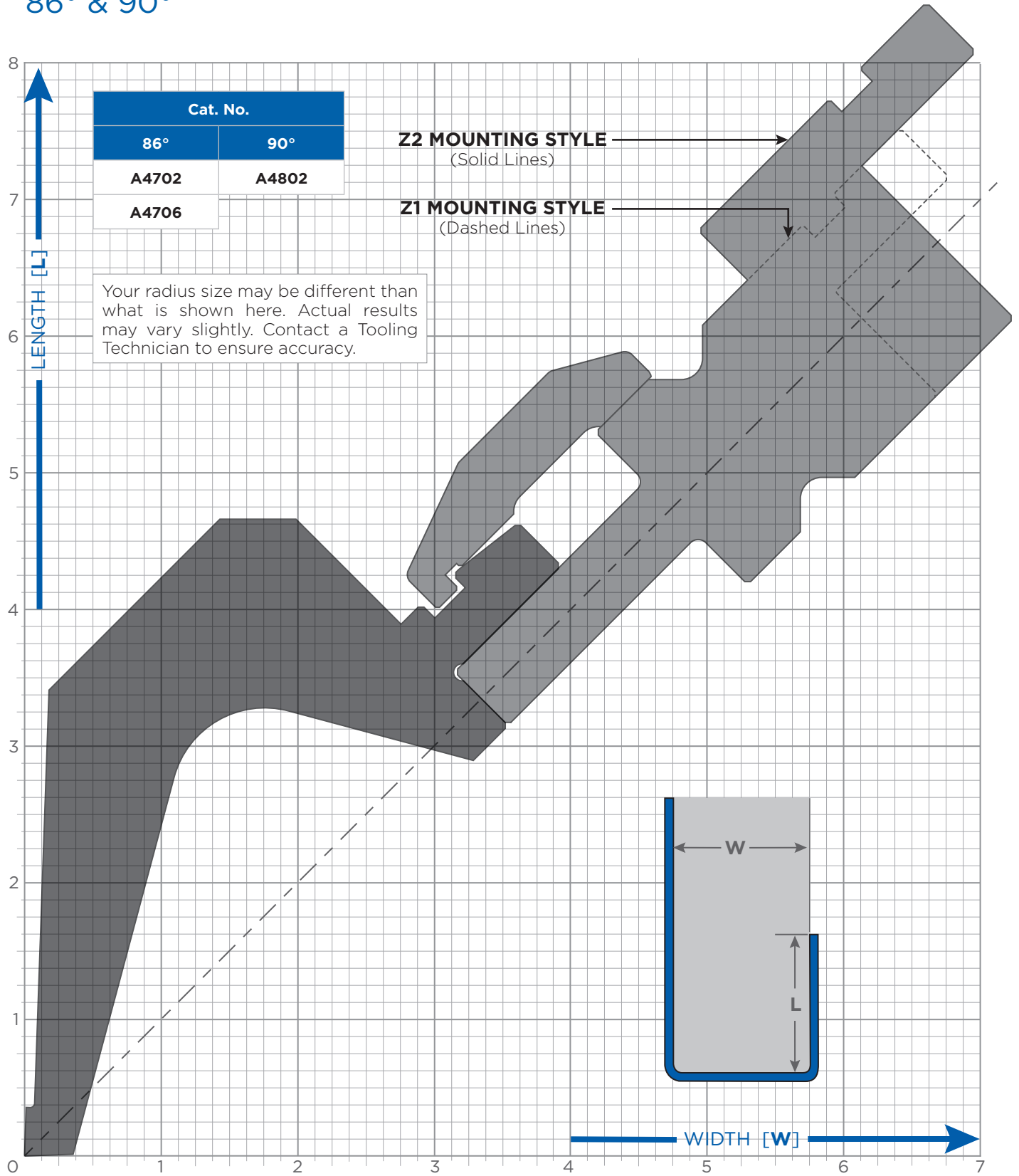
## 86° & 90°



# GOOSENECK PUNCH (FIXED HEIGHT)

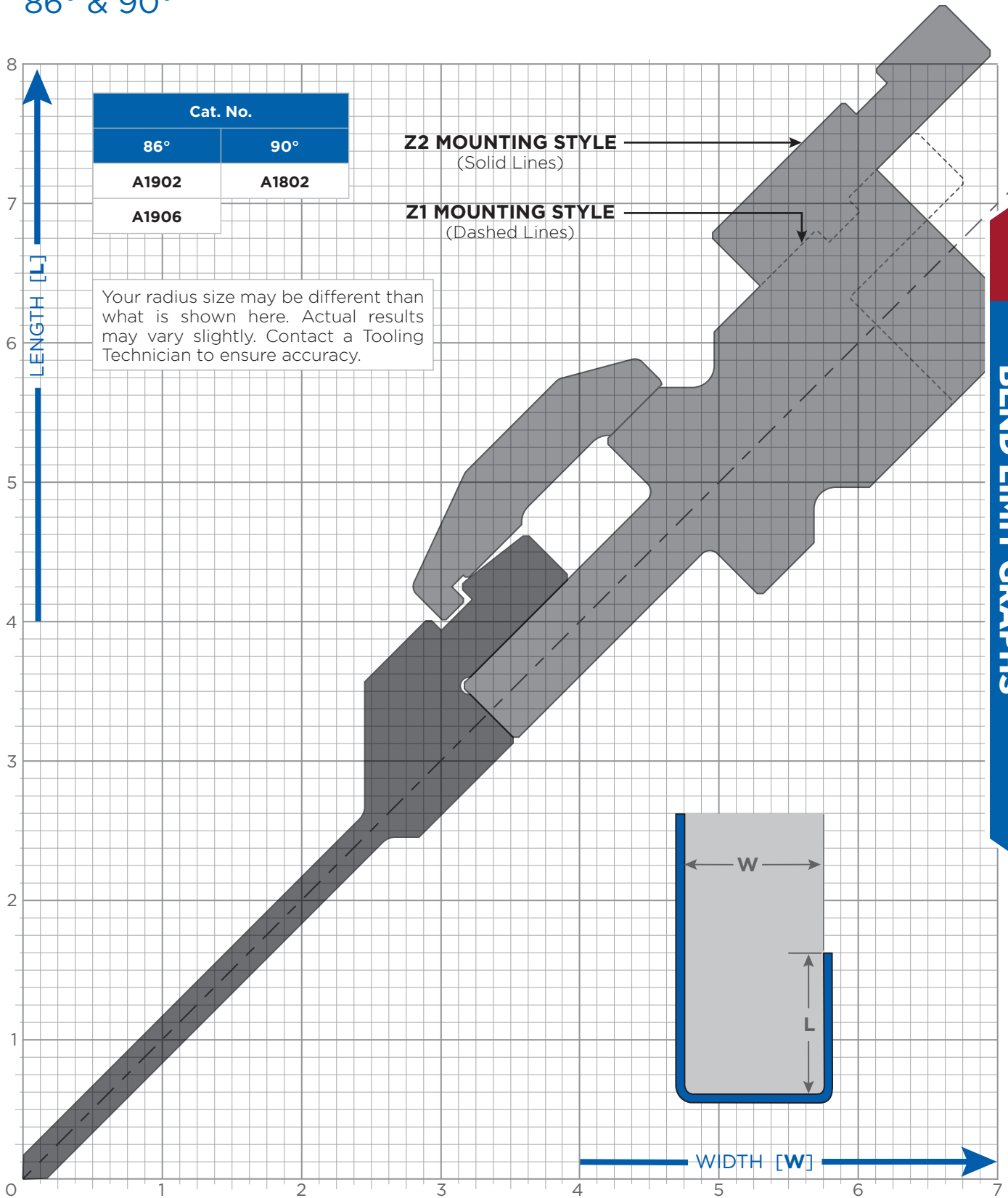
## 86° & 90°

BEND LIMIT GRAPHS



# NARROW PUNCH (FIXED HEIGHT)

86° & 90°

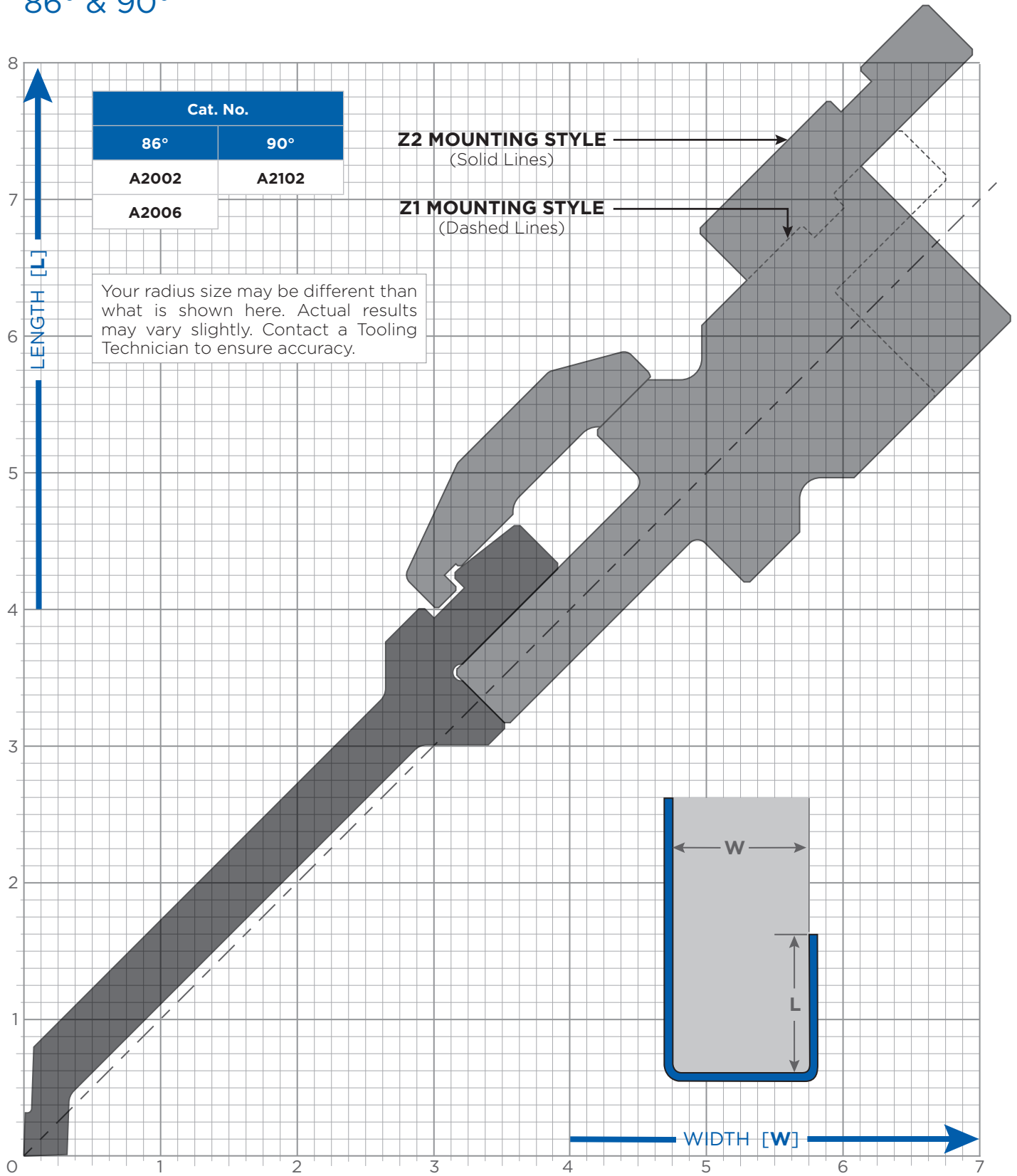




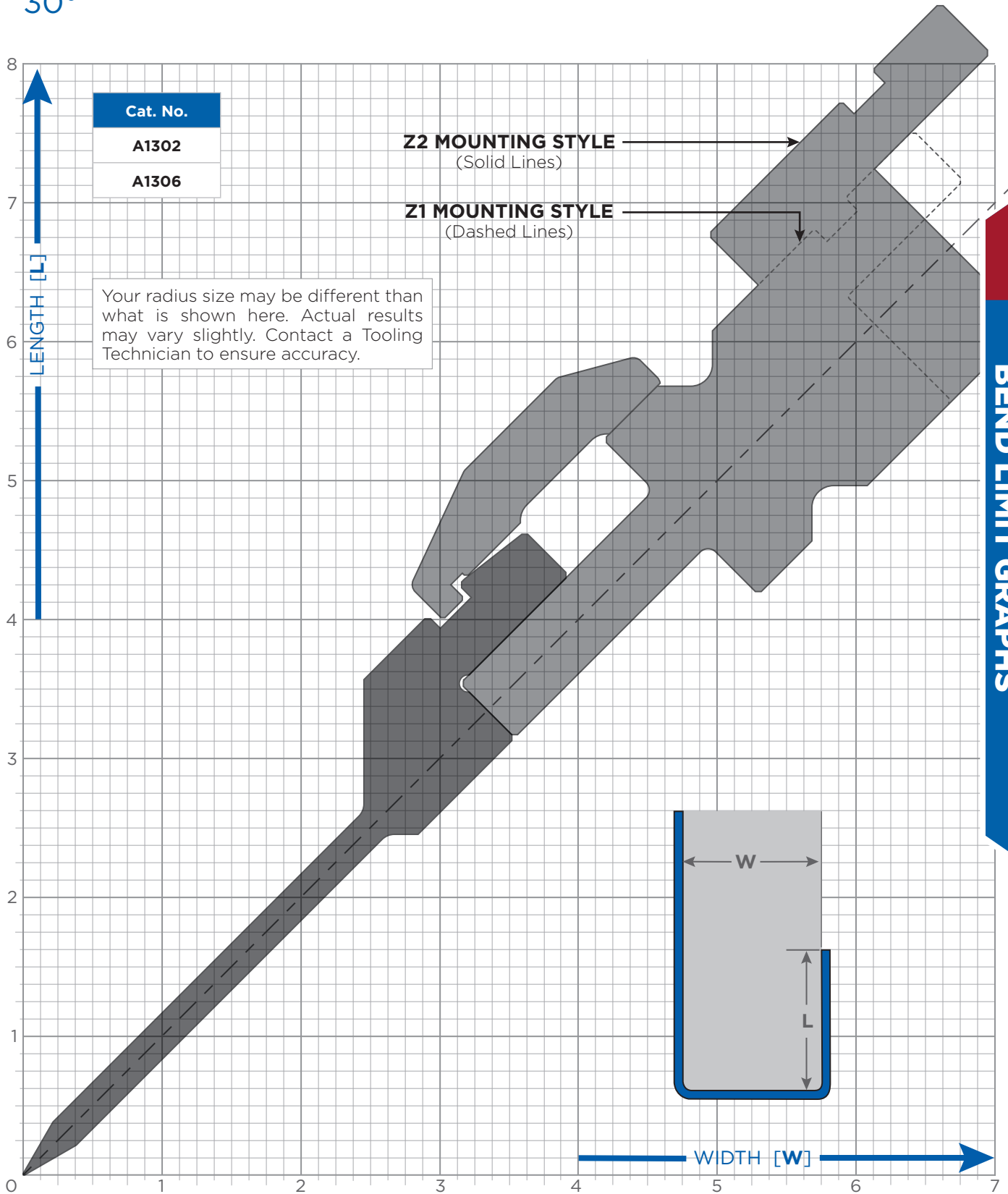
# SASH PUNCH (FIXED HEIGHT)

86° & 90°

BEND LIMIT GRAPHS



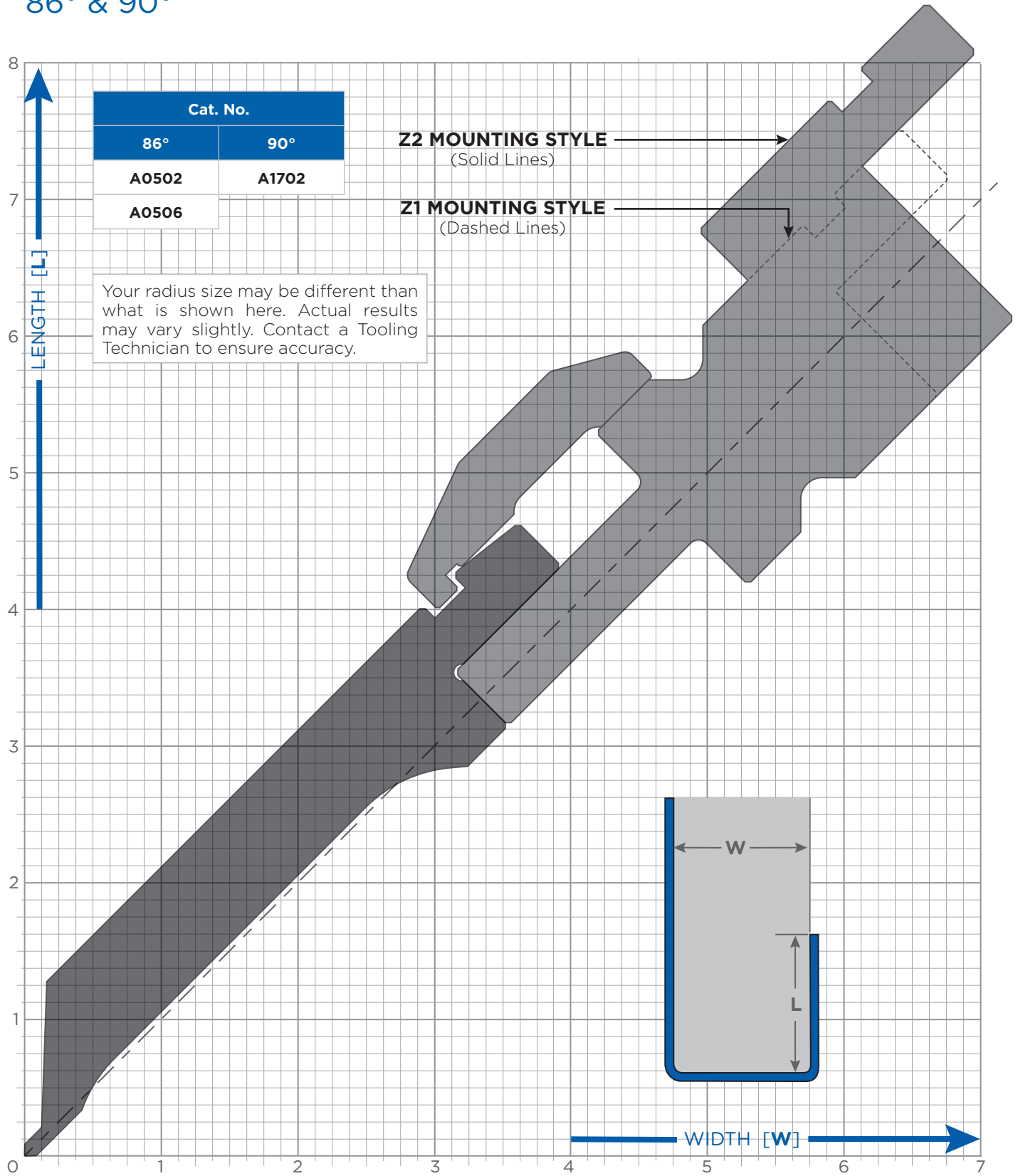
# ACUTE PUNCH (FIXED HEIGHT) 30°



# BURRING PUNCH (FIXED HEIGHT)

86° & 90°

BEND LIMIT GRAPHS



# EUROPEAN STANDARD TOOLING

STOCKED AND READY FOR  
**SAME-DAY DELIVERY**

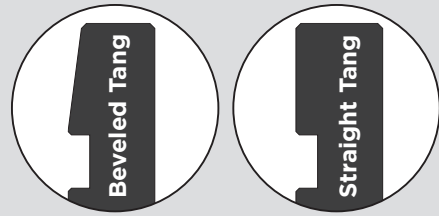
Let Wilson Tool International support all of your European-Style Tooling needs with exact match **STANDARD PUNCH & DIE PROFILES** and a lead time that tops the industry!



EUROPEAN TRADITIONAL

# EUROPEAN TRADITIONAL

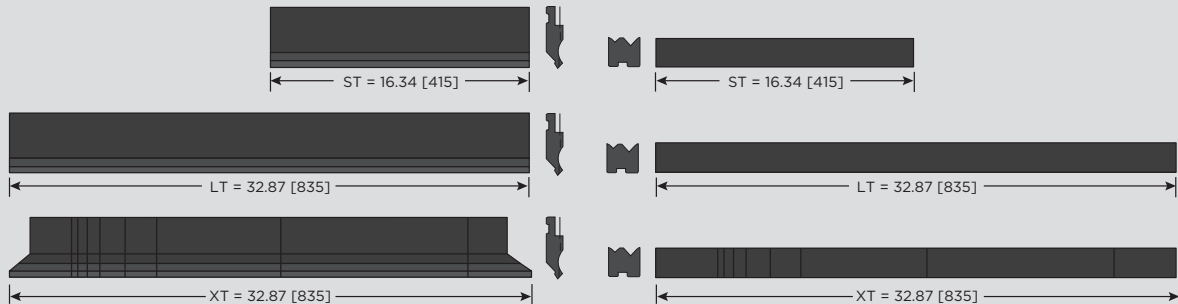
European Traditional Tooling has two main die styles that include 1V and quick change 2V dies. Both are offered with a holder that allows alignment-free changeover and no extra fastening step.



Punches are commonly loaded into a segmented holder. This allows for shorter punches to be used for box bending since the punch holder creates space for the part, and also increases the height of the punch. Operators like European Traditional Tooling because they get to handle a smaller, lighter punch. All punches are available with a straight or beveled tang

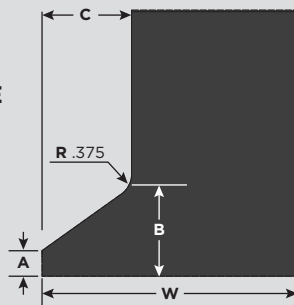
Our European Traditional Tooling is precision ground, and comes in sectionalized punches with “ear pieces” for box bending. Tooling is Nitrex® heat-treated for optimal life and durability, laser marked for easy identification, and available “staged” so you don’t need to add shims or risers to make your tooling close at the same height.

## PUNCH AND DIE LENGTHS



### SPECIAL EAR PIECE

When ordering a special ear section, indicate these dimensions:



### SECTION WIDTHS

- .394" (10mm)
- .591" (15mm)
- .787" (20mm)
- 1.575" (40mm)
- 1.969" (50mm)
- 3.937" (100mm) Left Ear
- 3.937" (100mm) Right Ear
- 7.874" (200mm)
- 11.811" (300mm)

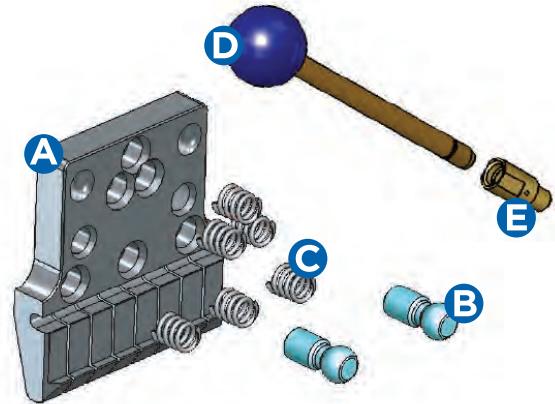


# EXPRESS PUNCH CLAMPS



Note: Handles can be easily removed to reduce interference.

Cat. No.	Description	Height	Price
<b>CONVENTIONAL PRESS BRAKES W/WEDGE</b>			
43815I-2	2 Front Clamp Plates	100mm	
43815I	2 Front & 2 Back Clamp Plates	100mm	
<b>Z1 SERIES W/WEDGE</b>			
43817I-2	2 Front Clamp Plates	100mm	
43817I	2 Front & 2 Back Clamp Plates	100mm	
<b>Z2 SERIES W/WEDGE</b>			
43818I-2	2 Front Clamp Plates	120mm	
43818I	2 Front & 2 Back Clamp Plates	120mm	
<b>TRUMPF PRESS BRAKES W/WEDGE</b>			
43819I-2	2 Front Clamp Plates	100mm	
43819I	2 Front & 2 Back Clamp Plates	100mm	



Cat. No.	Description	Price
<b>REPLACEMENT COMPONENTS</b>		
A	43812	Clamp Plate Assembly
B	43726	Pivot (2)
C	43732	Spring (6)
	8005944	Blue Label
<b>HANDLE ASSEMBLY</b>		
	43734	O-Ring
D	43020	Handle Assembly
E	43727	Shaft Socket

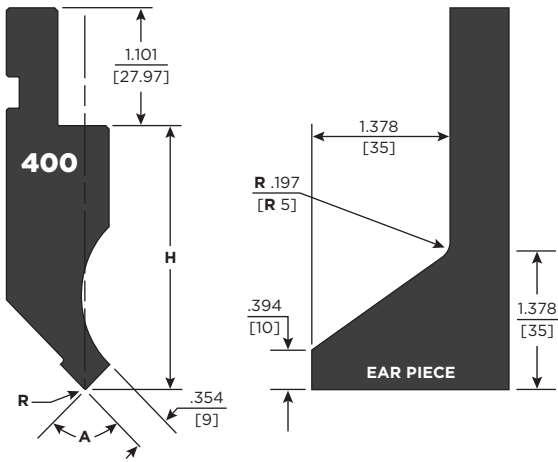


Cat. No.	Description	Price
<b>EXPRESS CLAMP TORQUE WRENCH KIT</b>		
8002	Complete Kit Includes: Case, 2 Pivots, Wrench, 2 Hex Tips	
<b>KIT COMPONENTS</b>		
8003	Case	
43726	Pivot (2)	
6793	Wrench	
6795	Hex Tip (2)	

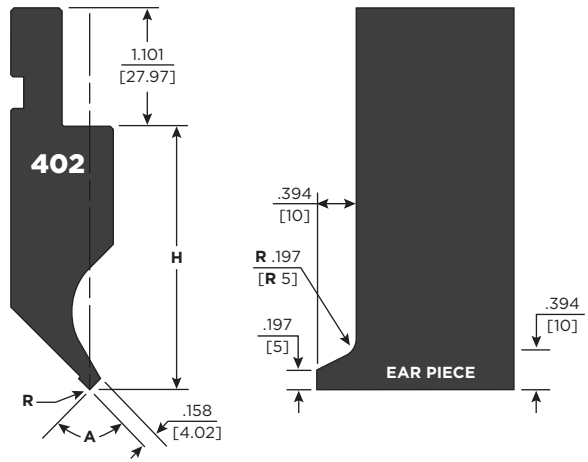
Watch the video on our YouTube Channel!

EUROPEAN TRADITIONAL

## 88° & 90° STANDARD TIP



## 88° & 90° THIN TIP



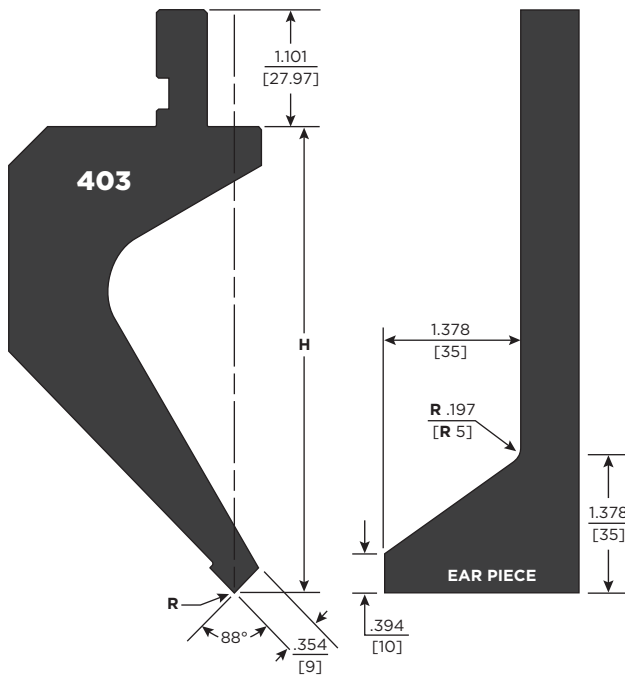
Cat. No.		A Angle	R Tip Radius inch [mm]	H Height inch [mm]	LT & ST	XT	Weight lbs/in [kg/mm]	LT	ST	XT
Straight	Beveled				Max. Ton feet [m]			32.87" [835mm]	16.34" [415mm]	32.87" [835mm]
<b>400 SERIES – 88° STANDARD TIP PUNCHES</b>										
40002	40002B	88°	.008 [0.2]	2.634 [66.9]	30 [100]	14 [47]	.86 [.015]			
40008	40008B		.030 [0.8]	2.624 [66.6]						
40015	40015B		.060 [1.5]	2.612 [66.3]						
40023	40023B		.090 [2.3]	2.598 [66.0]						
40030	40030B		.120 [3.0]	2.586 [65.7]						
<b>400 SERIES – 90° STANDARD TIP PUNCHES</b>										
40102	40102B	90°	.008 [0.2]	2.634 [66.9]	30 [100]	14 [47]	.86 [.015]			
40108	40108B		.030 [0.8]	2.624 [66.7]						
40115	40115B		.060 [1.5]	2.613 [66.4]						
40123	40123B		.090 [2.3]	2.600 [66.0]						
40130	40130B		.120 [3.0]	2.588 [65.7]						

Cat. No.		A Angle	R Tip Radius inch [mm]	H Height inch [mm]	LT & ST	XT	Weight lbs/in [kg/mm]	LT	ST	XT
Straight	Beveled				Max. Ton feet [m]			32.87" [835mm]	16.34" [415mm]	32.87" [835mm]
<b>402 SERIES – 88° &amp; 90° THIN TIP PUNCHES</b>										
40212	40212B	88°	.008 [0.2]	2.634 [66.9]	12 [40]	3 [10]	.86 [0.015]			
40202	40202B	90°	.008 [0.2]	2.634 [66.9]						

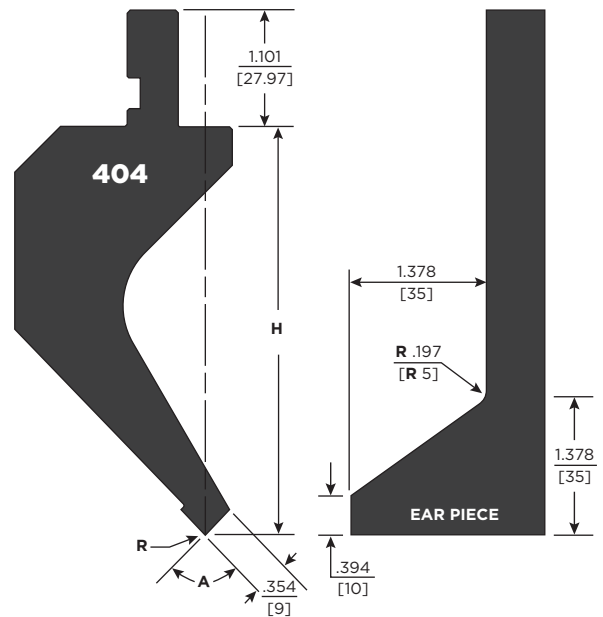
Note: Punch relief available at an additional cost. Contact a Tooling Technician for pricing and lead times.



## 88° GOOSENECK



## 88° & 90° GOOSENECK



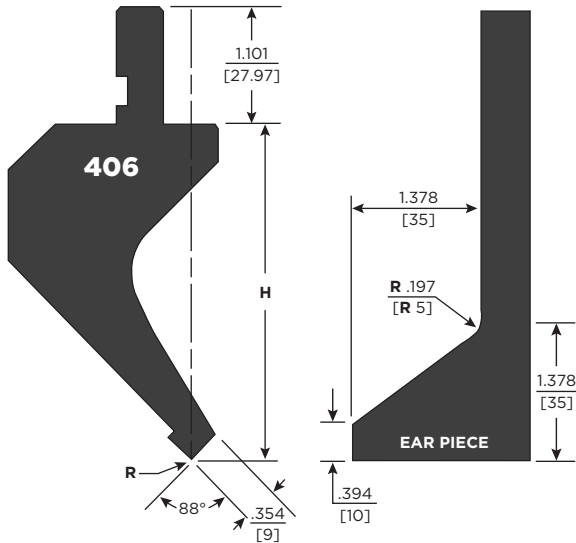
Cat. No.		A Angle	R Tip Radius inch [mm]	H Height inch [mm]	Max. Ton feet [m]	Weight lbs/in [kg/mm]	LT	ST	XT
Straight	Beveled						32.87" [835mm]	16.34" [415mm]	32.87" [835mm]
<b>403 SERIES — 88° GOOSENECK PUNCHES</b>									
40302	40302B	88°	.008 [0.2]	4.721 [119.9]	15 [50]	1.68 [.030]			
40308	40308B		.030 [0.8]	4.711 [119.7]					

Cat. No.		A Angle	R Tip Radius inch [mm]	H Height inch [mm]	LT & ST	XT	Weight lbs/in [kg/mm]	LT	ST	XT
Straight	Beveled				Max. Ton feet [m]			32.87" [835mm]	16.34" [415mm]	32.87" [835mm]
<b>404 SERIES — 88° &amp; 90° GOOSENECK PUNCHES</b>										
40402	40402B	88°	.008 [0.2]	4.130 [104.9]	15 [50]	14 [47]	1.54 [.027]			
40408	40408B		.030 [0.8]	4.120 [104.6]						
40415	40415B		.060 [1.5]	4.108 [104.3]						
40430	40430B		.120 [3.0]	4.082 [103.7]						
40502	40502B	90°	.008 [0.2]	4.130 [104.9]						

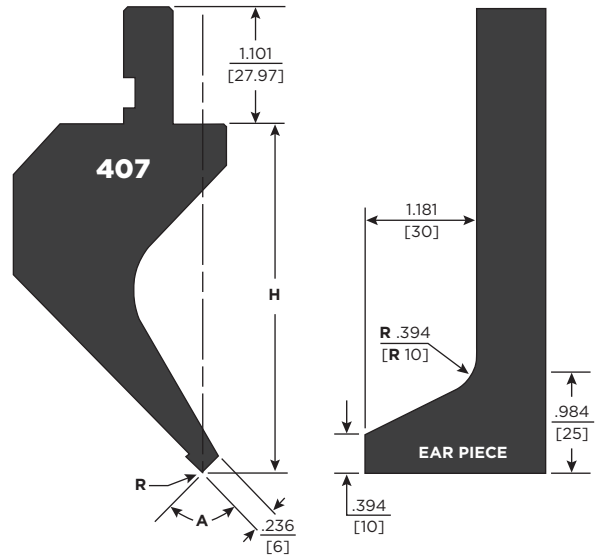
Note: Punch relief available at an additional cost.  
Contact a Tooling Technician for pricing and lead times.

= 30 lbs. / 13.6kg or more

## 88° GOOSENECK STANDARD TIP



## 88° & 90° GOOSENECK THIN TIP



EUROPEAN TRADITIONAL

Cat. No.		A Angle	R Tip Radius inch [mm]	H Height inch [mm]	LT & ST	XT	Weight lbs/in [kg/mm]	LT	ST	XT
Straight	Beveled				Max. Ton feet [m]			32.87" [835mm]	16.34" [415mm]	32.87" [835mm]
<b>406 SERIES — 88° STANDARD TIP GOOSENECK PUNCHES</b>										
40602	40602B	88°	.008 [0.2]	3.539 [89.9]	21 [70]	14 [47]	1.29 [.023]			
40608	40608B		.030 [0.8]	3.529 [89.6]						
40615	40615B		.060 [1.5]	3.517 [89.3]						
40630	40630B		.120 [3.0]	3.491 [88.7]						

Cat. No.		A Angle	R Tip Radius inch [mm]	H Height inch [mm]	LT & ST	XT	Weight lbs/in [kg/mm]	LT	ST	XT
Straight	Beveled				Max. Ton feet [m]			32.87" [835mm]	16.34" [415mm]	32.87" [835mm]
<b>407 SERIES — 88° THIN TIP GOOSENECK PUNCHES</b>										
40702	40702B	88°	.008 [0.2]	3.539 [89.9]	15 [50]	9 [30]	1.29 [.023]			
40708	40708B		.030 [0.8]	3.529 [89.6]						
<b>407 SERIES — 90° THIN TIP GOOSENECK PUNCHES</b>										
40712	40712B	90°	.008 [0.2]	3.539 [89.9]	15 [50]	9 [30]	1.29 [.023]			
40718	40718B		.030 [0.8]	3.530 [89.7]						

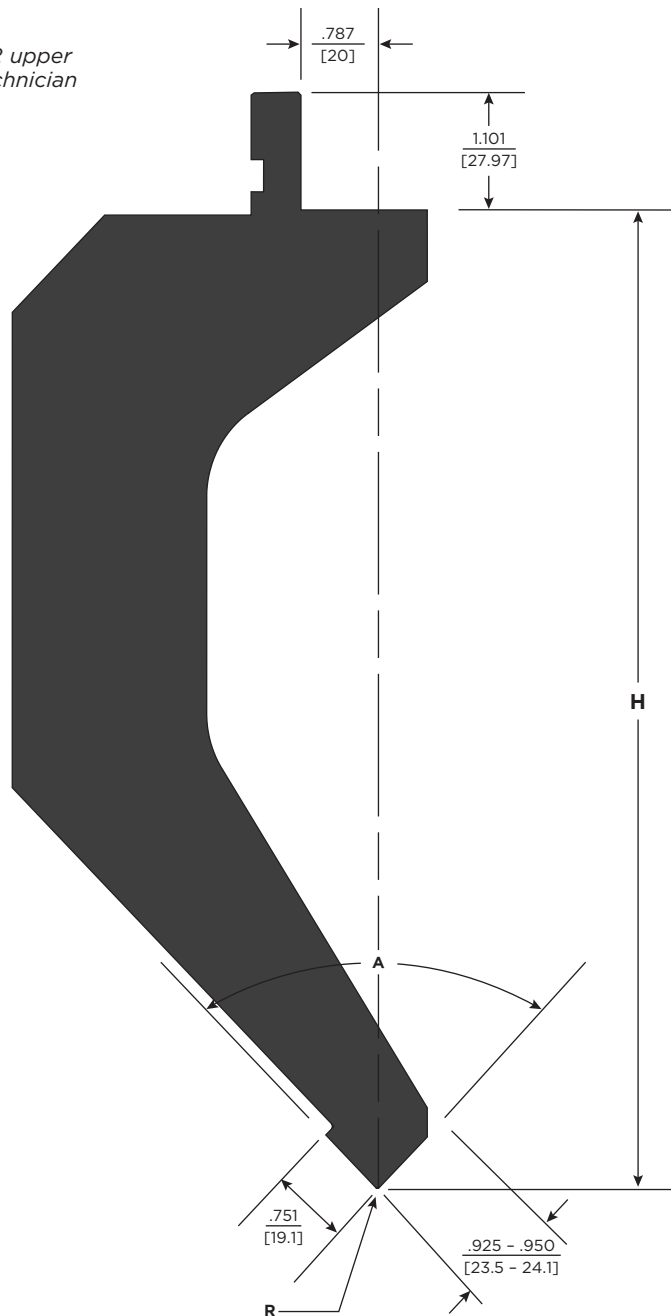
Note: Punch relief available at an additional cost.  
Contact a Tooling Technician for pricing and lead times.

= 30 lbs. / 13.6kg or more








# Z2 STYLE GOOSENECK

Note: This punch mounts to Z2 upper beam. Please call a Tooling Technician for further explanation.

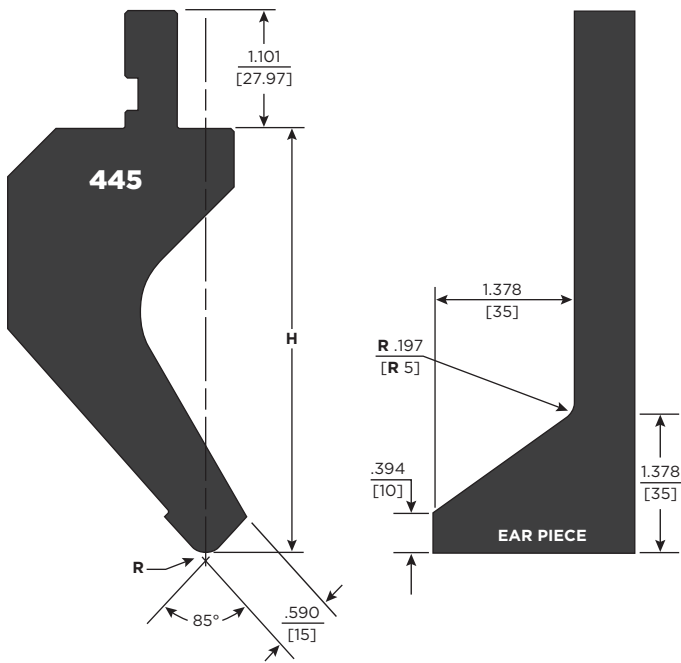


EUROPEAN TRADITIONAL

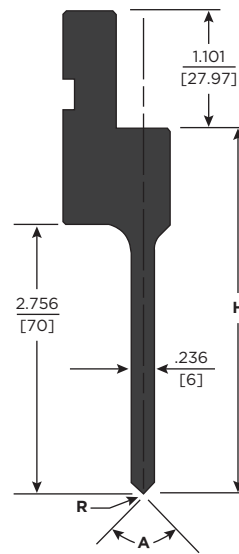
Cat. No.		A Angle	R Tip Radius inch [mm]	H Height inch [mm]	Max. Ton feet [m]	Weight lbs/in [kg/mm]	S	200mm
Straight	Beveled						16.34" [415mm]	7.87" [200mm]
<b>Z2 STYLE GOOSENECK PUNCHES</b>								
43080C	43080CB	85° - 90°	.008 - .7 [0.2 - 17.75]	Variable 9.555 [242.7]	25 [83]	6.0 [.100]		
43081	43081B	88°	.030 [0.8]					

 = 30 lbs. / 13.6kg or more

## 85° GOOSENECK



## 88° & 90° NARROW



EUROPEAN TRADITIONAL

Cat. No.		A Angle	R Tip Radius inch [mm]	H Height inch [mm]	LT & ST	XT	Weight lbs/in [kg/mm]	LT	ST	XT
Straight	Beveled				Max. Ton feet [m]			32.87" [835mm]	16.34" [415mm]	32.87" [835mm]
<b>445 SERIES — 85° GOOSENECK PUNCHES</b>										
44540	44540B	85°	.188 [4.8]	4.134 [105.0]	30 [100]	14 [47]	1.68 [.030]			
44560	44560B		.250 [6.4]	4.105 [104.3]						

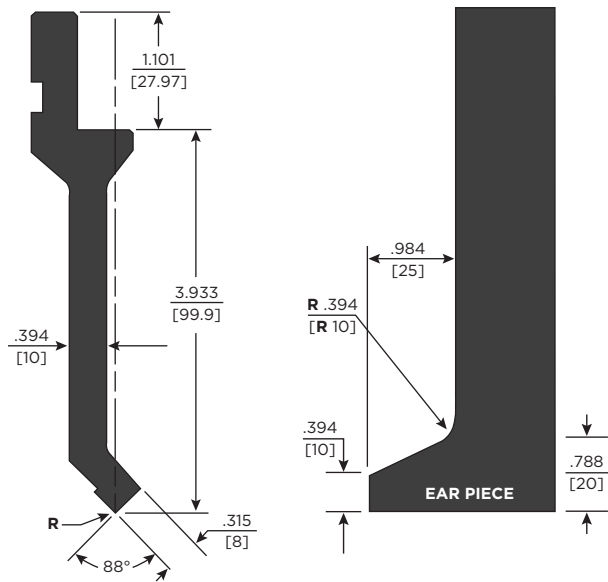
Cat. No.		A Angle	R Tip Radius inch [mm]	H Height inch [mm]	Max. Ton feet [m]	Weight lbs/in [kg/mm]	LT	ST	XT
Straight	Beveled						32.87" [835mm]	16.34" [415mm]	32.87" [835mm]
<b>88° &amp; 90° NARROW PUNCHES</b>									
40802	40802B	88°	.008 [0.2]	3.740 [95.0]	15 [50]	0.70 [.012]			
40902	40902B	90°	.008 [0.2]						

Note: Sectionalized version does not include ear pieces (horns). Ear pieces (horns) available at an additional cost. Punch relief available at an additional cost. Contact a Tooling Technician for pricing and lead times.

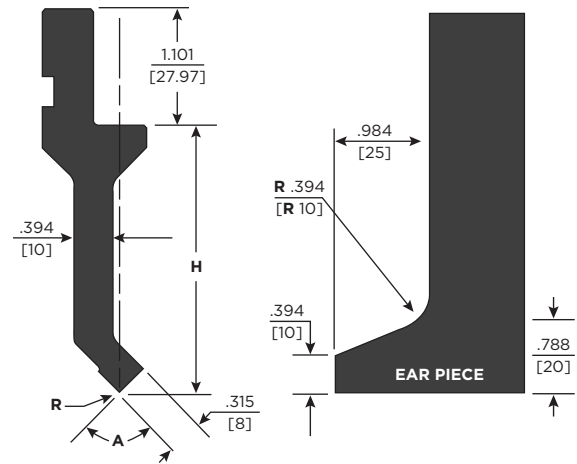
= 30 lbs. / 13.6kg or more



## 88° SASH - TALL



## 88° & 90° SASH - SHORT

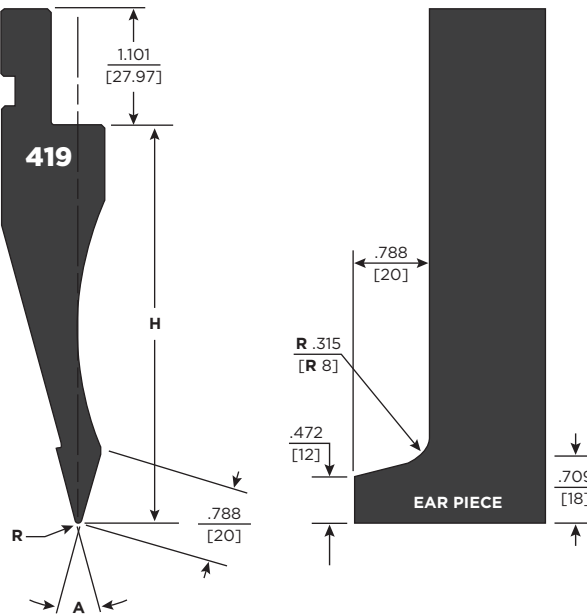


Cat. No.		A Angle	R Tip Radius inch [mm]	H Height inch [mm]	Max. Ton feet [m]	Weight lbs/in [kg/mm]	LT	ST	XT
Straight	Beveled						32.87" [835mm]	16.34" [415mm]	32.87" [835mm]
<b>88° SASH PUNCHES — TALL</b>									
41002	41002B	88°	.008 [0.2]	3.933 [99.9]	10 [30]	0.70 [.012]			

Cat. No.		A Angle	R Tip Radius inch [mm]	H Height inch [mm]	Max. Ton feet [m]	Weight lbs/in [kg/mm]	LT	ST	XT
Straight	Beveled						32.87" [835mm]	16.34" [415mm]	32.87" [835mm]
<b>88° &amp; 90° SASH PUNCHES — SHORT</b>									
41102	41102B	88°	.008 [0.2]	2.752 [69.9]	10 [30]	0.51 [.009]			
41202	41202B	90°							

Note: Punch relief available at an additional cost. Contact a Tooling Technician for pricing and lead times.

# 30° ACUTE - TALL



EUROPEAN TRADITIONAL

Cat. No.		A Angle	R Tip Radius inch [mm]	H Height inch [mm]	LT & ST	XT	Weight lbs/in [kg/mm]	LT	ST	XT
Straight	Beveled				Max. Ton feet [m]			32.87" [835mm]	16.34" [415mm]	32.87" [835mm]
<b>419 SERIES — 30° ACUTE PUNCHES — TALL</b>										
41908c		30°	.008 [0.2]	4.162 [105.7]	30 [100]	14 [47]	1.01 [.018]			
41908	41908B		.030 [0.8]	4.095 [104.0]						
41915	41915B		.060 [1.5]	4.016 [102.0]						
41923	41923B		.090 [2.3]	3.927 [99.7]						
41930	41930B		.120 [3.0]	3.846 [97.7]						
41948	41948B		.188 [4.8]	3.648 [92.7]						
41964	41964B		.250 [6.35]	3.469 [88.1]						

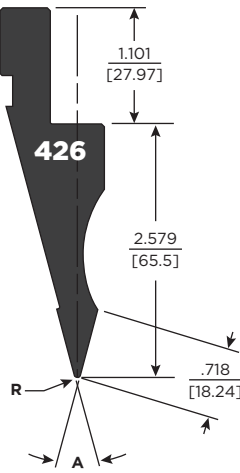
Note: Punch relief available at an additional cost.  
Contact a Tooling Technician for pricing and lead times.

= 30 lbs. / 13.6kg or more

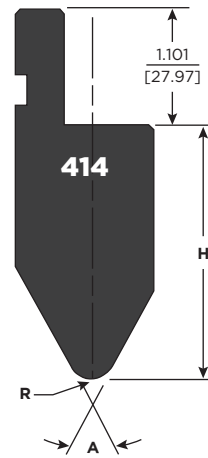





## 30° ACUTE - SHORT




## 60° ACUTE



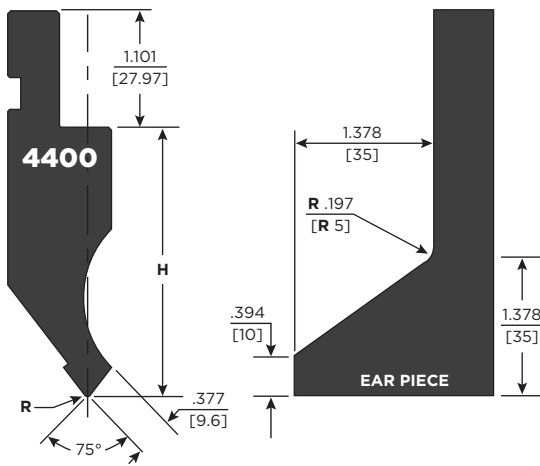
Cat. No.		A Angle	R Tip Radius inch [mm]	H Height inch [mm]	Max. Ton feet [m]	Weight lbs/in [kg/mm]	LT	ST	XT
Straight	Beveled						32.87" [835mm]	16.34" [415mm]	32.87" [835mm]
<b>426 SERIES — 30° ACUTE PUNCHES — SHORT</b>									
42610c		30°	.008 [0.2]	2.646 [67.2]	30 [100]	0.51 [.009]			
42610	42610B		.030 [0.8]	2.579 [65.5]					

Cat. No.		A Angle	R Tip Radius inch [mm]	H Height inch [mm]	Max. Ton feet [m]	Weight lbs/in [kg/mm]	LT	ST	XT
Straight	Beveled						32.87" [835mm]	16.34" [415mm]	32.87" [835mm]
<b>414 SERIES — 60° ACUTE PUNCHES</b>									
41440	41440B	60°	.188 [4.8]	2.607 [66.2]	30 [100]	1.01 [.018]			
41460	41460B		.236 [6.0]	2.559 [65.0]					

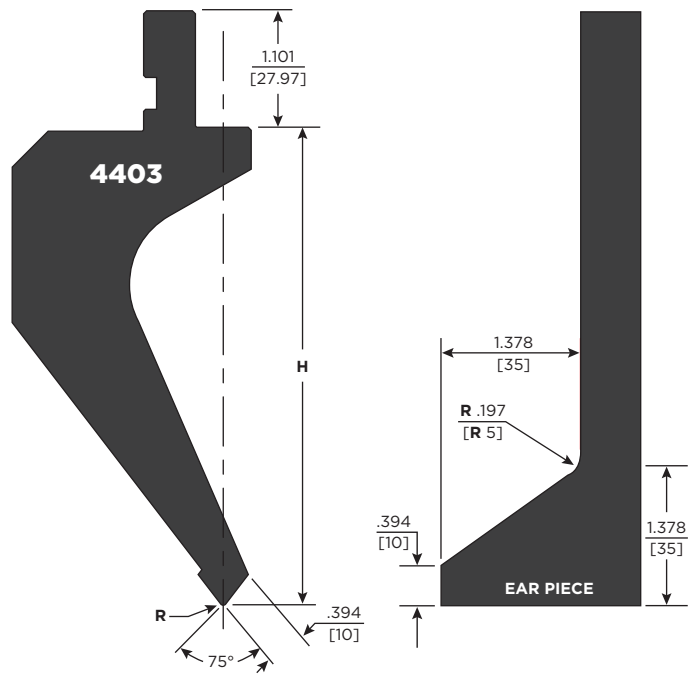
Note: Punch relief available at an additional cost.  
Contact a Tooling Technician for pricing and lead times.

 = 30 lbs. / 13.6kg or more

## 75° STANDARD



## 75° GOOSENECK



Cat. No.		A Angle	R Tip Radius inch [mm]	H Height inch [mm]	LT & ST	XT	Weight lbs/in [kg/mm]	LT	ST	XT
Straight	Beveled				Max. Ton feet [m]			32.87" [835mm]	16.34" [415mm]	32.87" [835mm]
<b>4400 SERIES — 75° STANDARD PUNCHES</b>										
44000	44000B	75°	.030 [0.8]	2.662 [67.6]	30 [100]	14 [47]	0.86 [.015]			
44001	44001B		.060 [1.5]	2.645 [67.2]						
44003	44003B		.120 [3.0]	2.607 [66.2]						

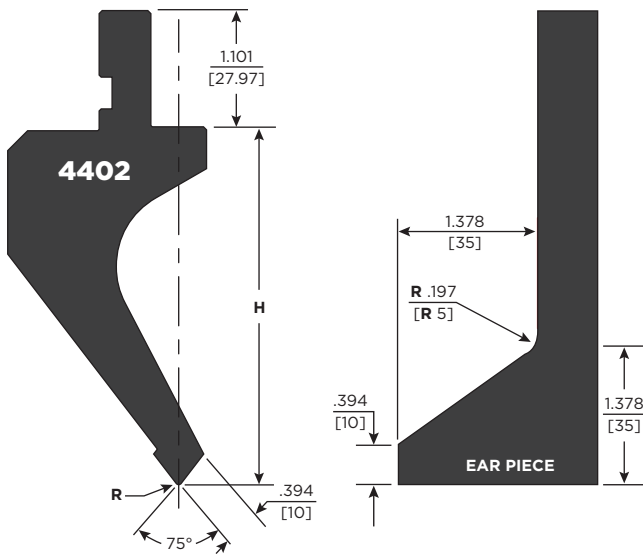
Cat. No.		A Angle	R Tip Radius inch [mm]	H Height inch [mm]	Max. Ton feet [m]	Weight lbs/in [kg/mm]	LT	ST	XT
Straight	Beveled						32.87" [835mm]	16.34" [415mm]	32.87" [835mm]
<b>4403 SERIES — 75° GOOSENECK PUNCHES</b>									
44030	44030B	75°	.030 [0.8]	4.724 [120.0]	15 [50]	1.68 [.030]			
44031	44031B		.060 [1.5]	4.707 [119.5]					
44033	44033B		.120 [3.0]	4.669 [118.6]					

Note: Punch relief available at an additional cost.  
Contact a Tooling Technician for pricing and lead times.

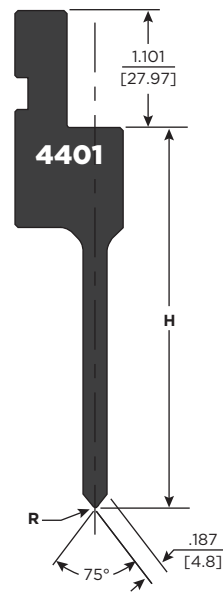
= 30 lbs. / 13.6kg or more



## 75° GOOSENECK



## 75° NARROW



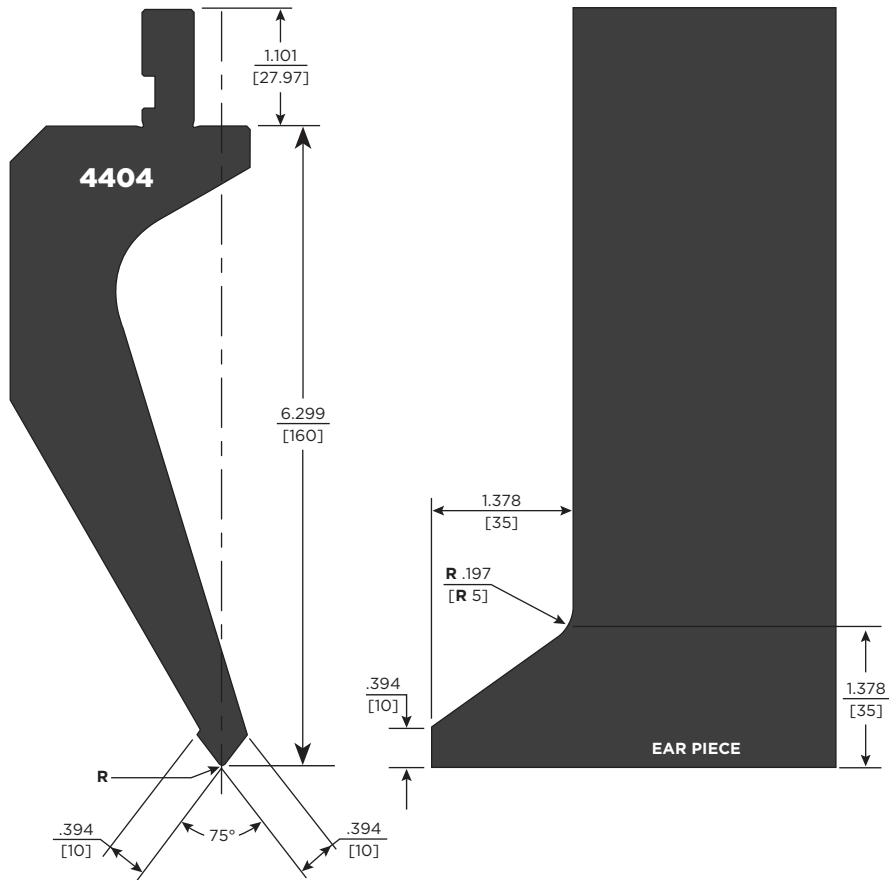
Cat. No.		A Angle	R Tip Radius inch [mm]	H Height inch [mm]	LT & ST	XT	Weight lbs/in [kg/mm]	LT	ST	XT
Straight	Beveled				Max. Ton feet [m]			32.87" [835mm]	16.34" [415mm]	32.87" [835mm]
<b>4402 SERIES — 75° GOOSENECK PUNCH</b>										
44020	44020B	75°	.030 [0.8]	3.543 [90.0]	21 [70]	14 [47]	1.68 [.030]			

Cat. No.		A Angle	R Tip Radius inch [mm]	H Height inch [mm]	LT & ST	XT	Weight lbs/in [kg/mm]	LT	ST	XT
Straight	Beveled				Max. Ton feet [m]			32.87" [835mm]	16.34" [415mm]	32.87" [835mm]
<b>4401 SERIES — 75° NARROW PUNCH</b>										
44010	44010B	75°	.030 [0.8]	3.740 [95.0]	15 [50]	15 [50]	0.70 [.012]			

Note: Sectionalized version does not include ear pieces (horns). Ear pieces (horns) available at an additional cost (44010). Punch relief available at an additional cost. Contact a Tooling Technician for pricing and lead times.

= 30 lbs. / 13.6kg or more

# 75° LARGE GOOSENECK



EUROPEAN TRADITIONAL

Cat. No.		A Angle	R Tip Radius inch [mm]	Height inch [mm]	LT & ST	XT	Weight lbs/in [kg/mm]	LT	ST	XT	200mm
Straight	Beveled				Max. Ton feet [m]	32.87" [835mm]		16.34" [415mm]	32.87" [835mm]	7.87" [200mm]	
<b>4404 SERIES — 75° LARGE GOOSENECK PUNCH</b>											
44040	44040B	75°	.030 [0.8]	6.299 [160.0]	15 [50]	14 [47]	2.17 [.039]				

Note: Sectionalized version does not include ear pieces (horns). Ear pieces (horns) available at an additional cost (44010). Punch relief available at an additional cost. Contact a Tooling Technician for pricing and lead times.

= 30 lbs. / 13.6kg or more



# HOW TO READ AN AIR BENDING FORCE CHART

The Air Bending Force Chart is a simple grid to help determine the correct V-Opening to use. It is based on 90° bends and all numbers are estimations. Visit our YouTube channel to walk through using this chart.

- Tonnage calculation
- Minimum Flange (OD)
- Radius Produced

Watch the video on our YouTube Channel!

**AIR BENDING FORCE CHART**  
IMPERIAL TONNAGE • IMPERIAL V-OPENINGS

NOTE: Formulas and chart are for reference only.  
T = Material Thickness; V = V-Opening; MF = Minimum Flange Length; IR = Inside Radius

STANDARD FORMULAS FOR SELECTING A V-OPENING  
Material Thickness: 120° or Less = T x 6  
120° - 137° = T x 8  
137° - 150° = T x 10  
150° - 165° = T x 12

**AIR BENDING FORCE CHART**  
IMPERIAL TONNAGE • IMPERIAL V-OPENINGS

NOTE: Formulas and chart are for reference only.  
T = Material Thickness; V = V-Opening; MF = Minimum Flange Length; IR = Inside Radius

STANDARD FORMULAS FOR SELECTING A V-OPENING  
Material Thickness: 120° or Less = T x 6  
120° - 137° = T x 8  
137° - 150° = T x 10  
150° - 165° = T x 12

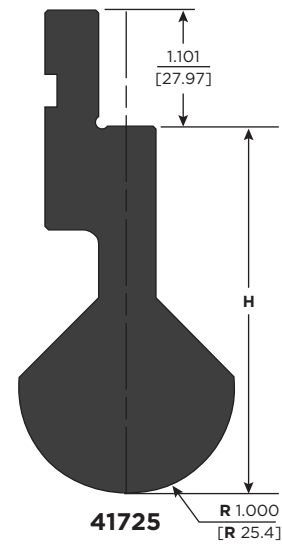
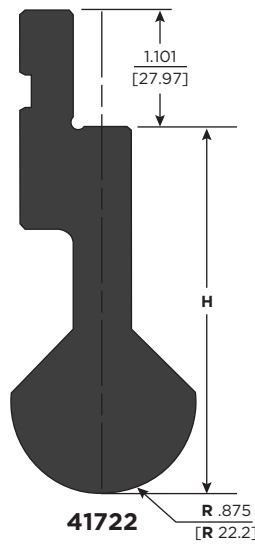
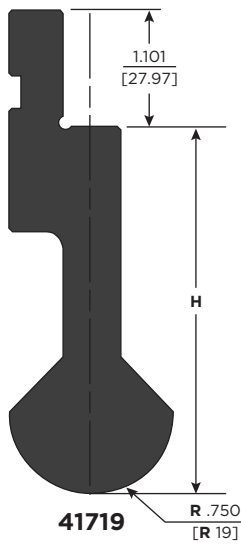
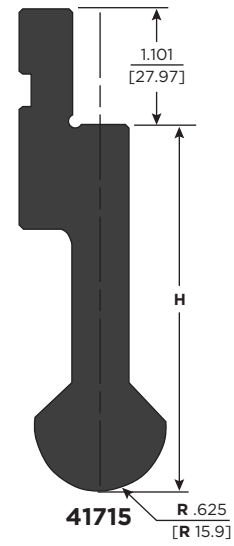
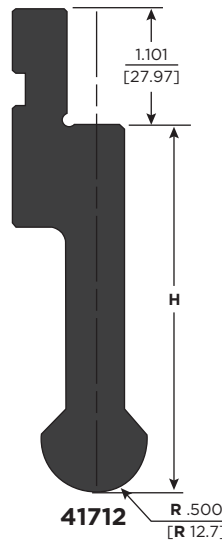
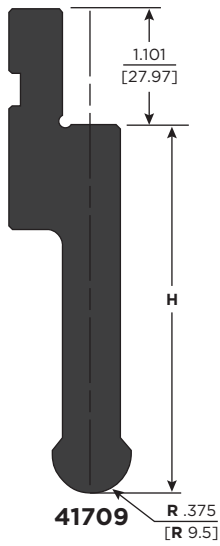
For more information, visit [wilsontool.com](http://wilsontool.com), call our tooling technicians at 800-445-4518 or contact your sales engineer.

US Headquarters tel: 800.445.4518 | Canada tel: 800.268.4180 | Mexico tel: 001.800.741.2510  
bending@wilsontool.com | bendingcanada@wilsontool.com | doblez@wilsontool.com



		V (in.)	0.250	0.313	0.375	0.500	0.625	0.750	0.875	1.000	1.125	1.250
		MF	0.180	0.225	0.270	0.360	0.450	0.540	0.630	0.720	0.810	0.900
GAUGE	DEC. inch [mm]	IR	0.042	0.052	0.063	0.084	0.104	0.125	0.146	0.167	0.188	0.209
20	0.036 [.9]		2.9	2.2	1.7	1.2	1.0					
18	0.048 [1.2]		7.0	4.0	2.9	2.2	1.6	1.3				
16	0.060 [1.5]			7.8	5.6	3.6	2.7	2.2	1.7			
14	0.075 [1.9]				11.7	6.0	4.5	3.4	3.0	2.5	2.1	
13	0.090 [2.3]					12.2	6.8	5.4	4.3	3.7	3.3	2.9
12	0.105 [2.7]						10.1	7.4	6.3	5.4	4.4	4.0
11	0.120 [3]							10.5	8.8	7.2	6.2	5.4
10	0.135 [3.4]								11.3	9.6	8.4	7.0

EUROPEAN TRADITIONAL

## LARGE RADIUS PUNCHES - ONE PIECE DESIGN



EUROPEAN TRADITIONAL

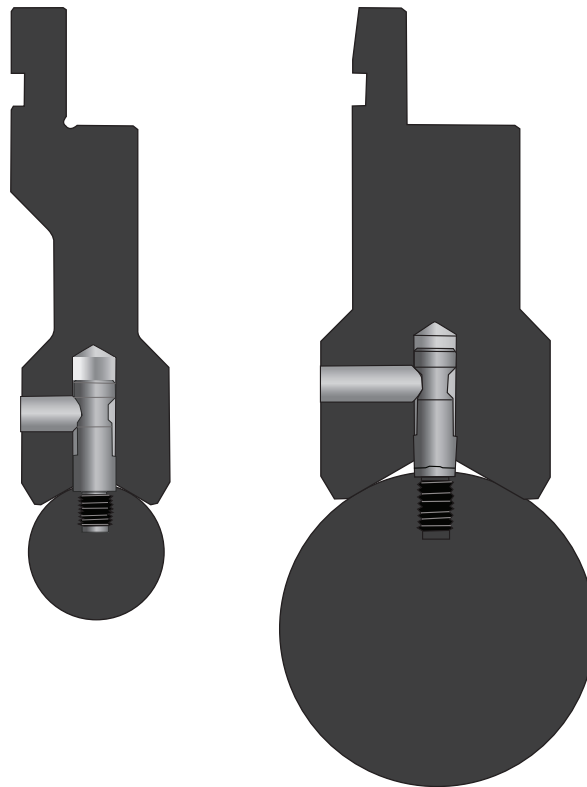
Cat. No.		H Height inch [mm]	Max. Ton feet [m]	Weight lbs/in [kg/mm]	LT	ST	XT
Straight	Beveled				32.87" [835mm]	16.34" [415mm]	32.87" [835mm]
41709	41709B	3.268 [83.0]	30 [100]	0.86 [.015]			
41712	41712B	3.504 [89.0]		1.01 [.018]			
41715	41715B	3.425 [87.0]		0.86 [.015]			
41719	41719B	3.583 [91.0]		1.29 [.023]			
41722	41722B	3.701 [94.0]					
41725	41725B	3.780 [96.0]					

Note: Sectionalized version does not include ear pieces (horns).  
Ear pieces (horns) available at an additional cost. Additional radii available, please contact a Tooling Technician.

 = 30 lbs. / 13.6kg or more



# LARGE RADIUS HOLDER & TIP ASSEMBLY



**CAUTION:** Do not load the radius tip into the holder while in the machine. Remove the holder from the machine to change radius.

EUROPEAN TRADITIONAL

Radius Cat. No.	Radius Size inch [mm]	Radius Weight lbs/in [kg/mm]	Radius Price	Stem Bolt Cat. No.	Holder Cat. No.	Holder Width inch [mm]	Holder Weight lbs/in [kg/mm]	Holder Price	Assembled Height inch [mm]	Max. Ton feet [m]			
<b>LARGE RADIUS AND HOLDER      LENGTH: 19.685" [500mm]</b>													
6R095-500	.375 [9.5]	0.18 [.003]		980101	408T35-500	1.3778 [35]	1.21 [.024]		4.055 [103]	21 [71]			
6R127-500	.500 [12.7]	0.33 [.006]							4.324 [109.8]				
6R158-500	.625 [15.8]								4.593 [116.7]				
6R190-500	.750 [19.0]	0.51 [.009]							408T35-500B				4.863 [123.5]
6R222-500	.875 [22.2]	0.70 [.012]											5.132 [130.4]
6R254-500	1.000 [25.4]	1.01 [.018]		980102	408T55-500	2.165 [55]	1.92 [.034]	KG	5.401 [137.2]				
6R381-500	1.500 [38.1]	2.03 [.036]	KG						408T55-500B				5.213 [132.4]
6R508-500	2.000 [50.8] MTO	3.63 [.065]	KG									6.290 [159.8]	
<b>LARGE RADIUS AND HOLDER      LENGTH: 9.84" [250mm]</b>													
6R381-250	1.500 [38.1]	2.03 [.036]		980102	408T55-250	2.165 [55]	1.92 [.034]		6.290 [159.8]	21 [71]			
6R508-250	2.000 [50.8]	3.63 [.065]	KG										7.058 [179.3]

NOTE: The large radius assemblies shown above are not designed to stage bend. Contact a Tooling Technician if stage bending is needed. Make to order (MTO) sizes are available upon request.

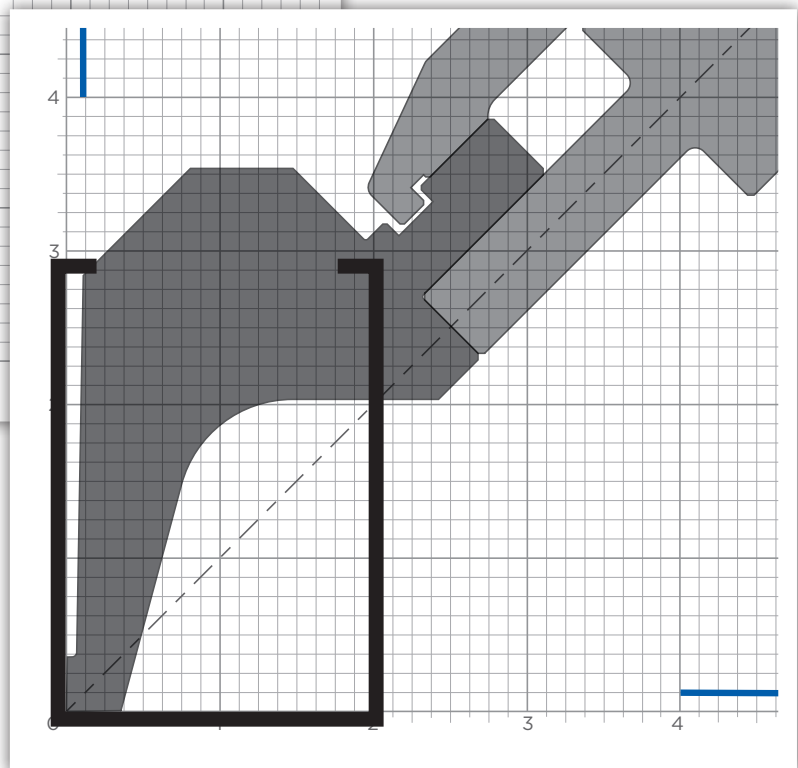
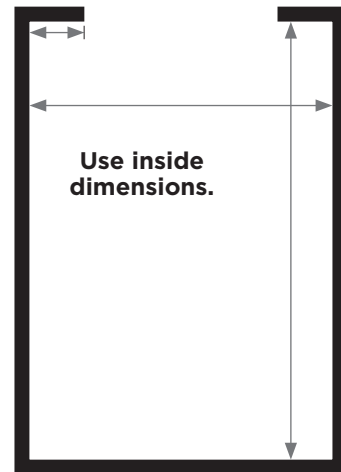
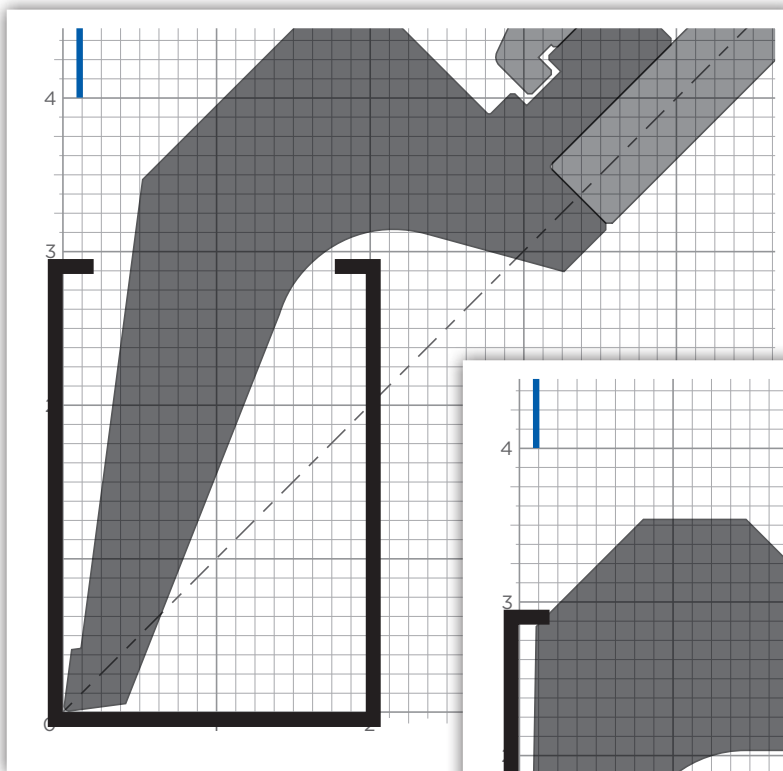
KG = 30 lbs. / 13.6kg or more

## HOW TO USE A BEND LIMIT GRAPH

Although a bend limit graph won't help with bend sequencing, it will help determine what punch profile is best for you. Visit our YouTube channel for a step-by-step video on using these graphs.

- The graphs are 1:1
- Your part can be laid on top of the catalog page
- Use inside dimensions - always account for material thickness

**This application works.**



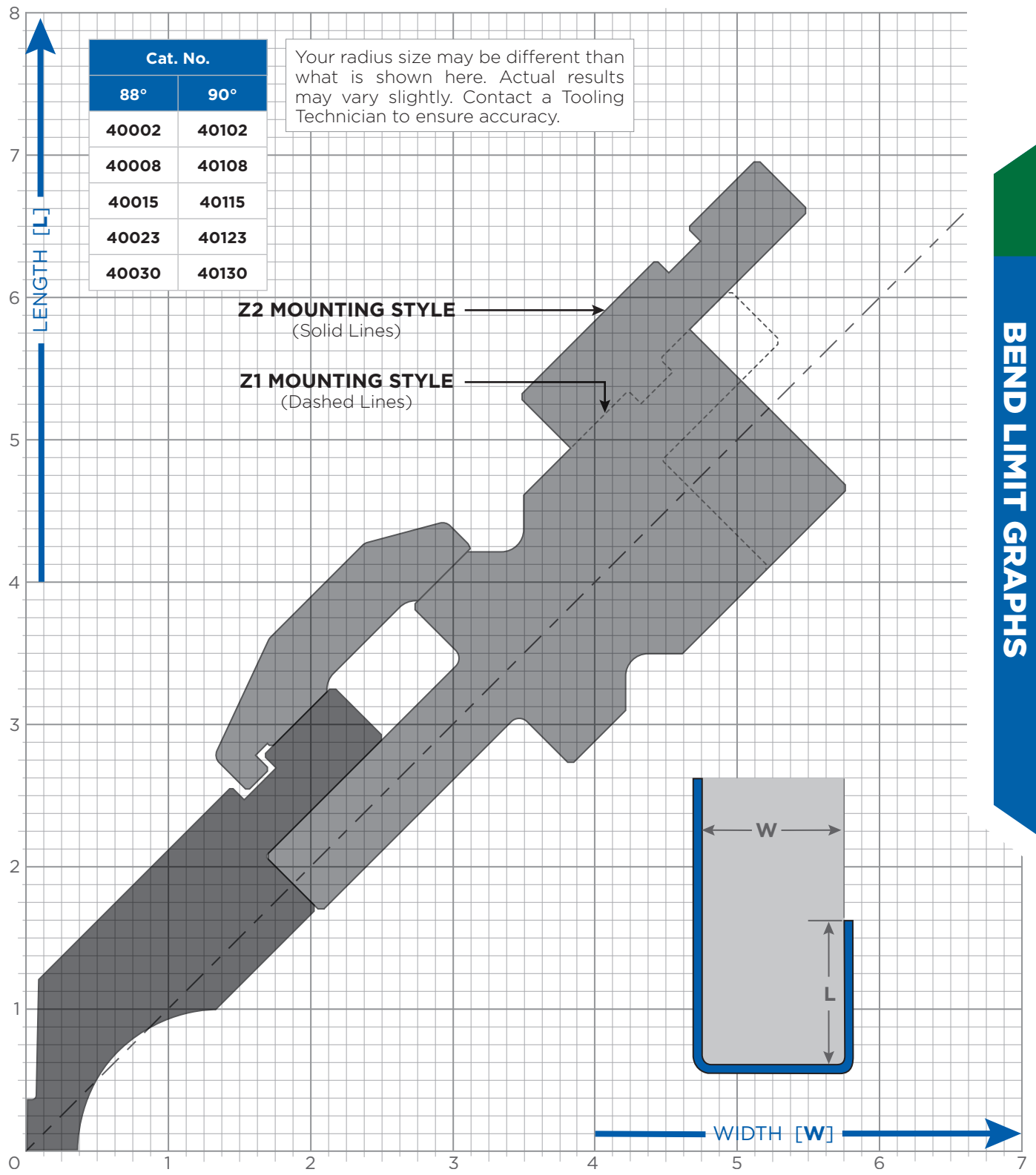
**This application doesn't work.**

 Watch the video on our YouTube Channel!



# STANDARD PUNCH

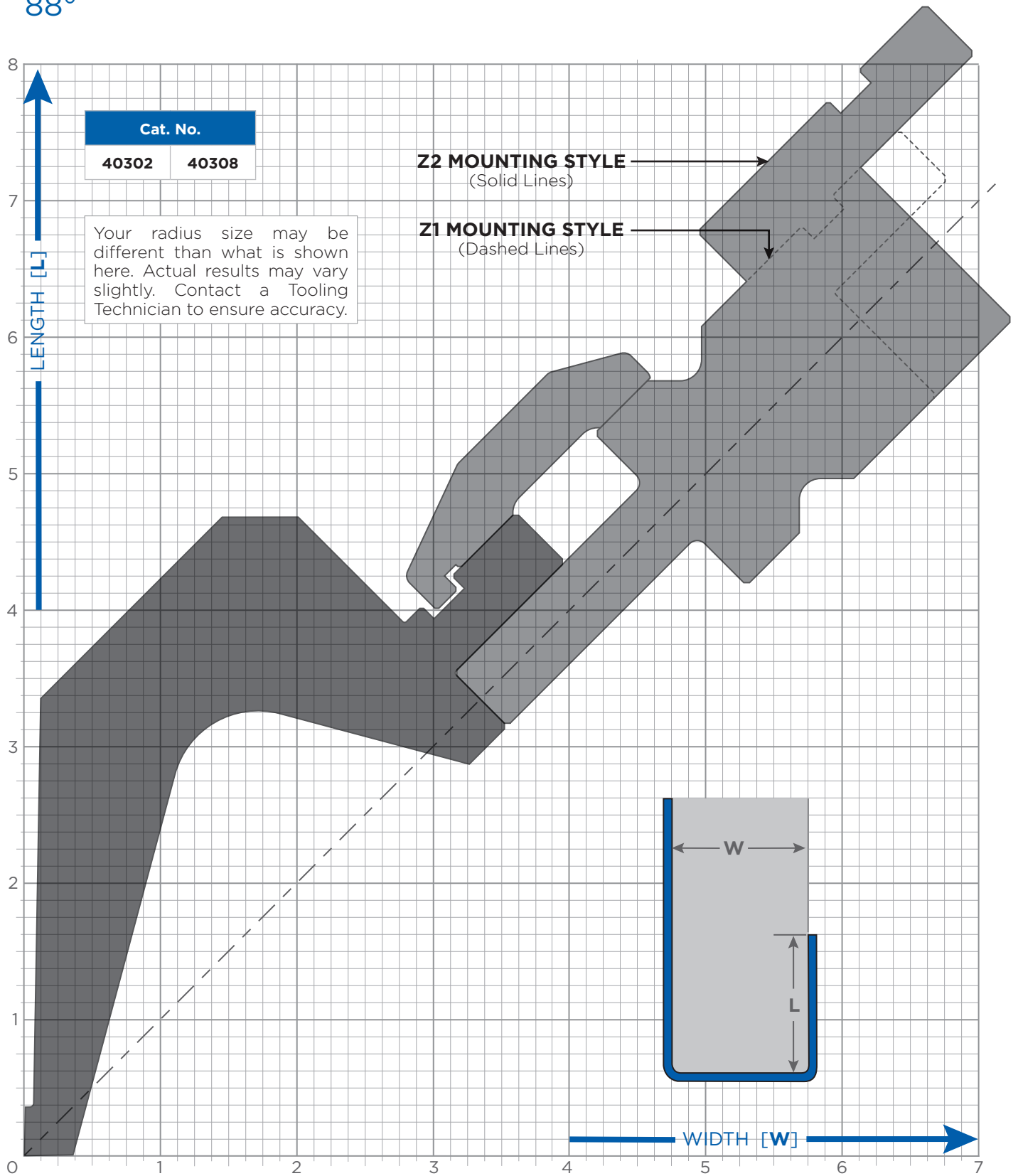
## 88° & 90°



# GOOSENECK PUNCH

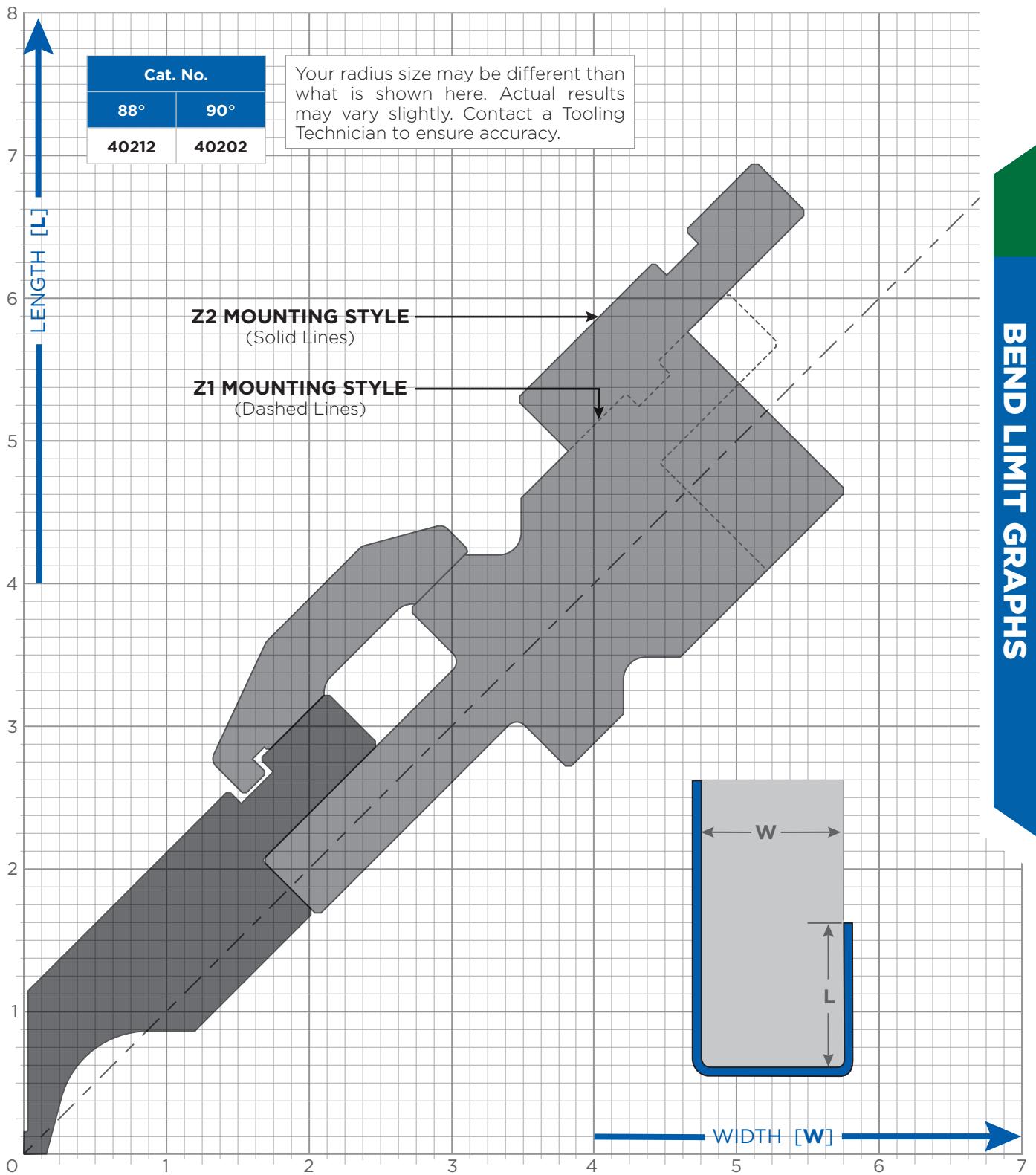
## 88°

BEND LIMIT GRAPHS



# THIN TIP STANDARD PUNCH

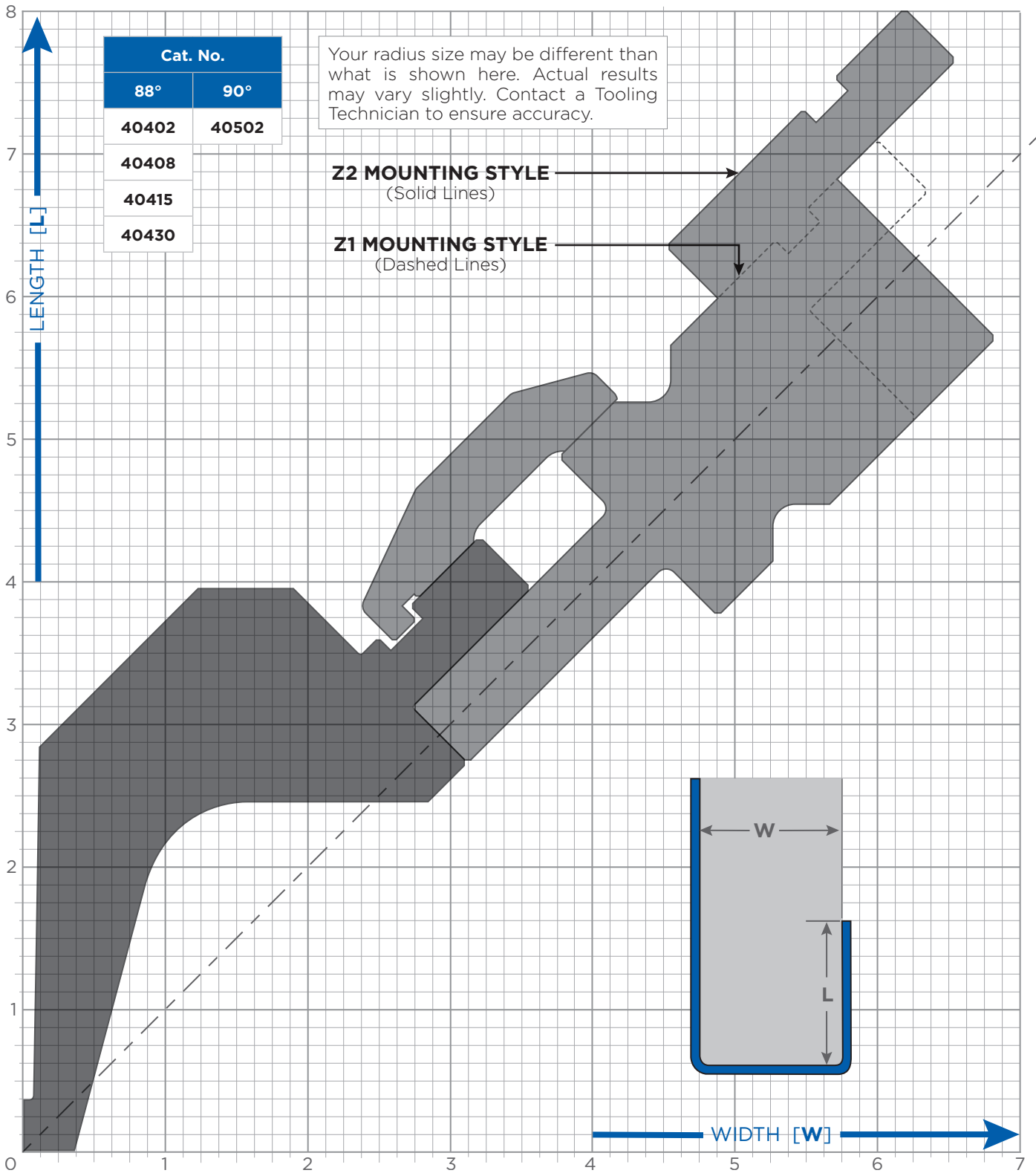
## 88° & 90°



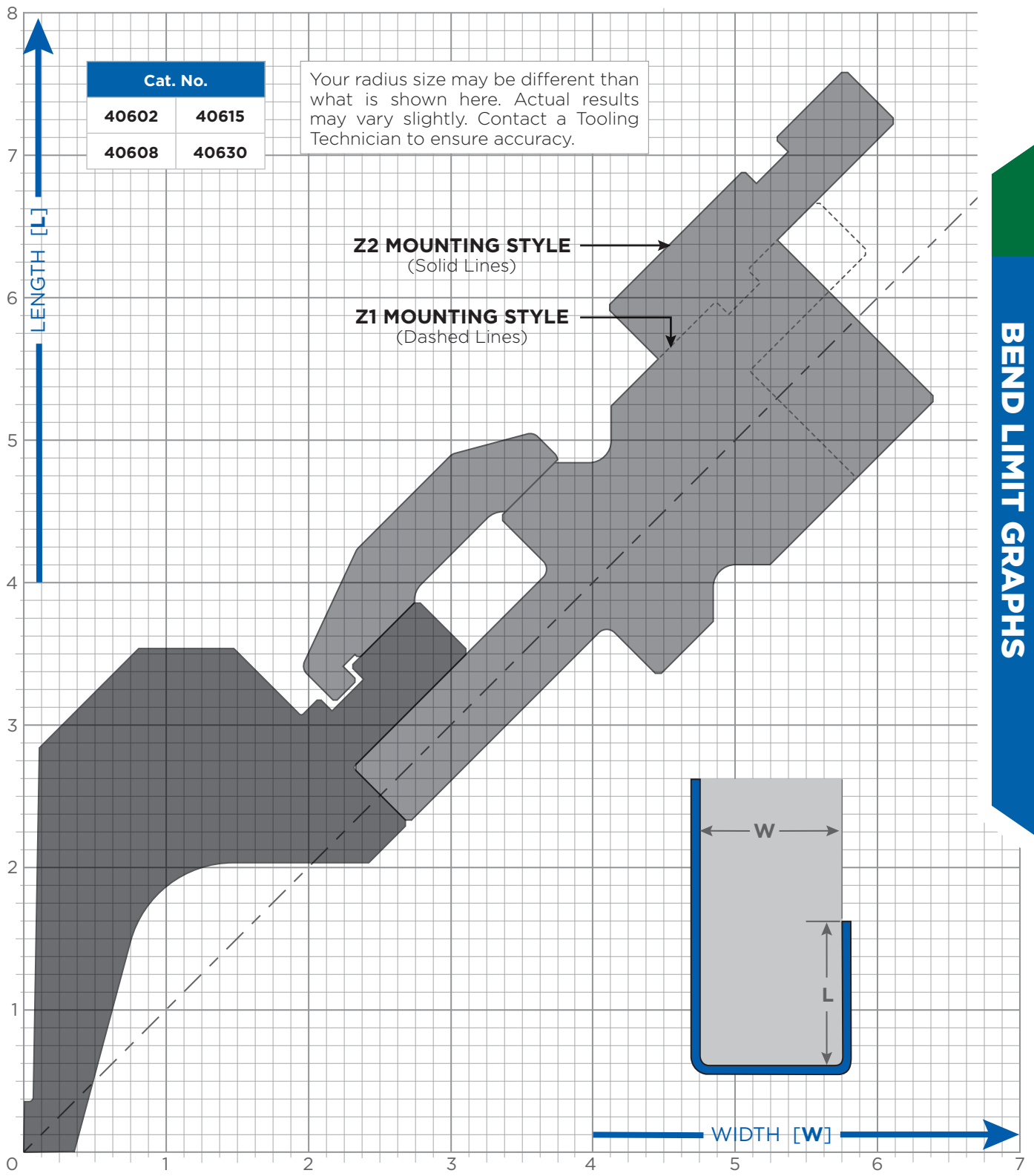
# GOOSENECK PUNCH

## 88° & 90°

BEND LIMIT GRAPHS



# GOOSENECK PUNCH 88°

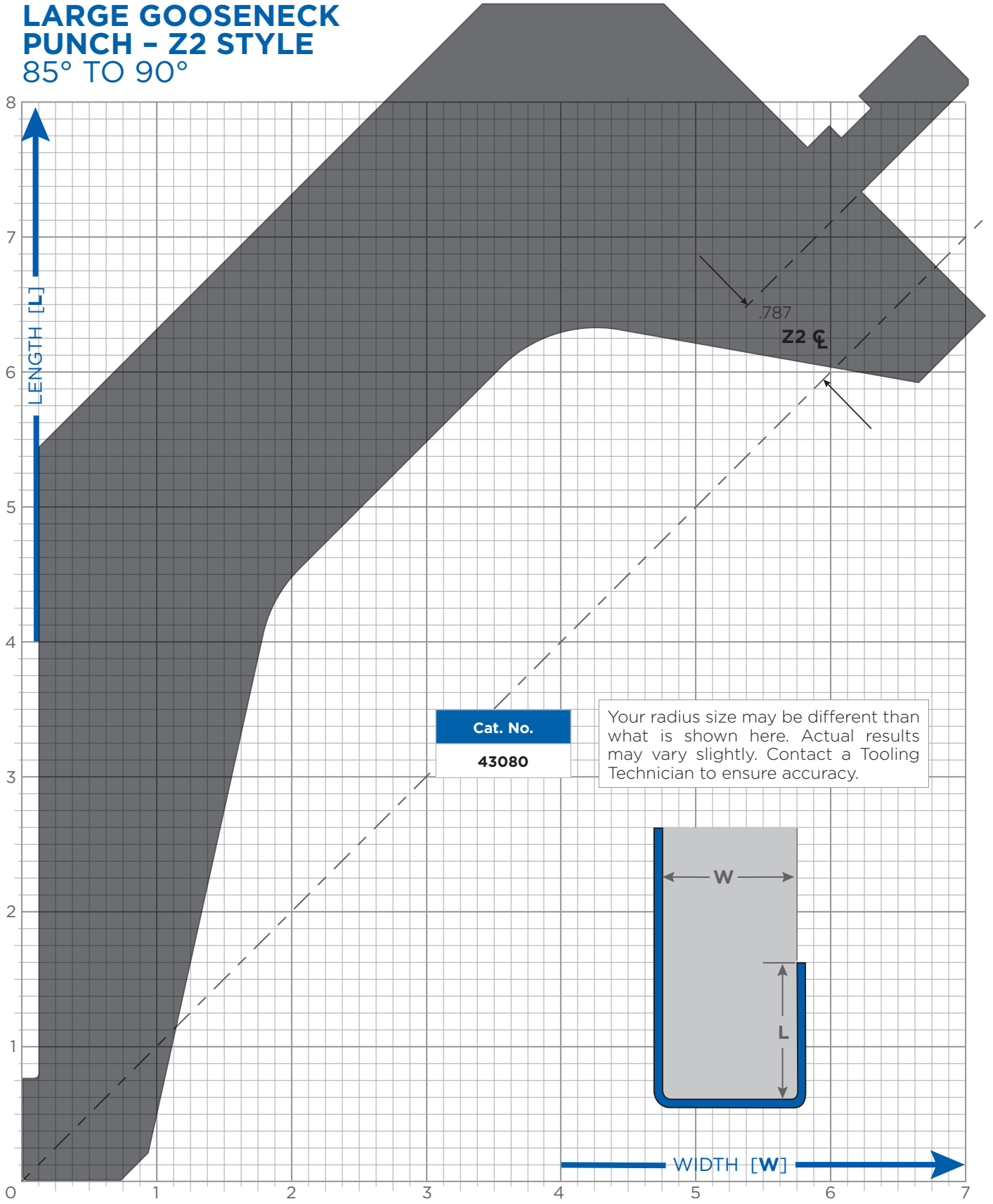


BEND LIMIT GRAPHS

# LARGE GOOSENECK PUNCH - Z2 STYLE

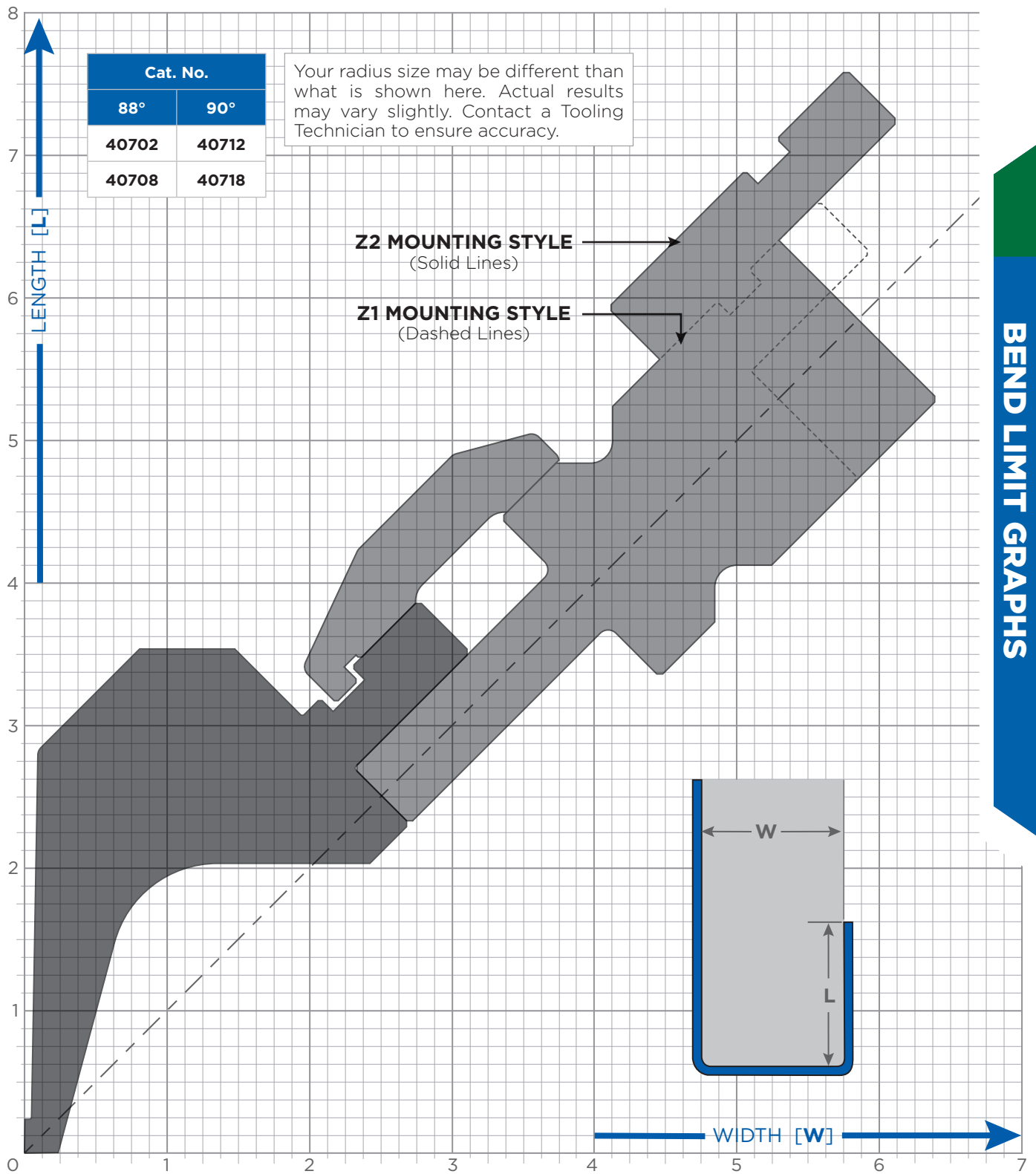
85° TO 90°

BEND LIMIT GRAPHS



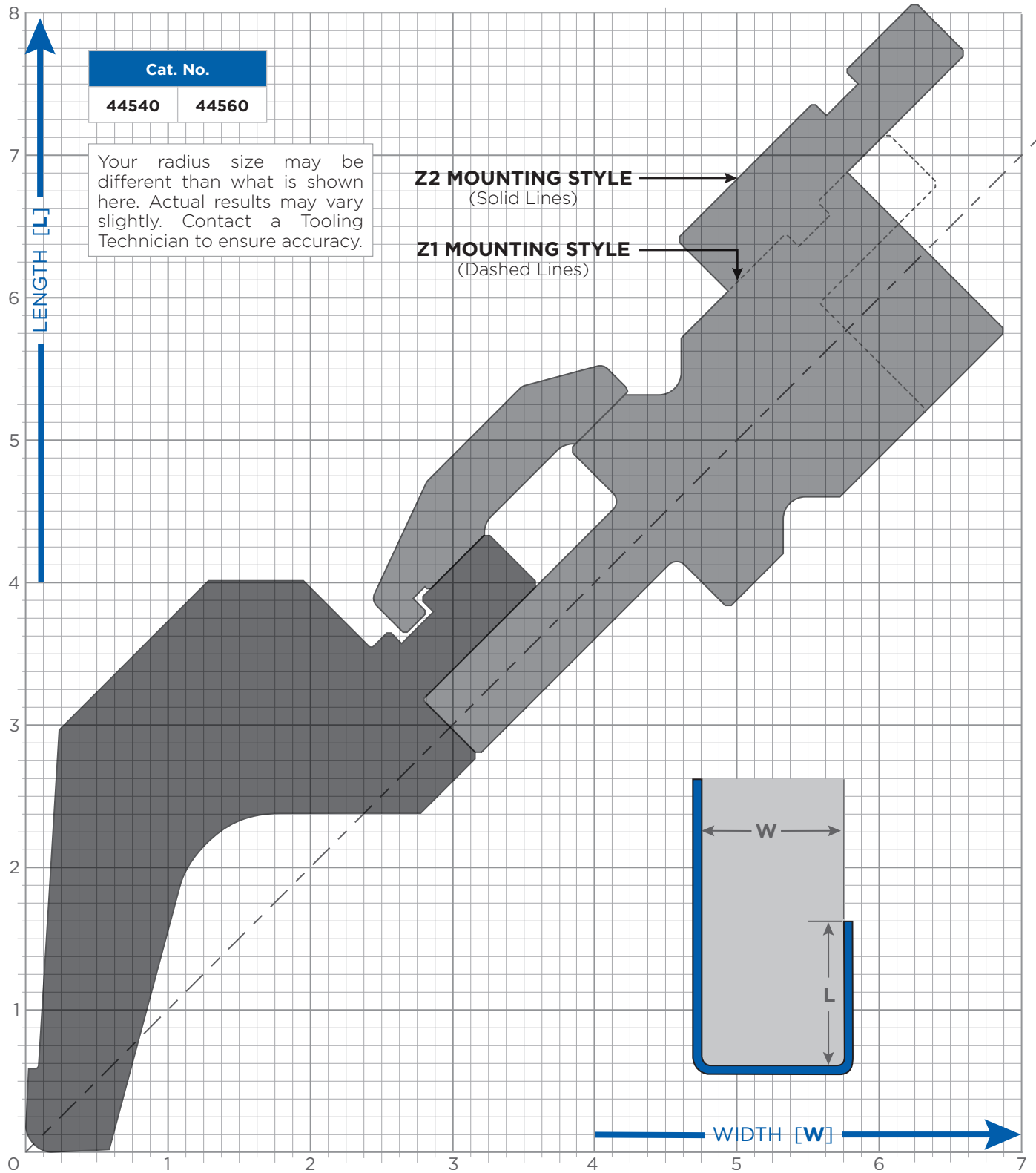
# THIN TIP GOOSENECK PUNCH

## 88° & 90°



# GOOSENECK PUNCH 85°

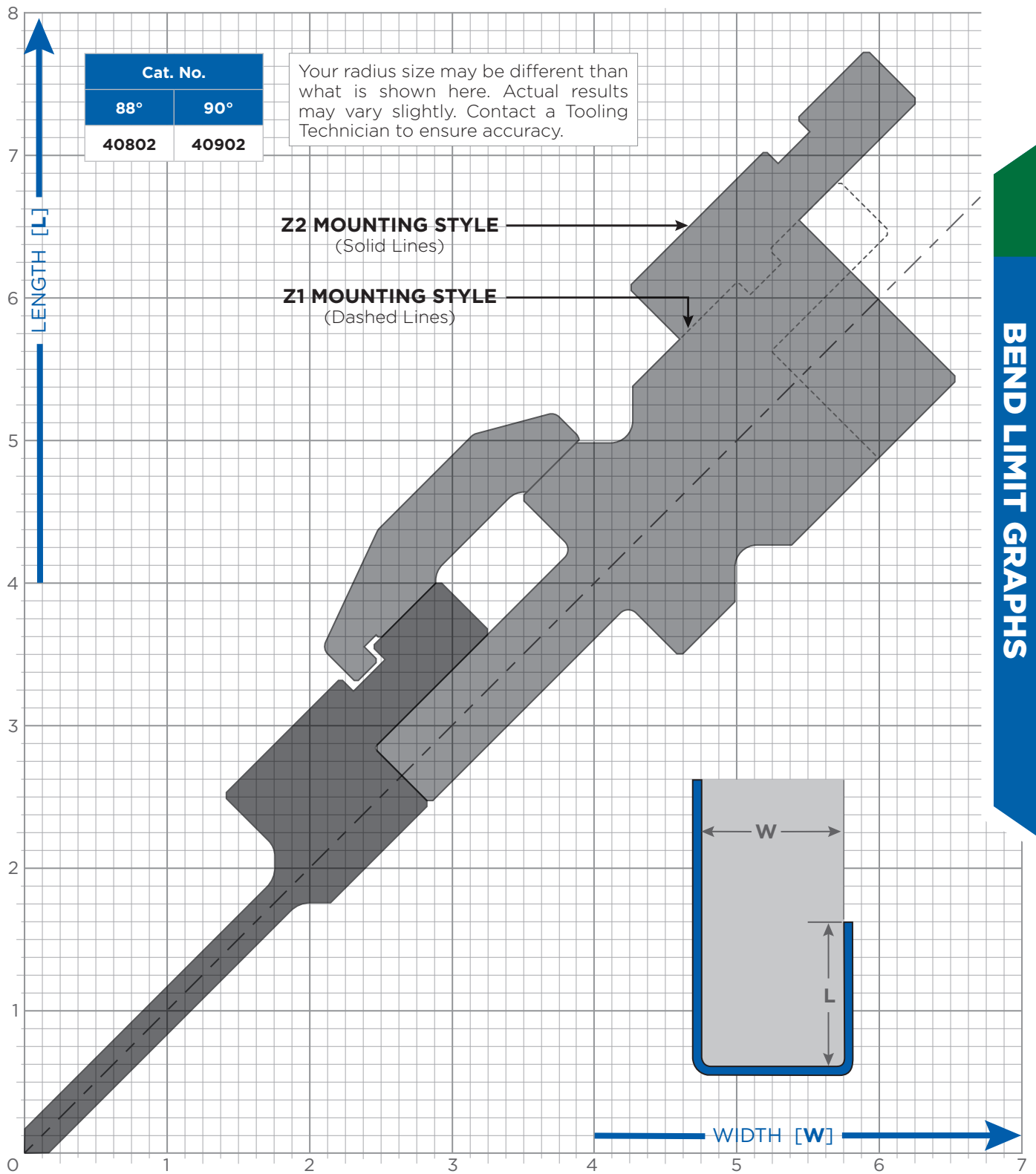
BEND LIMIT GRAPHS





# NARROW PUNCH

## 88° & 90°

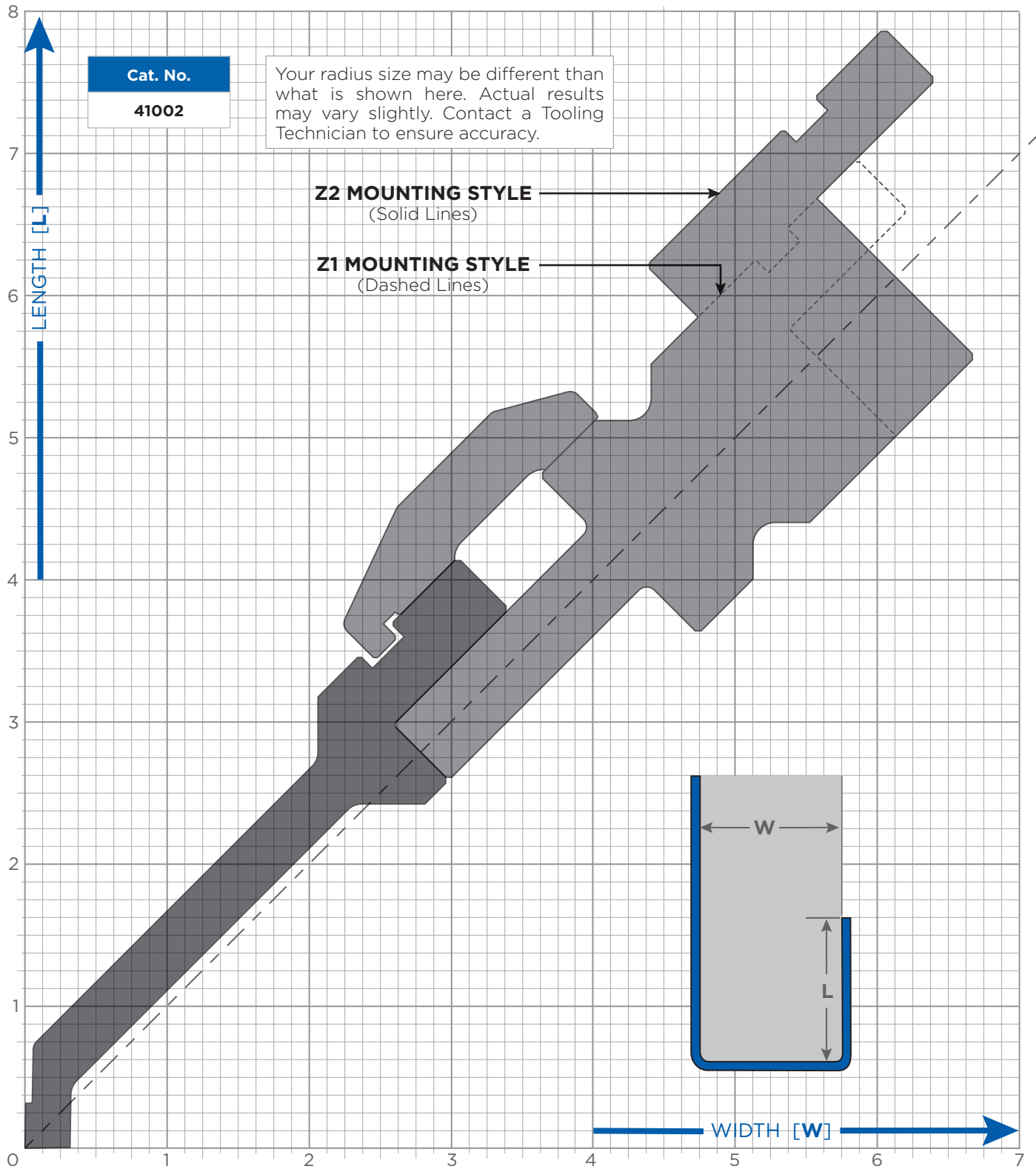


BEND LIMIT GRAPHS

# SASH PUNCH

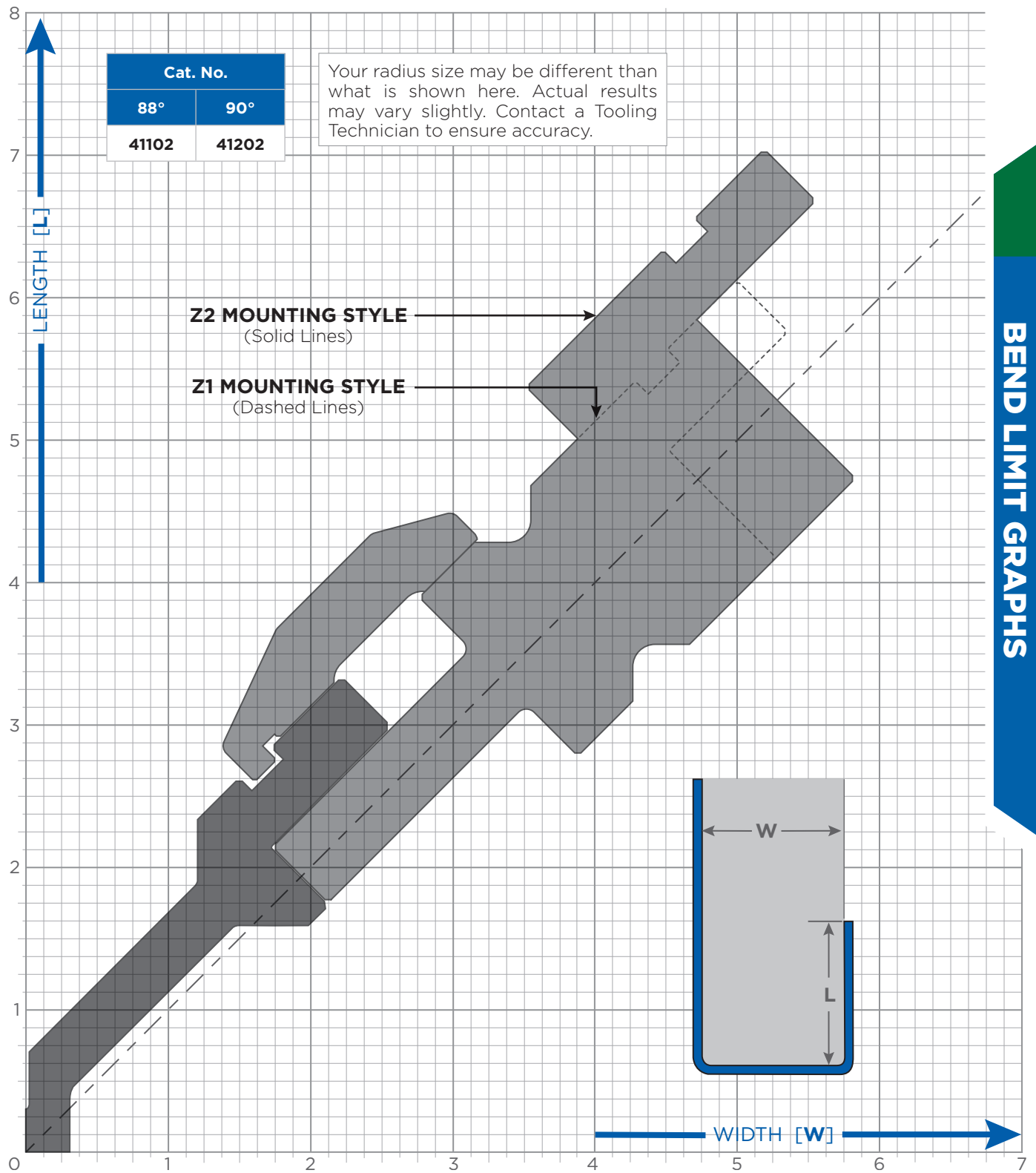
88°

BEND LIMIT GRAPHS



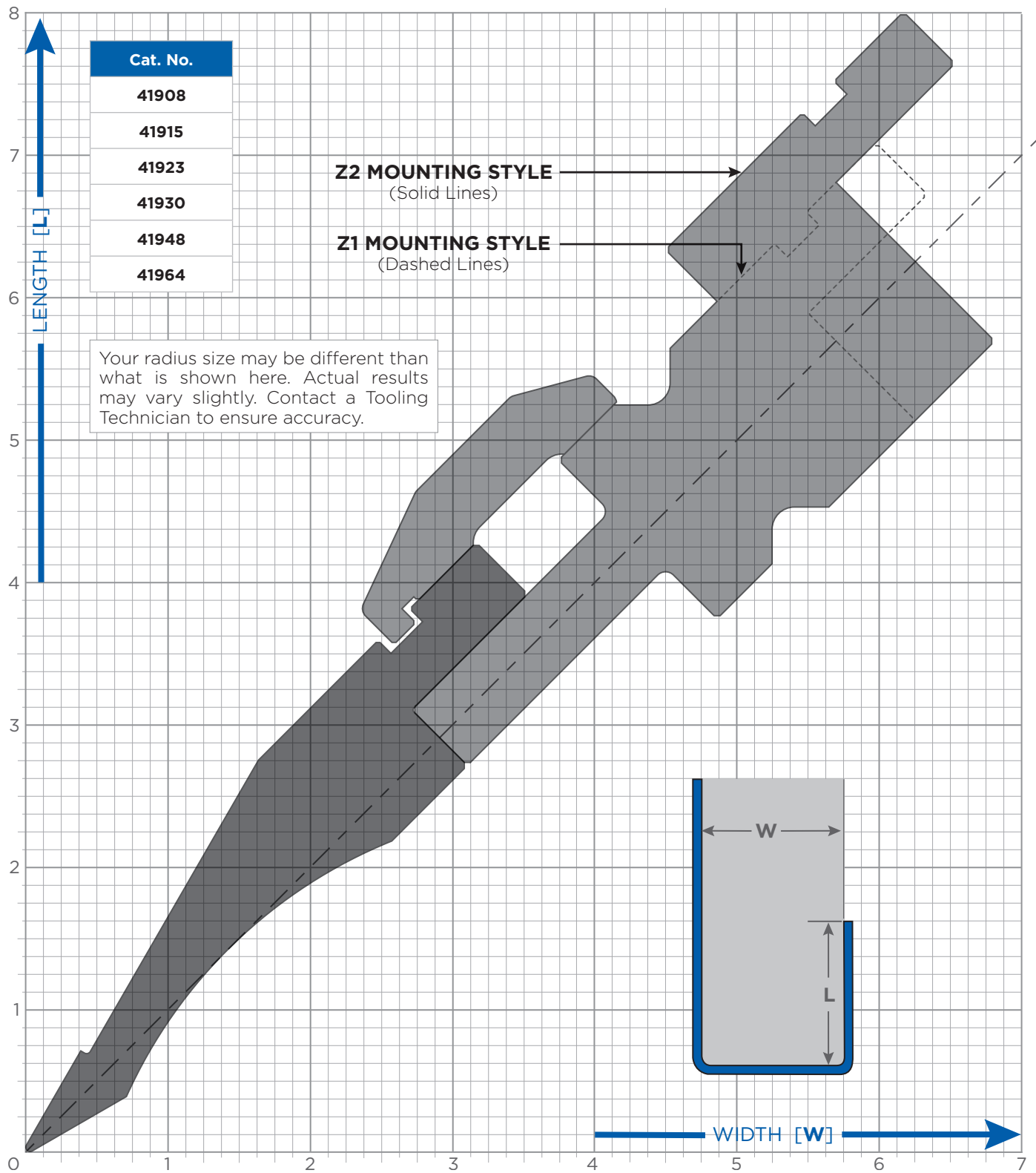
# SASH PUNCH

## 88° & 90°

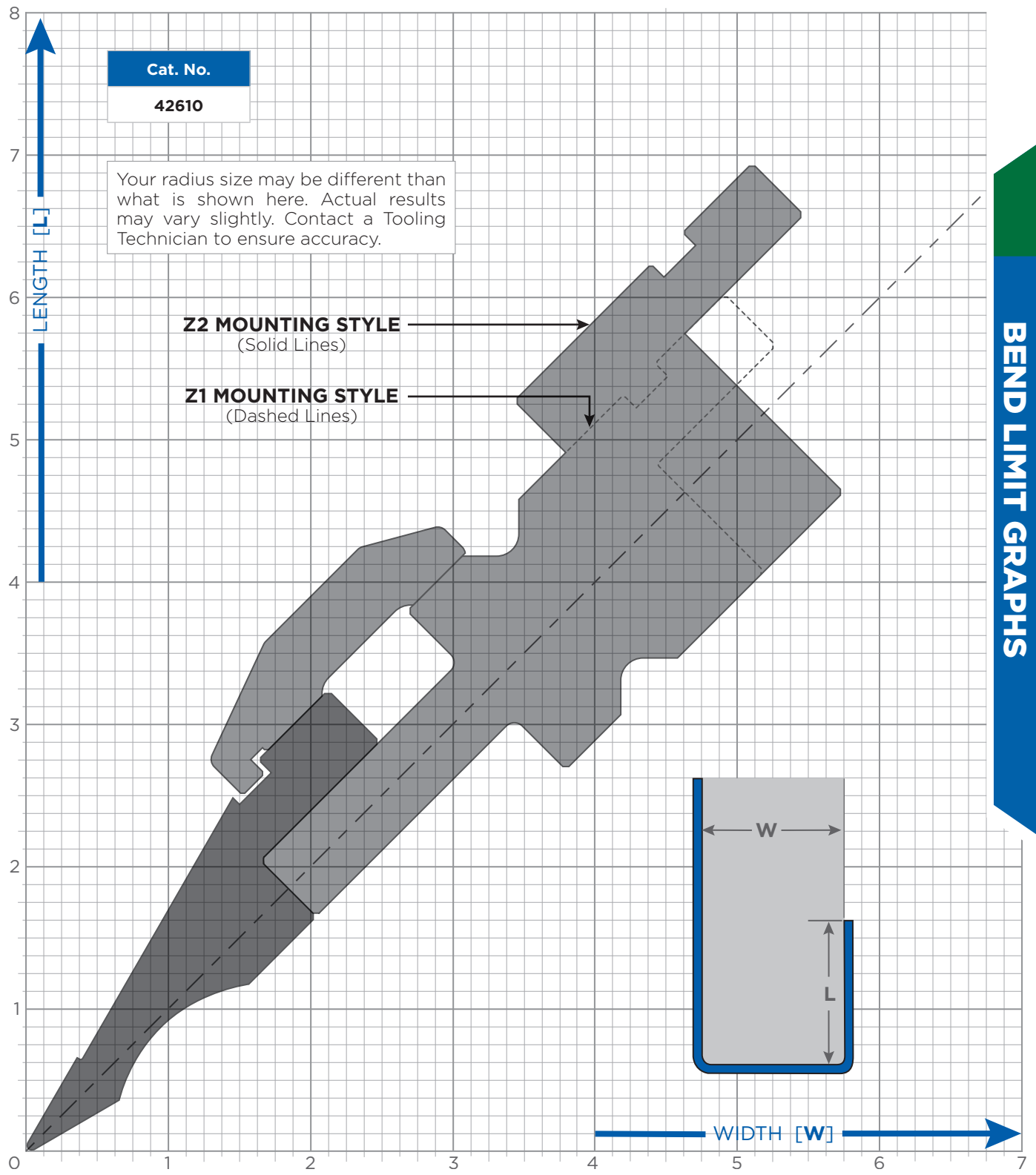


# ACUTE ANGLE PUNCH 30°

BEND LIMIT GRAPHS

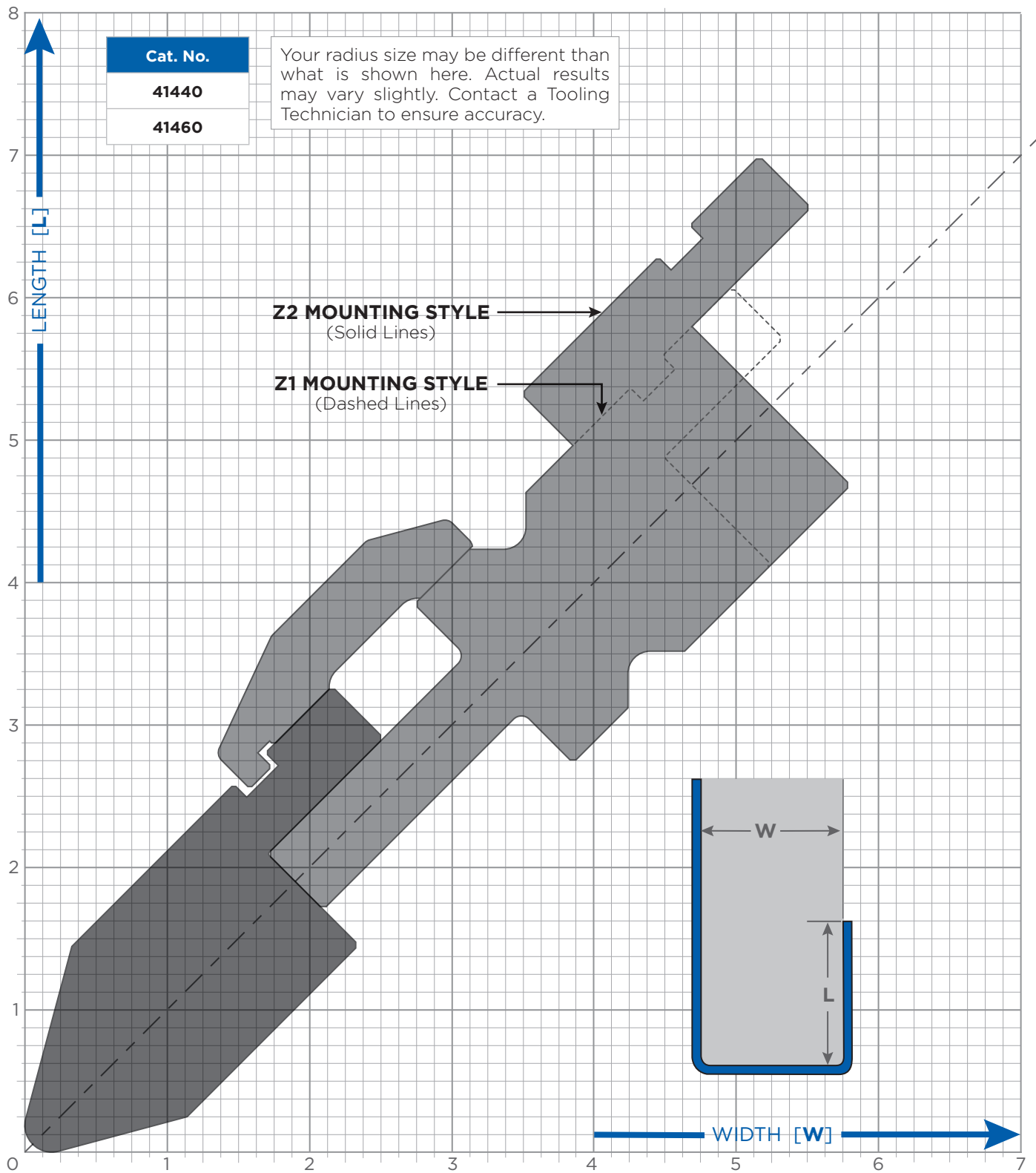


# ACUTE ANGLE PUNCH 30°

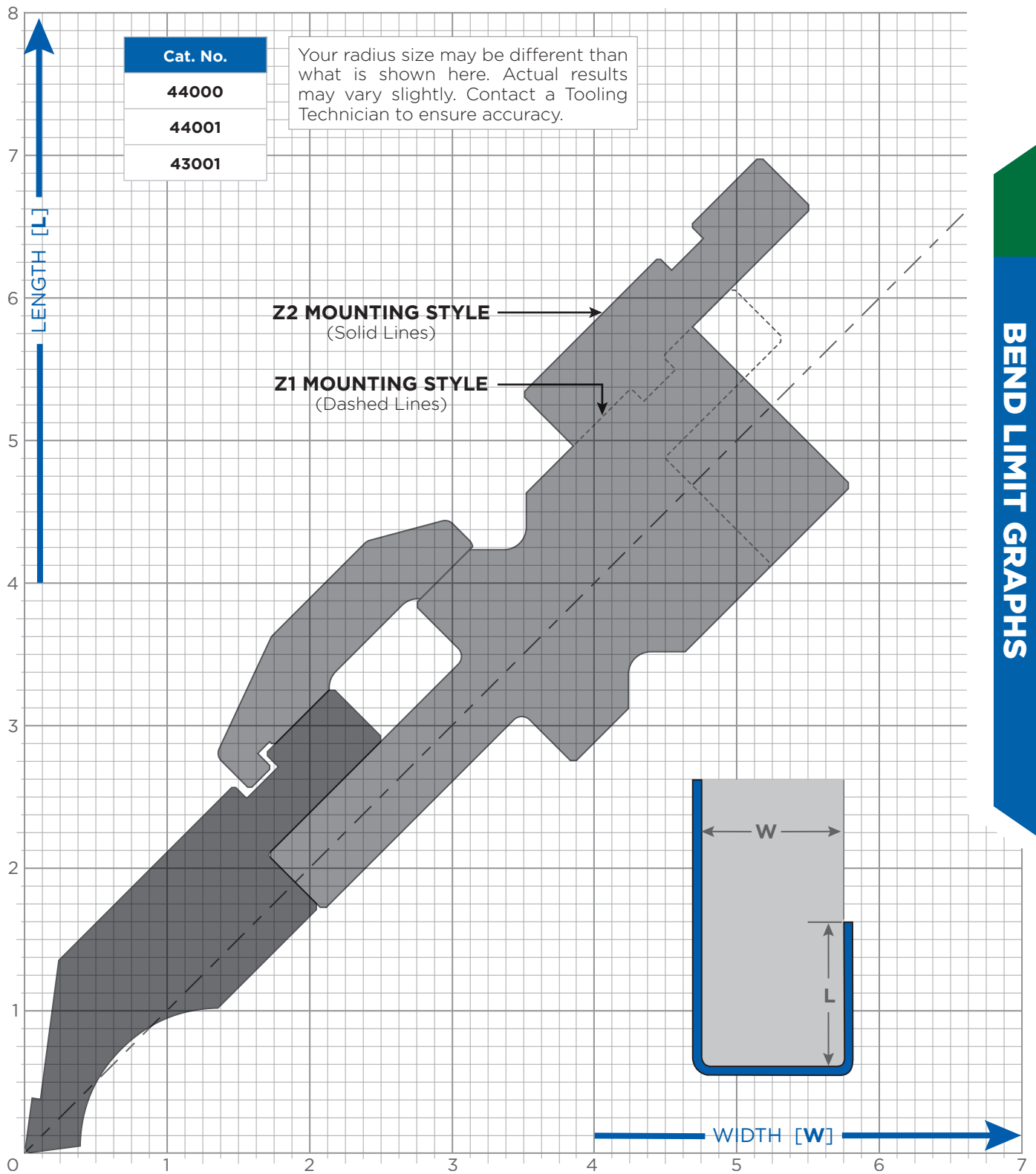


# ACUTE PUNCH 60°

BEND LIMIT GRAPHS

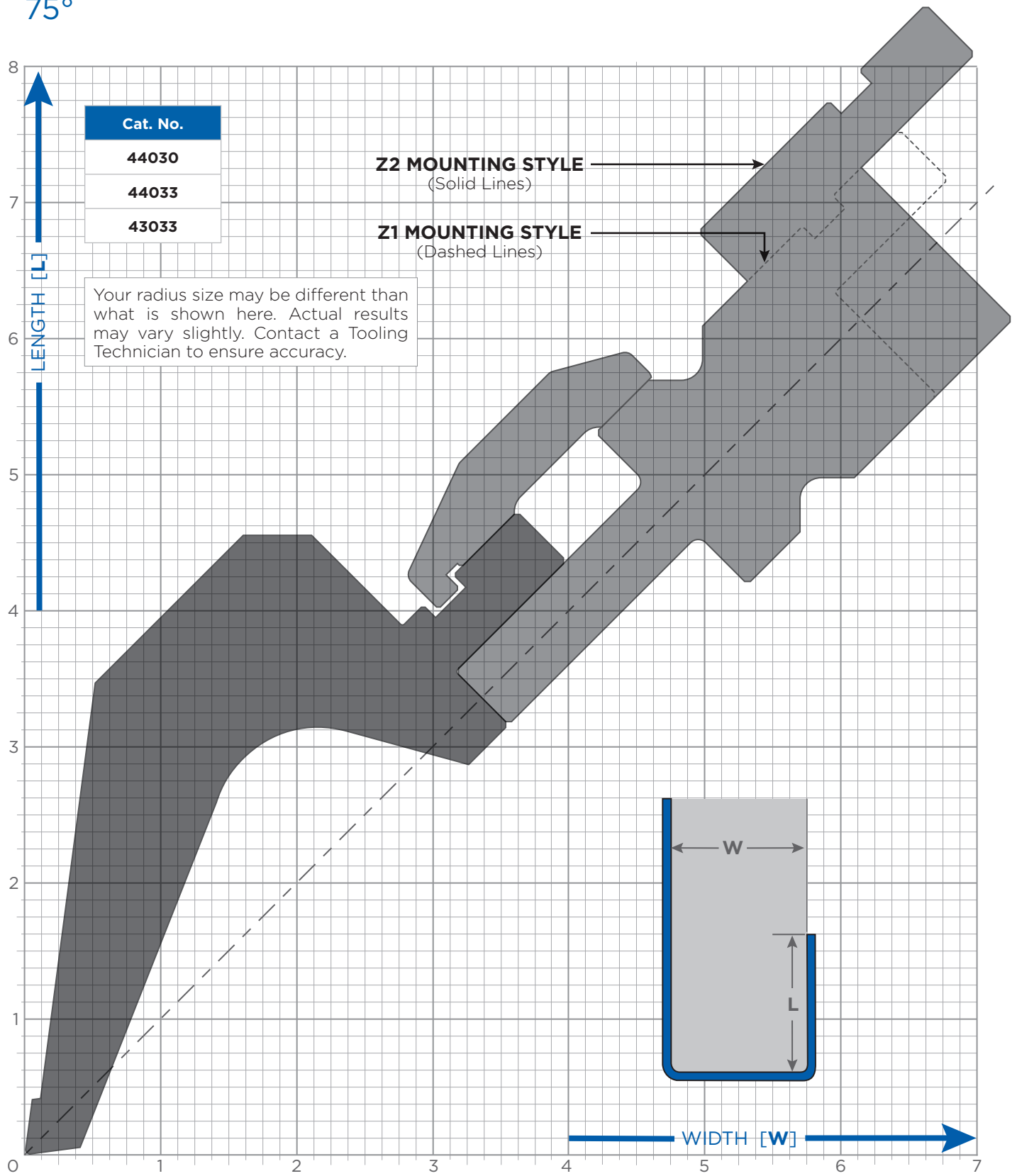


# STANDARD PUNCH 75°



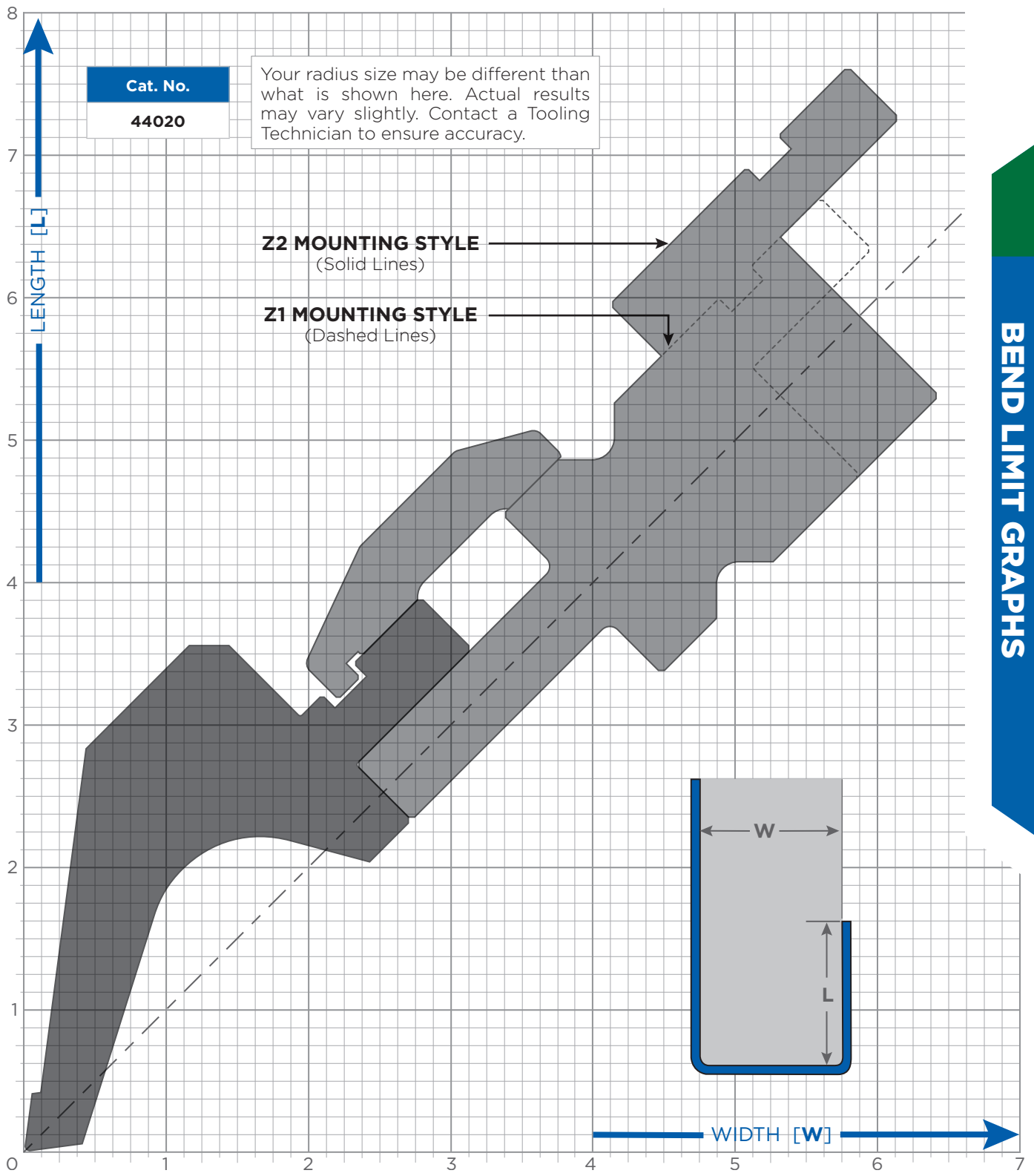
# GOOSENECK PUNCH 75°

BEND LIMIT GRAPHS





# GOOSENECK PUNCH 75°



**BEND LIMIT GRAPHS**

# GOOSENECK PUNCH 75°

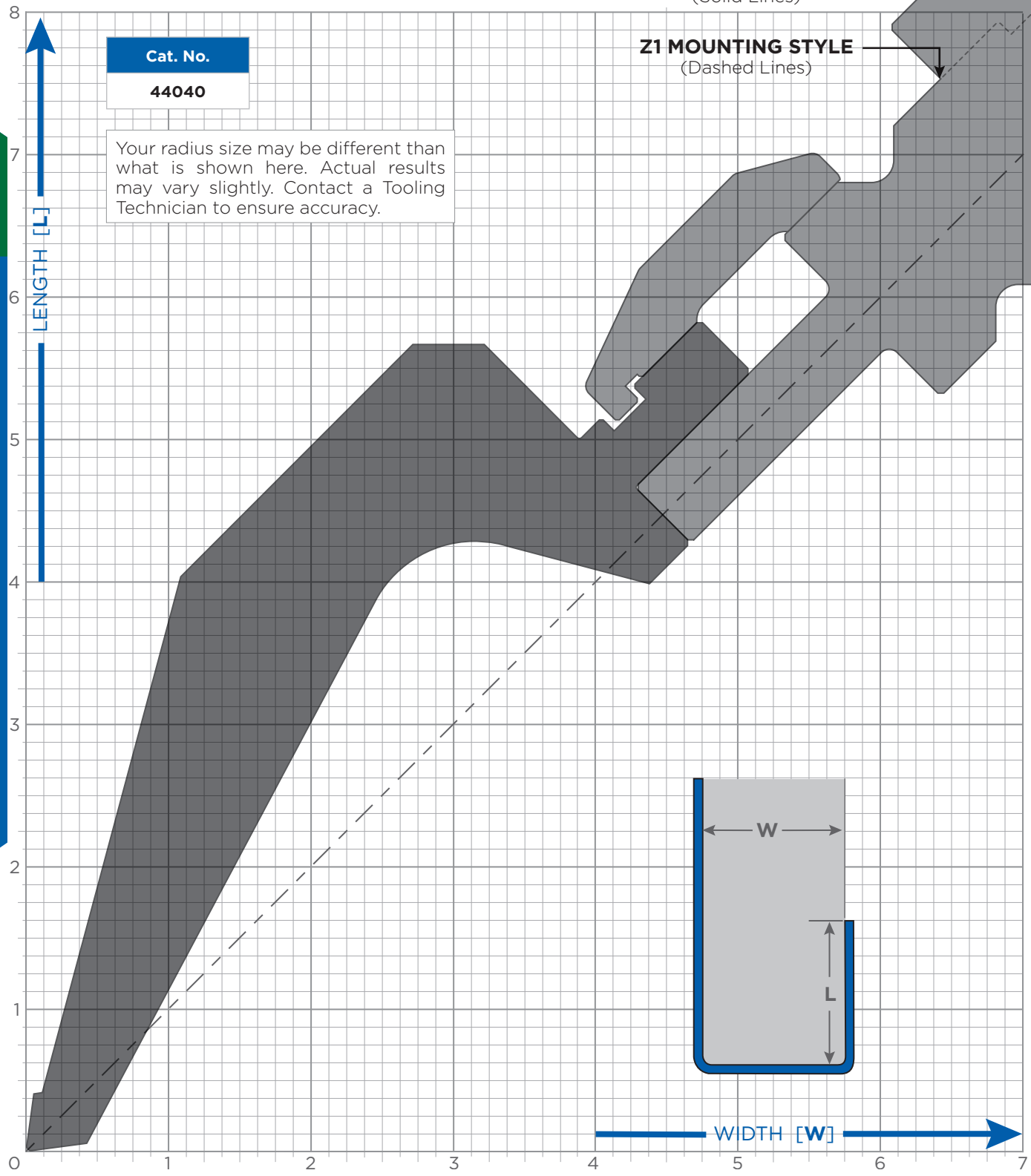
Cat. No.

**44040**

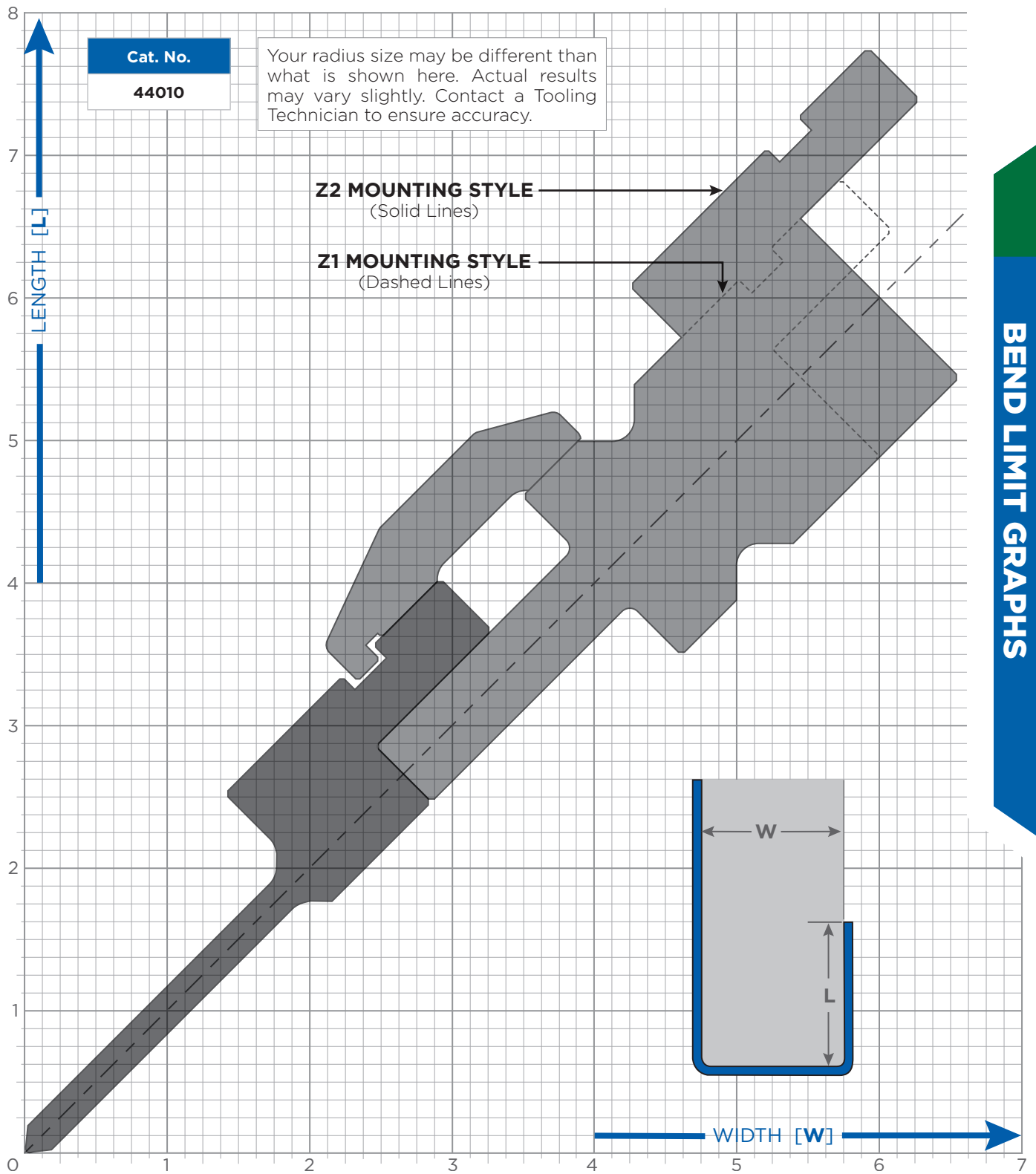
Your radius size may be different than what is shown here. Actual results may vary slightly. Contact a Tooling Technician to ensure accuracy.

**Z2 MOUNTING STYLE**  
(Solid Lines)

**Z1 MOUNTING STYLE**  
(Dashed Lines)

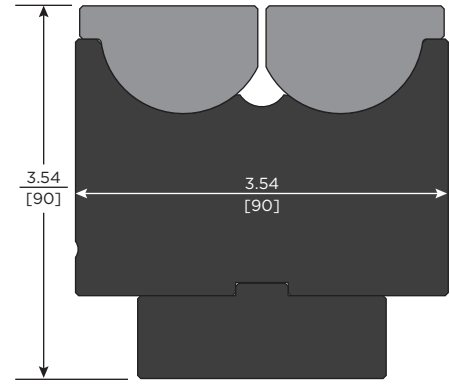
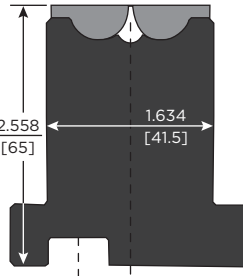
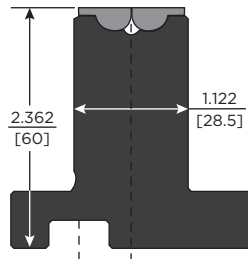


# NARROW PUNCH 75°



**BEND LIMIT GRAPHS**

# V-SERIES BLACK (VSB) DIES



Watch the video on our YouTube Channel!

**41060  
MODEL 1**

**42065  
MODEL 2**

**43090  
MODEL 3**

MODEL 1	SOLID		SECTIONAL		X1		X2			
Length	9.84" [250mm]		19.68" [500mm]		21.65" [550mm]		10.83" [275mm]			
Height	55	100	55	100	55	100	55	100		
Assembly Cat. No.	51055-250	51100-250	51055-500	51100-500	51055-550	51100-550	51055x1	51100x1	51055x2	51100x2
Spring	980682	981031	980682	981031	980682	981031	980682	981031	980682	981031
Weight	6 lbs.	10 lbs.	11 lbs.	20 lbs.	13 lbs.	22 lbs.	6 lbs.	11 lbs.	6 lbs.	11 lbs.
Price										
Insert Cat. No.	-		(4) 980872A		980873A & 980874A		987158		987159	

MODEL 2	SOLID		SECTIONAL		X1		X2			
Length	9.84" [250mm]		19.68" [500mm]		21.65" [550mm]		10.83" [275mm]			
Height	60	100	60	100	60	100	60	100		
Assembly Cat. No.	52060-250	52100-250	52060-500	52100-500	52060-550	52100-550	52060x1	52100x2	52060x2	52100x2
Spring	980683	981032	980683	981032	980683	981032	980683	981032	980683	981032
Weight	9 lbs.	14 lbs.	15 lbs.	25 lbs.	17 lbs.	29 lbs.	8 lbs.	14 lbs.	8 lbs.	14 lbs.
Price										
Insert Cat. No.	-		(4) 980948		980949 & 980950		987160		987161	

MODEL 3	SOLID		
Length	3.94" [100mm]	9.84" [250mm]	17.91" [455mm]
Height	70	70	70
Assembly Cat. No.	53070.2-100	53070.2-250	53070.2-455
Spring	980881	980881	980881
Weight	11 lbs.	27 lbs.	47 lbs.
Price			
Insert Cat. No.	987163	980959	980960 & 980977

Installation Tools		
Description	Cat. No.	Price
Spring Installation Tool Kit	981002	
Spring Extension Wire (short)	981003	
Spring Extension Wire (long)	981004	



ZIP-MAR URETHANE SHOULDER STRIPS [54' Roll, .020" Thick]		
Width	Cat. No.	Price
<b>Model 1</b> 1/2"	980953	
<b>Model 2</b> 3/4"	980954	
<b>Model 3</b> 1-5/8"	980955	

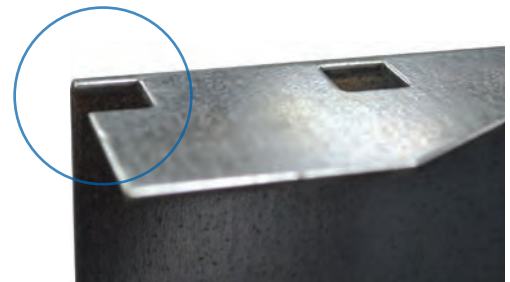
SPRINGS					
Cat. No.	980682	981031	980683	981032	980881
500mm Qty.	40	40	40	40	8
550mm Qty.	44	44	44	44	18

V-SERIES BLACK (VSB) DIES

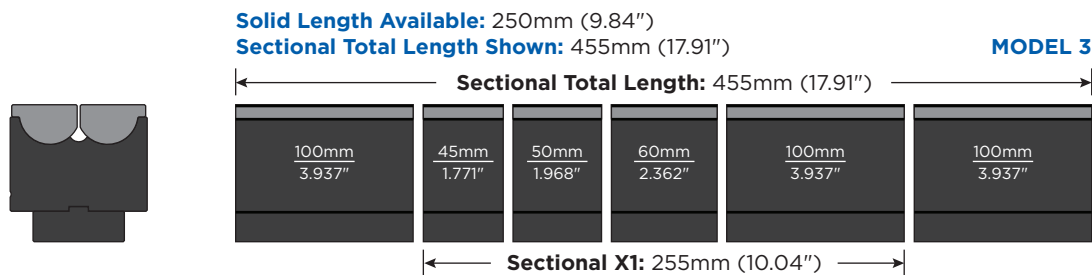
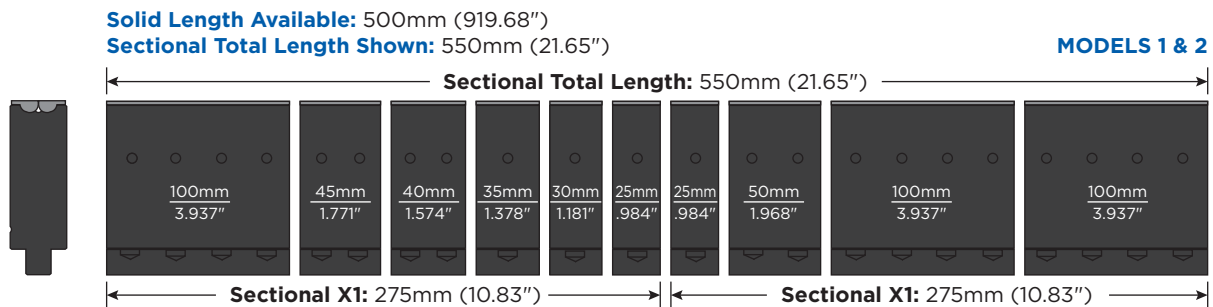


Model	Material Thickness inch [mm]	Min. Outside Flange inch [mm]	Ton/ Ft.	Min. Angle	Punch Tip Required to Achieve Angle	Max OR Radius @ Min. Angle inch [mm]	Max OR Radius @ 90° inch [mm]	Tonnage Cap/Ft.	T/M	kN/M
<b>V-SERIES BLACK (VSB) SPECIFICATIONS</b>										
1	.018 [.45]	.118 [3.0]	1.8	34°	0.054	.125 [3.17]	.175 [4.45]	34	112	1100
	.020 [.50]		1.8		0.052					
	.024 [.60]		2.0		0.047					
	.030 [.80]		2.5		0.042					
	.036 [.90]		3.3		0.036					
	.040 [1.0]	.153 [3.9]	4.0		0.031					
	.048 [1.2]		5.8							
2	.074 [1.9]	.335 [8.5]	7	42°	0.122	.216 [5.5]	.354 [9.0]	50	168	1650
	.105 [2.9]	.347 [8.8]	13		0.112					
	.118 [3.0]	.366 [9.3]	15		0.099					
	.126 [3.2]		20		0.091					
	.135 [3.4]		22		0.082					
3	.157 [4.0]	.886 [22.5]	9	65°	0.078	.453 [11.5]	.500 [12.7]	60	204	2000
	.187 [4.75]		26		0.094					
	.250 [6.35]		28		0.125					

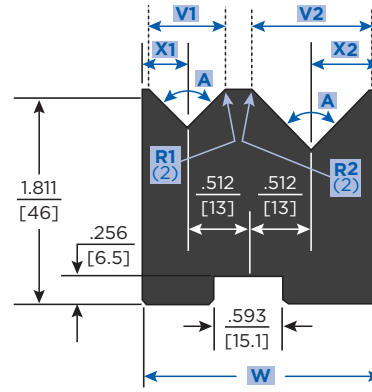
Model	Shoulder Radius inch [mm]	Desired Angle	Theoretical V (Metric)	Theoretical V (Imperial)
<b>V OPENING AND SHOULDER RADIUS DIMENSIONS</b>				
1	.040 [1.0]	90°	7.2	0.283
		34°	6.5	0.256
2	.051 [1.3]	90°	13.9	0.547
		42°	13.3	0.524
3	.236 [6.0]	90°	33.0	1.299
		65°	31.4	1.236



### V-Series Black (VSB) Standard Lengths



# 75°, 88° & 90° QUICK CHANGE 2V DIES



EUROPEAN TRADITIONAL

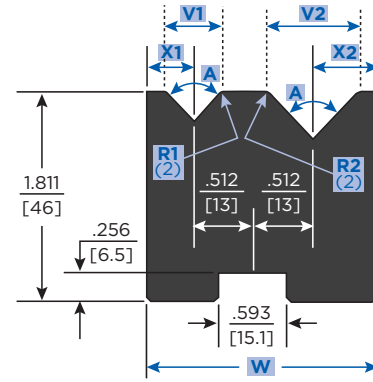
Cat. No.	A Angle	Max. Ton feet [m]	W Width inch [mm]	V1 inch [mm]	V2 inch [mm]	X1 inch [mm]	X2 inch [mm]	R1 inch [mm]	R2 inch [mm]	Weight lbs/in [kg/mm]	LT 32.87" [835mm]	ST 16.34" [415mm]	XT 32.87" [835mm]	
<b>75° QUICK CHANGE 2V DIES</b>														
44100	75°	30 [100]	1.770 [45.0]	.394 [10.0]	.630 [16.0]	.304 [7.7]	.442 [11.2]	.098 [2.5]	.138 [3.5]	0.86 [.015]				
44101			1.760 [44.7]	.236 [6.0]	.787 [20.0]	.206 [5.2]	.530 [13.5]	.059 [1.5]	.157 [4.0]					
44102			1.908 [48.5]	.394 [10.0]	.866 [22.0]	.304 [7.7]	.580 [14.7]	.098 [2.5]	.177 [4.5]					
44103			2.035 [51.7]	.472 [12.0]	.984 [25.0]	.354 [9.0]	.658 [16.7]	.118 [3.0]	.216 [5.5]					1.01 [.018]
<b>88° QUICK CHANGE 2V DIES</b>														
42004	88°	30 [100]	1.772 [45.0]	.551 [14.0]	.709 [18.0]	.335 [8.5]	.413 [10.5]	.019 [0.5]	.019 [0.5]	0.86 [.015]				
42005			1.792 [45.5]	.472 [12.0]	.787 [20.0]	.295 [7.5]	.472 [12.0]	.019 [0.5]	.019 [0.5]					
42006			1.969 [50.0]	.630 [16.0]	.984 [25.0]	.374 [9.5]	.571 [14.5]	.031 [0.8]	.031 [0.8]					
42007			1.457 [37.0]	.236 [6.0]	.394 [10.0]	.177 [4.5]	.256 [6.5]	.016 [0.4]	.024 [0.6]					0.70 [.012]
42008			1.358 [34.5]	.158 [4.0]	.276 [7.0]	.138 [3.5]	.197 [5.0]	.016 [0.4]	.016 [0.4]					
42009			1.536 [39.0]	.315 [8.0]	.472 [12.0]	.217 [5.5]	.295 [7.5]	.019 [0.5]	.031 [0.8]					
<b>90° QUICK CHANGE 2V DIES</b>														
42000	90°	18 [60]	1.358 [34.5]	.158 [4.0]	.276 [7.0]	.138 [3.5]	.197 [5.0]	.016 [0.4]	.016 [0.4]	0.70 [.012]				
42001		21 [70]	1.457 [37.0]	.236 [6.0]	.394 [10.0]	.177 [4.5]	.256 [6.5]	.016 [0.4]	.024 [0.6]					
42002		24 [80]	1.536 [39.0]	.315 [8.0]	.472 [12.0]	.217 [5.5]	.295 [7.5]	.019 [0.5]	.031 [0.8]					0.86 [.015]
42003		30 [100]	1.772 [45.0]	.551 [14.0]	.709 [18.0]	.335 [8.5]	.413 [10.5]	.019 [0.5]	.019 [0.5]					

Note: V-opening modifications and die relief available at an additional cost. Contact a Tooling Technician for pricing and lead times. Nitrex® standard on all 2V dies provides HRC-70.

= 30 lbs. / 13.6kg or more

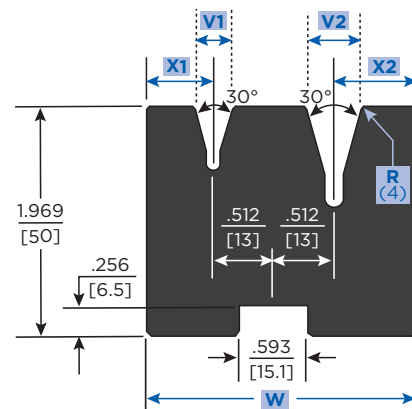


## 88° & 90° LARGE SHOULDER RADII QUICK CHANGE 2V DIES



Cat. No.	A Angle	Max. Ton feet [m]	W Width inch [mm]	V1 inch [mm]	V2 inch [mm]	X1 inch [mm]	X2 inch [mm]	R1 inch [mm]	R2 inch [mm]	Weight lbs/in [kg/mm]	LT 32.87" [835mm]	ST 16.34" [415mm]	XT 32.87" [835mm]
<b>88° LARGE SHOULDER RADII QUICK CHANGE 2V DIES</b>													
42012	88°	24 [80]	1.575 [40]	.236 [6.0]	.394 [10.0]	.236 [6.0]	.315 [8.0]	.059 [1.5]	.098 [2.5]	0.86 [.015]			
42011		30 [100]	1.969 [50]	.472 [12.0]	.787 [20.0]	.394 [10.0]	.551 [14.0]	.118 [3.0]	.158 [4.0]	1.01 [.018]			
<b>90° LARGE SHOULDER RADII QUICK CHANGE 2V DIES</b>													
42010	90°	24 [80]	1.575 [40]	.236 [6.0]	.394 [10.0]	.236 [6.0]	.315 [8.0]	.059 [1.5]	.098 [2.5]	0.86 [.015]			

## 30° ACUTE ANGLE QUICK CHANGE 2V DIES

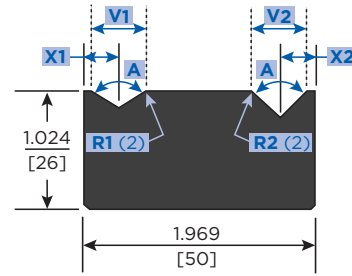


Cat. No.	Angle	Max. Ton feet [m]	W Width inch [mm]	V1 inch [mm]	V2 inch [mm]	X1 inch [mm]	X2 inch [mm]	R1 inch [mm]	R2 inch [mm]	Weight lbs/in [kg/mm]	LT 32.87" [835mm]	ST 16.34" [415mm]	XT 32.87" [835mm]
<b>30° ACUTE ANGLE QUICK CHANGE 2V DIES</b>													
42020	30°	9 [30]	1.969 [50]	.236 [6.0]	.394 [10.0]	.354 [9.0]	.591 [15.0]	.039 [1.0]	.039 [1.0]	1.01 [.018]			
42021		9 [30]	2.303 [58.5]	.315 [8.0]	.472 [12.0]	.571 [14.5]	.709 [18.0]	.039 [1.0]	.039 [1.0]	1.29 [.023]			

Note: V-opening modifications and die relief available at an additional cost. Contact a Tooling Technician for pricing and lead times. Nitrex® standard on all 2V dies provides HRC-70.

= 30 lbs. / 13.6kg or more

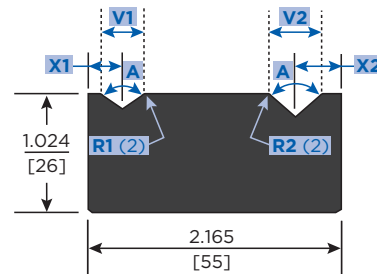
## BOLT DOWN 2V DIES OLD STYLE



Cat. No.	A Angle	Max. Ton feet [m]	V1 inch [mm]	V2 inch [mm]	X1 inch [mm]	X2 inch [mm]	R1 inch [mm]	R2 inch [mm]	Weight lbs/in [kg/mm]	LT 32.87" [835mm]	ST 16.34" [415mm]
<b>BOLT DOWN 2V DIES - OLD STYLE</b>											
42030	90°	18 [60]	.158 [4.0]	.276 [7.0]	.138 [3.5]	.197 [5.0]	.016 [0.4]	.016 [0.4]	0.70 [.012]		
42031		21 [70]	.236 [6.0]	.394 [10.0]	.177 [4.5]	.256 [6.5]	.016 [0.4]	.024 [0.6]			
42032		24 [80]	.315 [8.0]	.472 [12.0]	.217 [5.5]	.295 [7.5]	.020 [0.5]	.031 [0.8]			
42033		30 [100]	.551 [14.0]	.709 [18.0]	.335 [8.5]	.413 [10.5]	.020 [0.5]	.020 [0.5]			
42034	88°	30 [100]	.551 [14.0]	.709 [18.0]	.335 [8.5]	.413 [10.5]	.020 [0.5]	.020 [0.5]	0.51 [.009]		
42035		30 [100]	.472 [12.0]	.787 [20.0]	.295 [7.5]	.472 [12]	.020 [0.5]	.020 [0.5]			
42036		21 [70]	.630 [16.0]	.984 [25.0]	.374 [9.5]	.571 [14.5]	.031 [0.8]	.031 [0.8]			

EUROPEAN TRADITIONAL

## LARGE SHOULDER RADII 2V DIES OLD STYLE



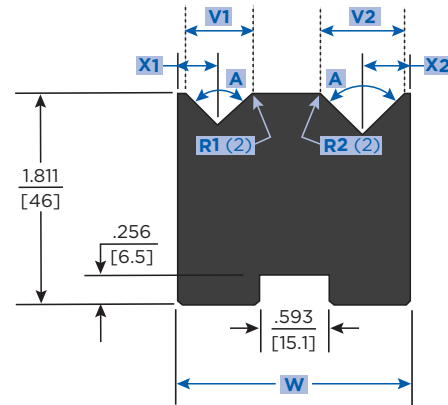
Cat. No.	A Angle	Max. Ton feet [m]	V1 inch [mm]	V2 inch [mm]	X1 inch [mm]	X2 inch [mm]	R1 inch [mm]	R2 inch [mm]	Weight lbs/in [kg/mm]	LT 32.87" [835mm]	ST 16.34" [415mm]
<b>LARGE SHOULDER RADII 2V DIES - OLD STYLE</b>											
42040	90°	24 [80]	.236 [6.0]	.394 [10.0]	.236 [6.0]	.394 [10.0]	.059 [1.5]	.098 [2.5]	0.70 [.012]		
42041	88°	30 [100]	.472 [12.0]	.787 [20.0]	.394 [10.0]	.591 [15.0]	.118 [3.0]	.157 [4.0]			

Note: All mounting hardware is included. V-opening modifications and die relief available at an additional cost. Contact a Tooling Technician for pricing and lead times. Nitrex® standard on all 2V dies provides HRC-70.






# LARGE SHOULDER RADII 2V DIES SECTIONALIZED – OLD STYLE

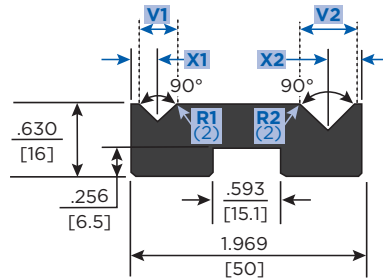


Cat. No.	A Angle	Max. Ton feet [m]	W Width inch [mm]	V1 inch [mm]	V2 inch [mm]	X1 inch [mm]	X2 inch [mm]	R1 inch [mm]	R2 inch [mm]	Weight lbs/in [kg/mm]	XT 32.87" [835mm]
<b>LARGE SHOULDER RADII 2V DIES - SECTIONALIZED - OLD STYLE</b>											
42050	90°	18 [60]	1.969 [50]	.158 [4.0]	.276 [7.0]	.138 [3.5]	.197 [5.0]	.016 [0.4]	.016 [0.4]	2.17 [.039]	
42051		21 [70]	1.969 [50]	.236 [6.0]	.394 [10.0]	.177 [4.5]	.256 [6.5]	.016 [0.4]	.023 [0.6]	1.01 [.018]	
42052		21 [70]	1.969 [50]	.315 [8.0]	.472 [12.0]	.217 [5.5]	.295 [7.5]	.020 [0.5]	.031 [0.8]		
42053		30 [100]	1.969 [50]	.551 [14.0]	.709 [18.0]	.335 [8.5]	.413 [10.5]	.020 [0.5]	.020 [0.5]		
42070		24 [80]	2.165 [55]	.236 [6.0]	.394 [10.0]	.236 [6.0]	.394 [10.0]	.059 [1.5]	.098 [2.5]		
42054	88°	30 [100]	1.969 [50]	.551 [14.0]	.709 [18.0]	.335 [8.5]	.413 [10.5]	.020 [0.5]	.020 [0.5]	1.01 [.018]	
42055			1.969 [50]	.472 [12.0]	.787 [20.0]	.295 [7.5]	.472 [12.0]	.020 [0.5]	.020 [0.5]		
42056			1.969 [50]	.630 [16.0]	.984 [25.0]	.374 [9.5]	.571 [14.5]	.031 [0.8]	.031 [0.8]		
42071			2.165 [55]	.472 [12.0]	.787 [20.0]	.394 [10.0]	.591 [15.0]	.118 [3.0]	.157 [4.0]		

Note: V-opening modifications and die relief available at an additional cost. Contact a Tooling Technician for pricing and lead times. Nitrex® standard on all 2V dies provides HRC-70.

 = 30 lbs. / 13.6kg or more

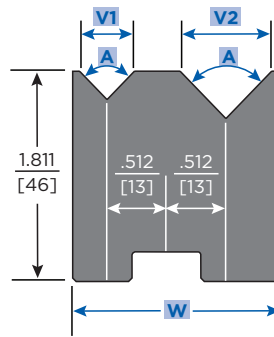
## LOW PROFILE 2V DIES SECTIONALIZED – OLD STYLE



Cat. No.	Angle	Max. Ton feet [m]	V1 inch [mm]	V2 inch [mm]	X1 inch [mm]	X2 inch [mm]	R1 inch [mm]	R2 inch [mm]	Weight lbs/in [kg/mm]	XT 32.87" [835mm]
<b>LOW PROFILE 2V DIES - SECTIONALIZED - OLD STYLE</b>										
42061	90°	21 [70]	.236 [6.0]	.394 [10.0]	.177 [4.5]	.256 [6.5]	.016 [0.4]	.023 [0.6]	0.33 [.006]	
42062			.315 [8.0]	.472 [12.0]	.217 [5.5]	.295 [7.5]	.019 [0.5]	.031 [0.8]		

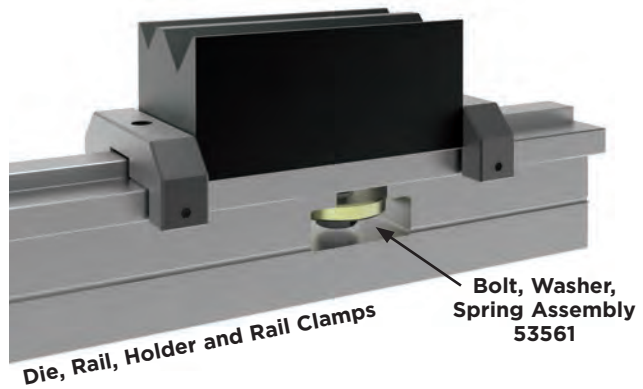
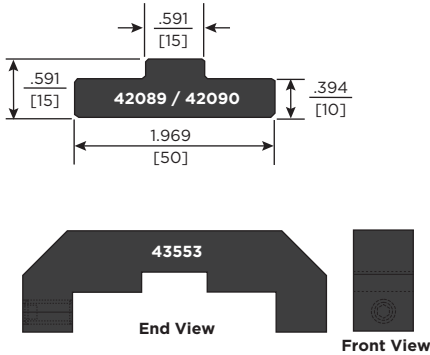
Note: V-opening modifications and die relief available at an additional cost. Contact a Tooling Technician for pricing and lead times. Nitrex® standard on all 2V dies provides HRC-70.

# URETHANE 2V DIES



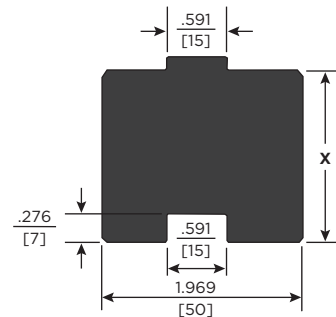
Cat. No.	A Angle	V1 inch [mm]	V2 inch [mm]	H Height inch [mm]	W Width inch [mm]	Weight lbs/in [kg/mm]	L 32.87" [835mm]
<b>URETHANE 2V DIES</b>							
42001ue	90°	.23 [6]	.39 [10]	1.81 [46]	1.77 [45]	0.18 [.003]	
42002ue		.31 [8]	.47 [12]	1.81 [46]	1.77 [45]		
42004ue	88°	.55 [14]	.70 [18]	1.81 [46]	2.36 [60]		
42005ue		.47 [12]	.78 [20]	1.81 [46]	2.36 [60]		
42006ue		.63 [16]	.98 [25]	1.81 [46]	2.61 [66.5]		
42021ue	30°	.31 [8]	.47 [12]	1.81 [46]	2.36 [60]		

## 2V DIE RAILS & RAIL CLAMP



Cat. No.	Description	Weight lbs [kg]	L	S
			32.87" [835mm]	16.34" [415mm]
42089	Die Rail [28-32 HRc]	0.33 lbs/in [.006 kg/mm]		
42090	Die Rail [48-54 HRc]			
43561	Bolt, Washer, Spring Assembly	2 [.9]		
43553	Rail Clamp	1 [.45]		

## 2V DIE STACKING RAILS

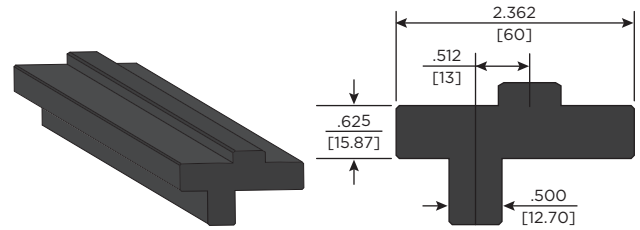


Cat. No.	Height Range	Weight lbs/in [kg/mm]	L	S	X
			32.87" [835mm]	16.34" [415mm]	32.87" (835mm)
42091	X = .575 - 1.250	1.01 [.018]			
42092	X = 1.251 - 2.000	1.68 [.030]			
42093	X = 2.001 - 2.750				

= 30 lbs. / 13.6kg or more

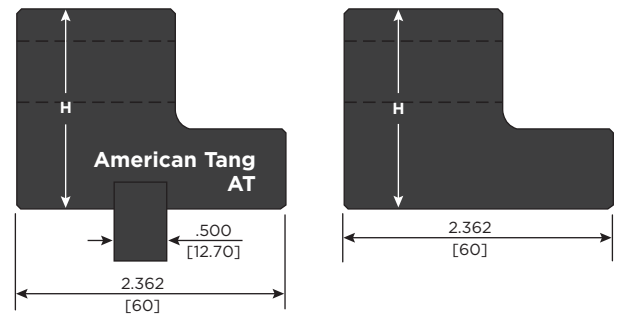




## AMERICAN TO EUROPEAN RAIL ADAPTER




Cat. No.	Max. Ton feet [m]	Weight lbs/in [kg/mm]	L 32.87" [835mm]	S 16.34" [415mm]
FOR QUICK CHANGE 2V DIES				
53090	30 [100]	0.70 [.012]		

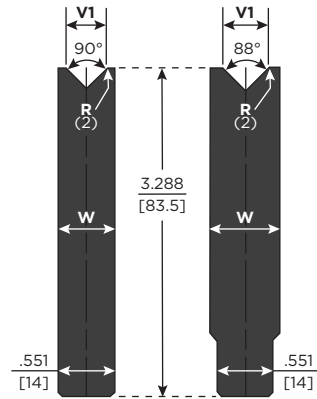
## 2V DIE HOLDERS



Cat. No.	H Height inch [mm]	Weight lbs/in [kg/mm]	L 32.87" [835mm]	S 16.34" [415mm]
43021 AT	1.536 [39]	0.70 [.012]		
43022 AT	1.772 [45]	0.86 [.015]		
43023 AT	2.953 [75]	1.29 [.023]		
43021	1.536 [39]	0.86 [.015]		
43022	1.772 [45]			
43023	2.953 [75]	1.29 [.023]		

 = 30 lbs. / 13.6kg or more

## 88° & 90° QUICK CHANGE 1V DIES

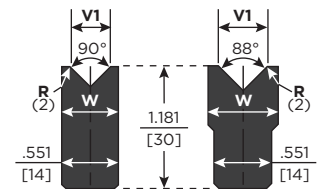


Cat. No.	Angle	Max. Ton feet [m]	W Width inch [mm]	V1 inch [mm]	R Radius inch [mm]	Weight lbs/in [kg/mm]	LT 32.87" [835mm]	ST 16.34" [415mm]	XT 32.87" [835mm]
<b>88° QUICK CHANGE 1V DIES</b>									
42120	88°	30 [100]	.551 [14.0]	.236 [6.0]	.059 [1.5]	0.51 [.009]			
42121			.551 [14.0]	.315 [8.0]	.059 [1.5]				
42122			.551 [14.0]	.394 [10.0]	.078 [2.0]				
42104			.669 [17.0]	.474 [12.0]	.098 [2.5]	0.70 [.012]			
42105			.709 [18.0]	.551 [14.0]	.098 [2.5]				
<b>90° QUICK CHANGE 1V DIES</b>									
42100	90°	30 [100]	.551 [14.0]	.236 [6.0]	.059 [1.5]	0.51 [.009]			
42101			.551 [14.0]	.315 [8.0]	.059 [1.5]				
42102			.551 [14.0]	.394 [10.0]	.078 [2.0]				
42103			.669 [17.0]	.472 [12.0]	.098 [2.5]	0.70 [.012]			

Note: Quick Change 1V Dies require die holder #43030 or #43530. V-opening modifications and die relief available at an additional cost. Contact a Tooling Technician for pricing and lead times. Nitrex® standard on all 1V dies provides HRC-70.

EUROPEAN TRADITIONAL

## 88° & 90° LOW PROFILE QUICK CHANGE 1V DIES

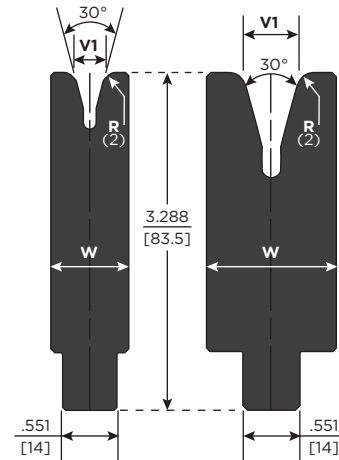


Cat. No.	Angle	Max. Ton feet [m]	W Width inch [mm]	V1 inch [mm]	R Radius inch [mm]	Weight lbs/in [kg/mm]	S 16.34" [415mm]	X 32.87" [835mm]
<b>88° LOW PROFILE QUICK CHANGE 1V DIE</b>								
42114	88°	30 [100]	.69 [17.0]	.472 [12.0]	.098 [2.5]	0.18 [.003]		
<b>90° LOW PROFILE QUICK CHANGE 1V DIES</b>								
42110	90°	30 [100]	.551 [14.0]	.236 [6.0]	.059 [1.5]	0.18 [.003]		
42111			.551 [14.0]	.315 [8.0]	.059 [1.5]			
42112			.551 [14.0]	.394 [10.0]	.078 [2.0]			

Note: Low Profile Quick Change 1V Dies require die holder #43030 or 43530. Nitrex® standard on all 1V dies provides HRC-70.



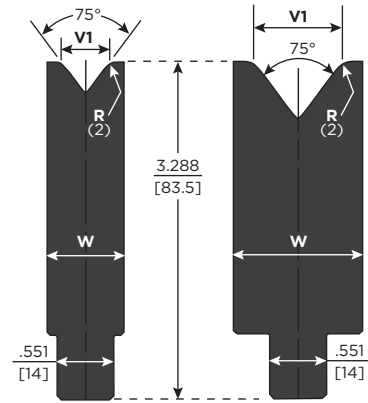
# 30° ACUTE ANGLE QUICK CHANGE 1V DIES



Cat. No.	Angle	Max. Ton feet [m]	W Width inch [mm]	V1 inch [mm]	R Radius inch [mm]	Weight lbs/in [kg/mm]	LT 32.87" [835mm]	ST 16.34" [415mm]	XT 32.87" [835mm]
<b>30° QUICK CHANGE 1V DIES</b>									
42200	30°	22 [76]	.630 [16.0]	.236 [6.0]	.118 [3.0]	0.51 [.009]			
42201		27 [90]	.748 [19.0]	.315 [8.0]	.118 [3.0]				
42202		30 [100]	.945 [24.0]	.394 [10.0]	.118 [3.0]	0.70 [.012]			
42203		30 [100]	1.102 [28.0]	.472 [12.0]	.197 [5.0]				
42204		30 [100]	1.260 [32.0]	.551 [14.0]	.197 [5.0]	0.86 [.015]			
42205		30 [100]	1.417 [36.0]	.630 [16.0]	.197 [5.0]				

Note: V-opening modifications and die relief available at an additional cost. Contact a Tooling Technician for pricing and lead times. Nitrex® standard on all Quick Change 1V dies provides HRC-70.


# 75° QUICK CHANGE 1V DIES



EUROPEAN TRADITIONAL

Cat. No.	A Angle	Max. Ton feet [m]	W Width inch [mm]	V1 inch [mm]	R Radius inch [mm]	Weight lbs/in [kg/mm]	LT 32.87" [835mm]	ST 16.34" [415mm]	XT 32.87" [835mm]
<b>75° QUICK CHANGE 1V DIES</b>									
44200	75°	30 [100]	.551 [14.0]	.118 [3.0]	.016 [0.4]	0.51 [.009]			
44201			.551 [14.0]	.236 [6.0]	.059 [1.5]				
44202			.669 [17.0]	.394 [10.0]	.098 [2.5]	0.70 [.012]			
44203			.748 [19.0]	.472 [12.0]	.118 [3.0]				
44204			.945 [24.0]	.630 [16.0]	.138 [3.5]	0.86 [.015]			
44205			1.102 [28.0]	.787 [20.0]	.157 [4.0]				
44206			1.260 [30.0]	.866 [22.0]	.177 [4.5]	1.01 [.018]			
44207			1.417 [36.0]	.984 [25.0]	.216 [5.5]				

Note: V-opening modifications and die relief available at an additional cost. Contact a Tooling Technician for pricing and lead times. Nitrex® standard on all Quick Change 1V dies provides HRC-70.

 = 30 lbs. / 13.6kg or more

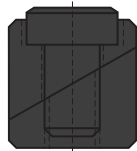




## QUICK CHANGE 1V DIE WEDGE BLOCK



Top View

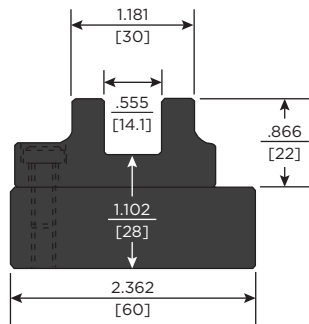


Side View



Cat. No.	Price
43559	

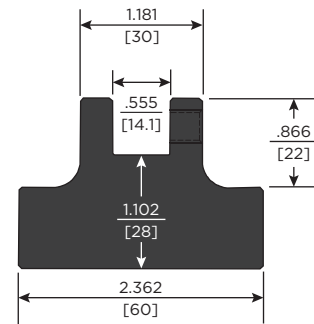
## QUICK CHANGE 1V DIE HOLDERS



**Two Piece Design**  
(No Set Screw for Mounting)

Cat. No.	Weight lbs/in [kg/mm]	L 32.87" [835mm]	S 16.34" [415mm]
<b>TWO PIECE DESIGN</b>			
43030	0.86 [.015]		

Tangs for American or WT-Style tooling can be added to the base of this die holder.

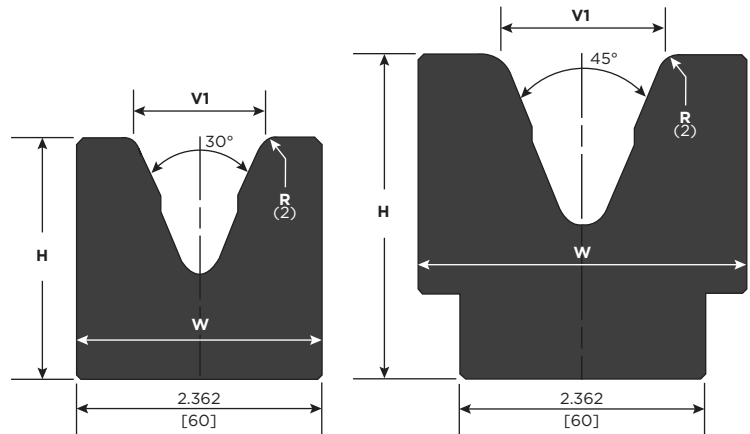








**One Piece Design**  
(With Set Screw for Mounting)

Cat. No.	Weight lbs/in [kg/mm]	LT 32.87" [835mm]	ST 16.34" [415mm]
<b>ONE PIECE DESIGN</b>			
43530	0.86 [.015]		

Tangs for American or WT-Style tooling can be added to the base of this die holder.


## 30° & 45° ACUTE ANGLE LARGE 1V DIES



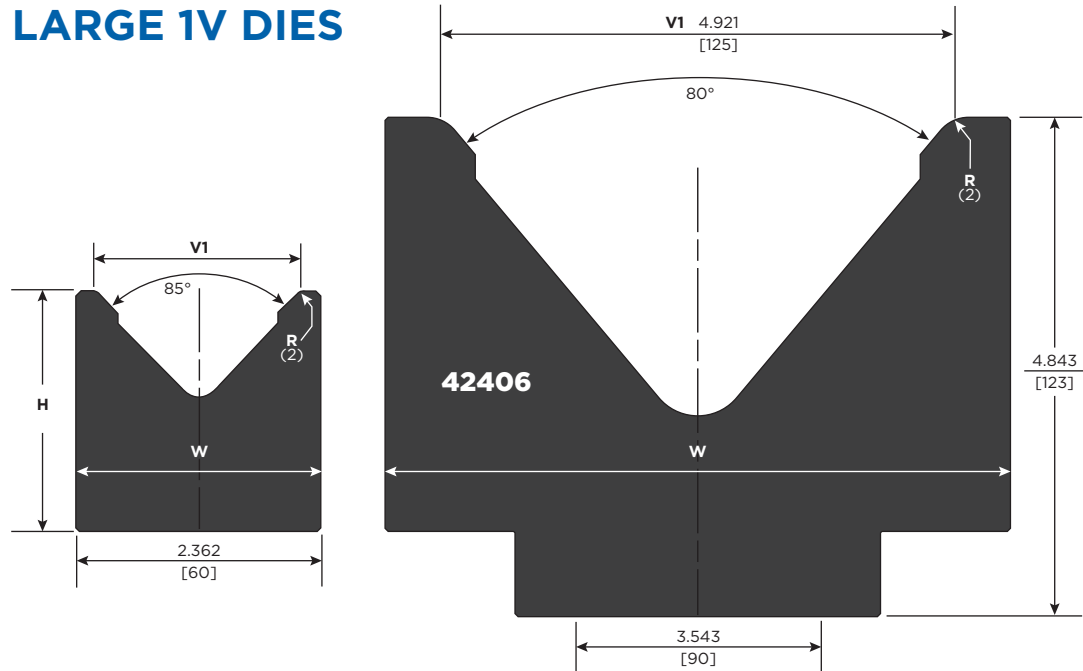
Cat. No.	A Angle	Max. Ton feet [m]	W Width inch [mm]	H Height inch [mm]	V1 inch [mm]	R Radius inch [mm]	Weight lbs/in [kg/mm]	LT 32.87" [835mm]	ST 16.34" [415mm]
<b>30° ACUTE ANGLE LARGE 1V DIES</b>									
42300	30°	24 [80]	2.362 [60.0]	2.362 [60.0]	.709 [18.0]	.118 [3.0]	1.54 [.027]		
42301		18 [60]	2.362 [60.0]	2.559 [65.0]	.984 [25.0]	.157 [4.0]			
<b>45° ACUTE ANGLE LARGE 1V DIES</b>									
42302	45°	12 [40]	2.362 [60.0]	2.362 [60.0]	1.260 [32.0]	.196 [5.0]	1.29 [.023]		
42303		21 [70]	3.150 [80.0]	3.150 [80.0]	1.575 [40.0]	.196 [5.0]	2.17 [.039]		
42304		21 [70]	3.740 [95.0]	3.740 [95.0]	1.969 [50.0]	.236 [6.0]	2.93 [.052]		

Tangs for American or WT-Style tooling can be added to the base of these dies.

Note: Acute-Angle Large 1V Dies may require die holder #43040. Check height against machine stroke prior to ordering. V-opening modifications and die relief available at an additional cost. Contact a Tooling Technician for pricing and lead times. Nitrex® standard on all large 1V dies provides HRC-70.

 = 30 lbs. / 13.6kg or more

# 80° & 85° LARGE 1V DIES



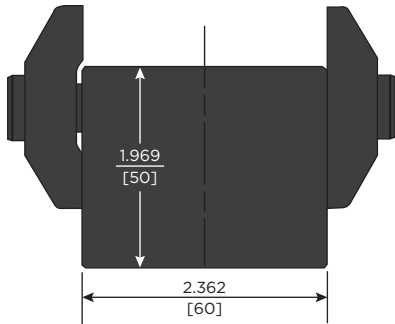
Cat. No.	A Angle	Max. Ton feet [m]	W Width inch [mm]	H Height inch [mm]	V1 inch [mm]	R Radius inch [mm]	Weight lbs/in [kg/mm]	LT 32.87" [835mm]	ST 16.34" [415mm]
<b>85° LARGE 1V DIES</b>									
42400	85°	30 [100]	2.362 [60.0]	2.362 [60.0]	1.260 [32.0]	.157 [4.0]	1.54 [.027]		
42401			2.362 [60.0]	2.362 [60.0]	1.575 [40.0]	.157 [4.0]	1.29 [.023]		
42402			2.362 [60.0]	2.362 [60.0]	1.968 [50.0]	.157 [4.0]			
42403			3.150 [80.0]	2.953 [75.0]	2.480 [63.0]	.196 [5.0]	1.92 [.034]		
42404			3.740 [95.0]	3.740 [95.0]	3.150 [80]	.236 [6.0]	2.77 [.049]		
42405			4.724 [120.0]	4.331 [110.0]	3.937 [100]	.275 [7.0]	3.87 [.069]		
<b>80° LARGE 1V DIE</b>									
42406	80°	30 [100]	6.063 [154.0]	4.843 [123.0]	4.921 [125]	.354 [9.0]	5.36 [.096]	—	


Tangs for American or WT-Style tooling can be added to the base of these dies.

Note: Large 1V Dies may require die holder #43040. Check height against machine stroke prior to ordering. V-opening modifications and die relief available at an additional cost. Contact a Tooling Technician for pricing and lead times. Nitrex® standard on all large 1V dies provides HRC-70.

= 30 lbs. / 13.6kg or more

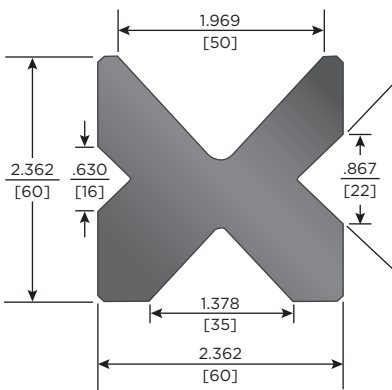
## 1V DIE HOLDER LARGE



Cat. No.	Weight lbs/in [kg/mm]	L 32.87" [835mm]	S 16.34" [415mm]
43040	1.68 [.030]	 KG	

Note: Large 1V Dies may require die holder #43040. Check height against machine stroke prior to ordering. Please check width of lower beam of press brake prior to ordering die #42406. V-opening modifications and die relief available at an additional cost. Contact a Tooling Technician for pricing and lead times. Tangs for American or WT-Style tooling can be added to the base of this die holder.

## 4-WAY DIE



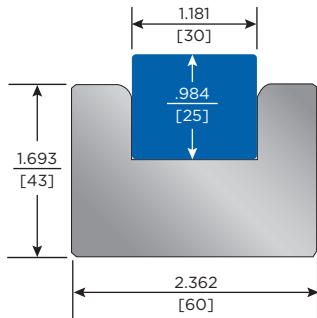
Cat. No.	V-Opening inch [mm]	Angle	Max. Ton feet [m]
42340c	V1	.630 [16]	88°
	V2	1.378 [35]	85°
	V3	.867 [22]	88°
	V4	1.969 [50]	85°
			30 [100]

Note: 4-Way Die is hardened, but does not have Nitrex® surface enhancement.

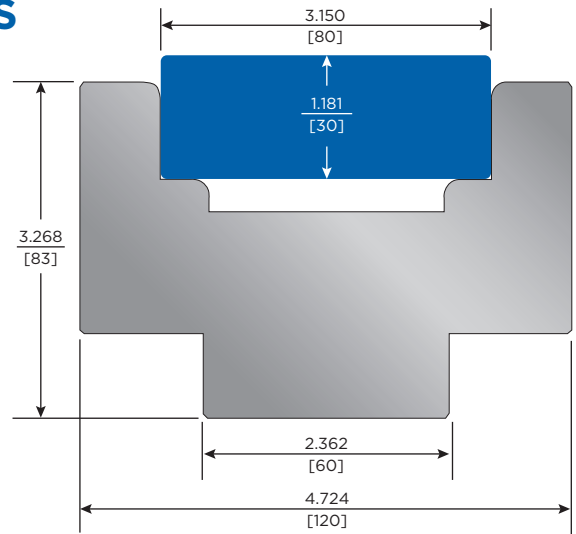
 = 30 lbs. / 13.6kg or more

## URETHANE DIE HOLDERS & PADS

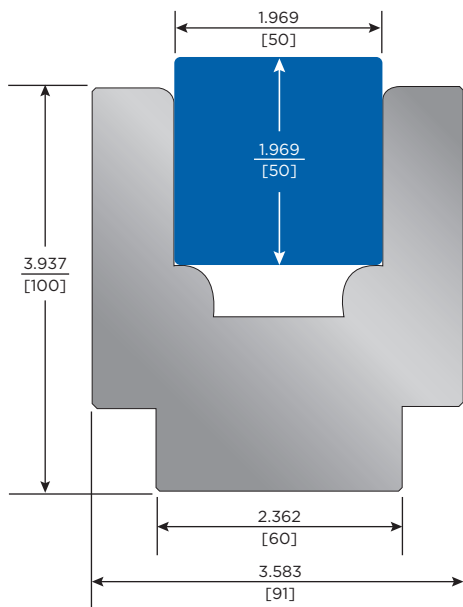
All urethane die holders are machined from 6061-T6 aluminum. Urethane holders may require die holder #43040. Check height against machine stroke prior to ordering. Tangs for American or WT-Style tooling can be added to the base of these urethane die holders.



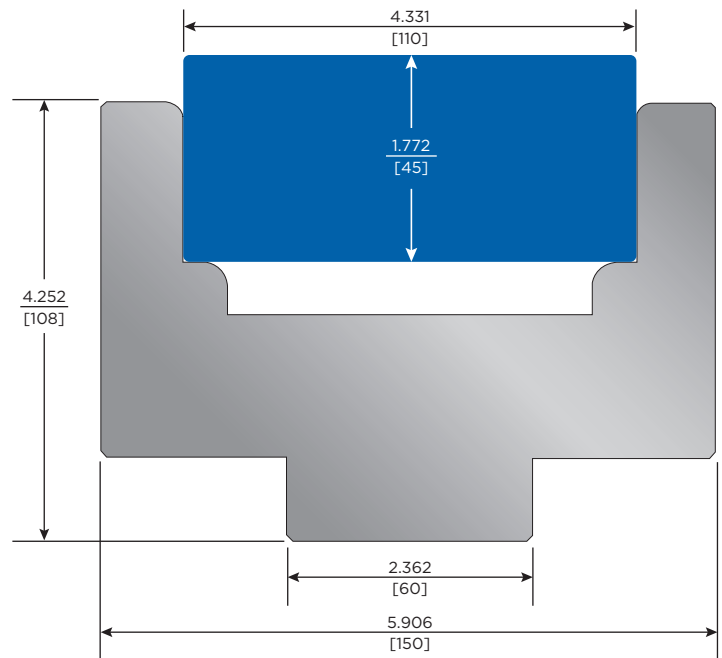
Cat. No.	Description	Shore Hardness	L 32.87" [835mm]	S 16.34" [415mm]
42501	Holder	N/A		
42511	Pad	80A/Red		
42521	Pad	90A/Blue		



Cat. No.	Description	Shore Hardness	L 32.87" [835mm]	S 16.34" [415mm]
42503	Holder	N/A		
42513	Pad	80A/Red		
42523	Pad	90A/Blue		



Cat. No.	Description	Shore Hardness	L 32.87" [835mm]	S 16.34" [415mm]
42502	Holder	N/A		
42512	Pad	80A/Red		
42522	Pad	90A/Blue		

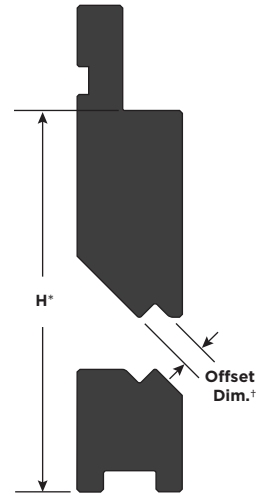


Cat. No.	Description	Shore Hardness	L 32.87" [835mm]	S 16.34" [415mm]
42504	Holder	N/A		
42514	Pad	80A/Red		
42524	Pad	90A/Blue		

EUROPEAN TRADITIONAL

# RAIL STYLE OFFSET TOOLS (NON-QUICK CHANGE)

 Watch the video on our YouTube Channel!



EUROPEAN TRADITIONAL

Cat. No.		Max. Ton feet [m]	Max. Material	H* Height inch [mm]	Offset Dim.† inch [mm]	Effective V	Weight lbs/in [kg/mm]	LT 32.87" [835mm]	ST 16.34" [415mm]	XT 32.87" [835mm]
Straight	Beveled									
<b>RAIL STYLE OFFSET TOOLS (NON-QUICK CHANGE)</b>										
43100	43100B	30 [100]	20g	3.701 [94.0]	.125 [3.2]	.177"	1.29 [.023]			
43101	43101B		18g	3.657 [92.9]	.188 [4.8]	.266"				
43102	43102B		16g	3.612 [91.8]	.250 [6.4]	.354"				
43103	43103B		14g	3.569 [90.7]	.312 [7.9]	.441"				
43104	43104B		13g	3.524 [89.5]	.375 [9.5]	.530"	1.54 [.027]			
43105	43105B		12g	3.480 [88.9]	.438 [11.1]	.619"				
43106	43106B		12g	3.436 [87.3]	.500 [12.7]	.707"				

\*Dimensions are for shut height.

†Offset height may vary as much as -.020" (0.5mm) after bending. All angles will be obtuse.

Special offset sizes are available at additional cost. Nitrex® (HRC-70) standard on all dies.

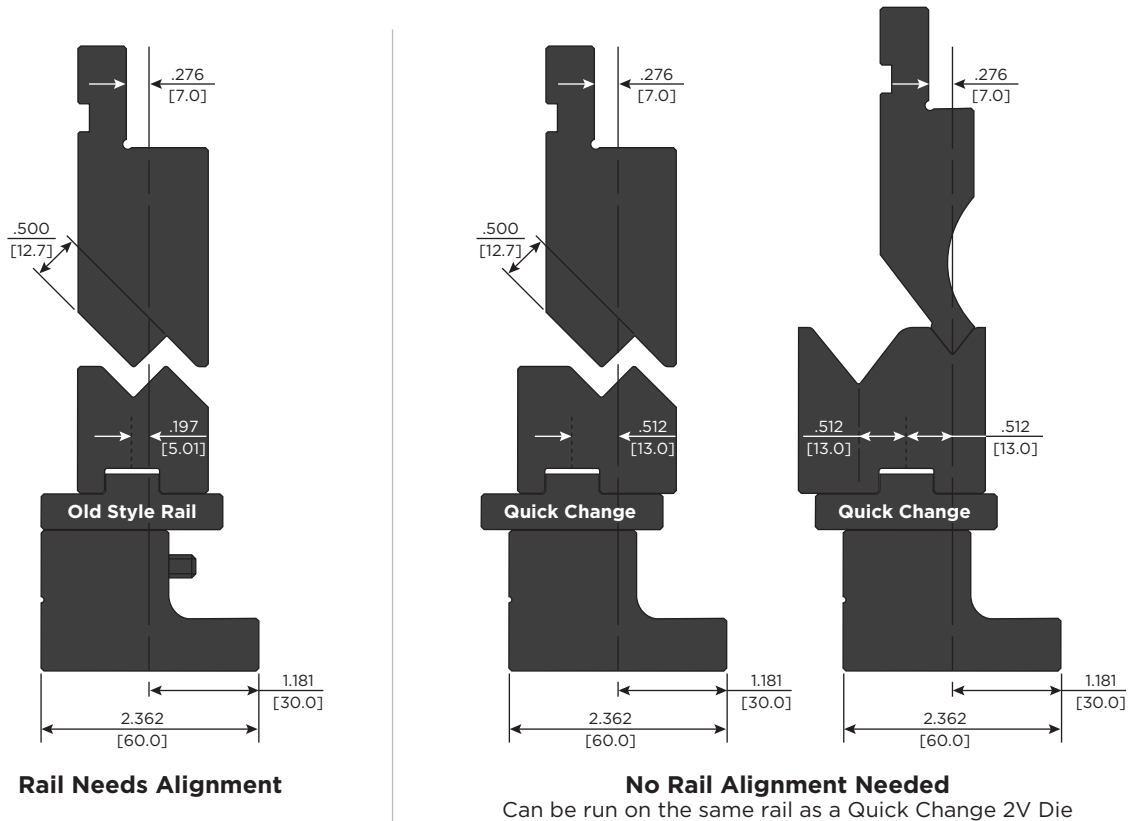
Max. Material listed will not yield a 90° bend, but is safe to use for obtuse bending.

 = 30 lbs. / 13.6kg or more



# TRUE QUICK CHANGE TOOLS

Interchangeable with Quick Change 2V Dies without the need for re-centering.  
 (Dies can be used with existing punches – the punch does not change.)



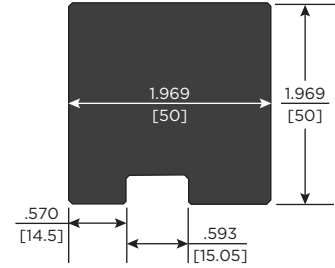
Cat. No.		Max. Ton feet [m]	Max. Material	Offset Dim. inch [m]	Effective V	Die Only Weight lbs/in [kg/mm]	LT 32.87" [835mm]	ST 16.34" [415mm]	XT 32.87" [835mm]		
Straight Beveled	Die Only										
43100xxQC	43534xxQC	30 [100]	18 GA. CRS	.125 [3.2]	.177"	0.51 [.009]					
43100xxQCB				43526xxQC	.188 [4.8]					.266"	
43101xxQC	43538xxQC				.250 [6.4]					.354"	
43101xxQCB					.312 [7.9]					.441"	
43102xxQC	43542xxQC				.375 [9.5]					.530"	0.70 [.012]
43102xxQCB					43544xxQC					.438 [11.1]	
43103xxQC			43546xxQC			.500 [12.7]				.707"	
43103xxQCB											
43104xxQC											
43104xxQCB											
43105xxQC											
43105xxQCB											
43106xxQC											
43106xxQCB											

EUROPEAN TRADITIONAL

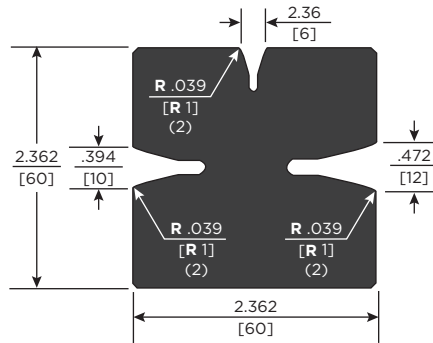
## RAIL STYLE - QUICK CHANGE

Cat. No.	Max. Ton feet [m]	Weight lbs/in [kg/mm]	LT 32.87" [835mm]	ST 16.34" [415mm]	XT 32.87" [835mm]
42312	30 [100]	0.86 [.015]			

Note: Designed to run with standard 2V Quick Change die system. Custom heights available for stage bending. Contact a Tooling Technician for pricing and lead times. Nitrex® standard on all Quick Change dies provides HRC-70.



## 3V FLATTENING DIE



Cat. No.	Max. Ton feet [m]	V1 inch [mm]	V2 inch [mm]	V3 inch [mm]	Weight lbs/in [kg/mm]	LTR 32.87" [835mm]	STR 16.34" [415mm]
42310	30 [100]	.236 [6.0]	.394 [10.0]	.472 [12.0]	1.54 [.027]		
42310R	30 [100]	.236 [6.0]	.394 [10.0]	.472 [12.0]			

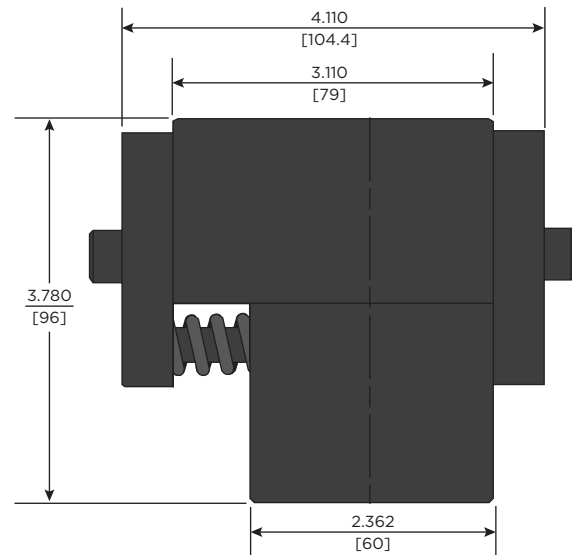
Nitrex® standard on all dies provides HRC-70.

## THRUST ABSORBING FLATTENING DIE

Cat. No.	Max. Ton feet [m]	Weight lbs/in [kg/mm]	L 32.87" [835mm]	S 16.34" [415mm]
42311	30 [100]	3.59 [064]		

Nitrex® standard on all dies provides HRC-70.

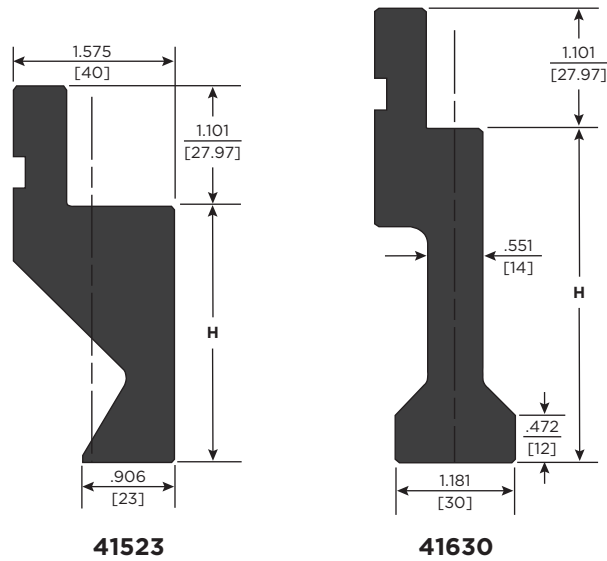
Tangs for American or WT-Style tooling can be added to the base of this die.



= 30 lbs. / 13.6kg or more

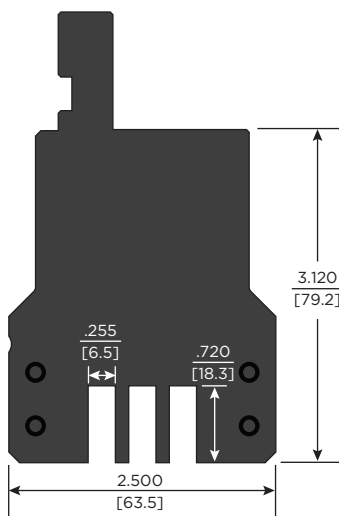


## FLATTENING PUNCHES



Cat. No.		H Height inch [mm]	Max. Ton feet [m]	Weight lbs/in [kg/mm]	LT 32.87" [835mm]	ST 16.34" [415mm]
Straight	Beveled					
41523	41523B	2.559 [65.0]	30 [100]	1.01 [.018]		
41630	41630B	3.307 [84.0]				

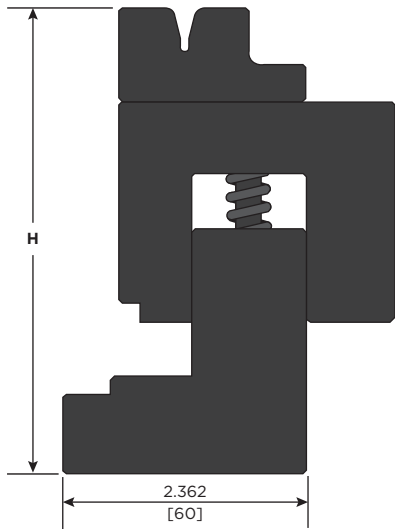
## LETTER STAMP



Cat. No.		Description	Size	Price
Straight	Beveled			
4LSP25	4LSP25B	Punch Character Holder	—	
	6898	Character	3/32"	
	6896	Character	1/8"	

= 30 lbs. / 13.6kg or more

## TWO STAGE HEMMING DIES

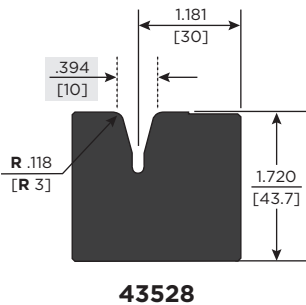
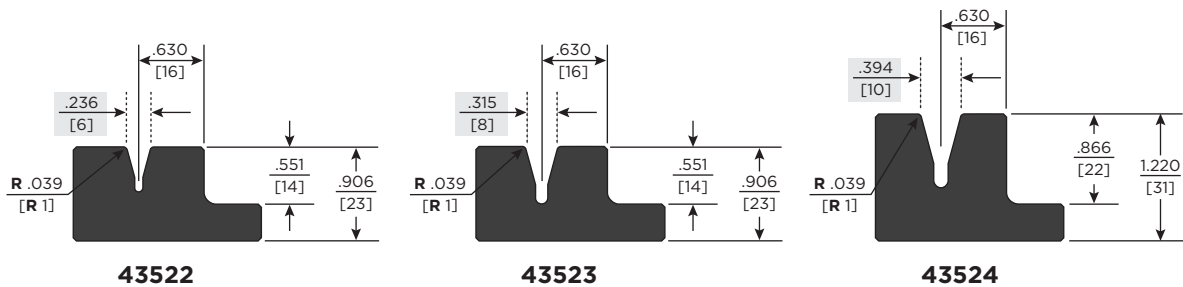


Cat. No.	V1 inch [mm]	H Height inch [mm]	Max. Ton feet [m]	Max. Material	Weight lbs/in [kg/mm]	LT 32.87" [835mm]	ST 16.34" [415mm]
42601	.236 [6.0]	4.587 [116.5]	20 [67]	20 GA. CRS	2.77 [049]		
42602	.315 [8.0]	4.587 [116.5]	20 [67]	16 GA. CRS			
42603	.394 [10.0]	4.902 [124.5]	20 [67]	14 GA. CRS			
42608	.394 [10.0]	5.402 [137.2]	25 [83]	14 GA. CRS	3.09 [.055]		

Tangs for American or WT-Style tooling can be added to the base of this die.

EUROPEAN TRADITIONAL

## REPLACEMENT V-BLOCKS FOR HEMMING DIES



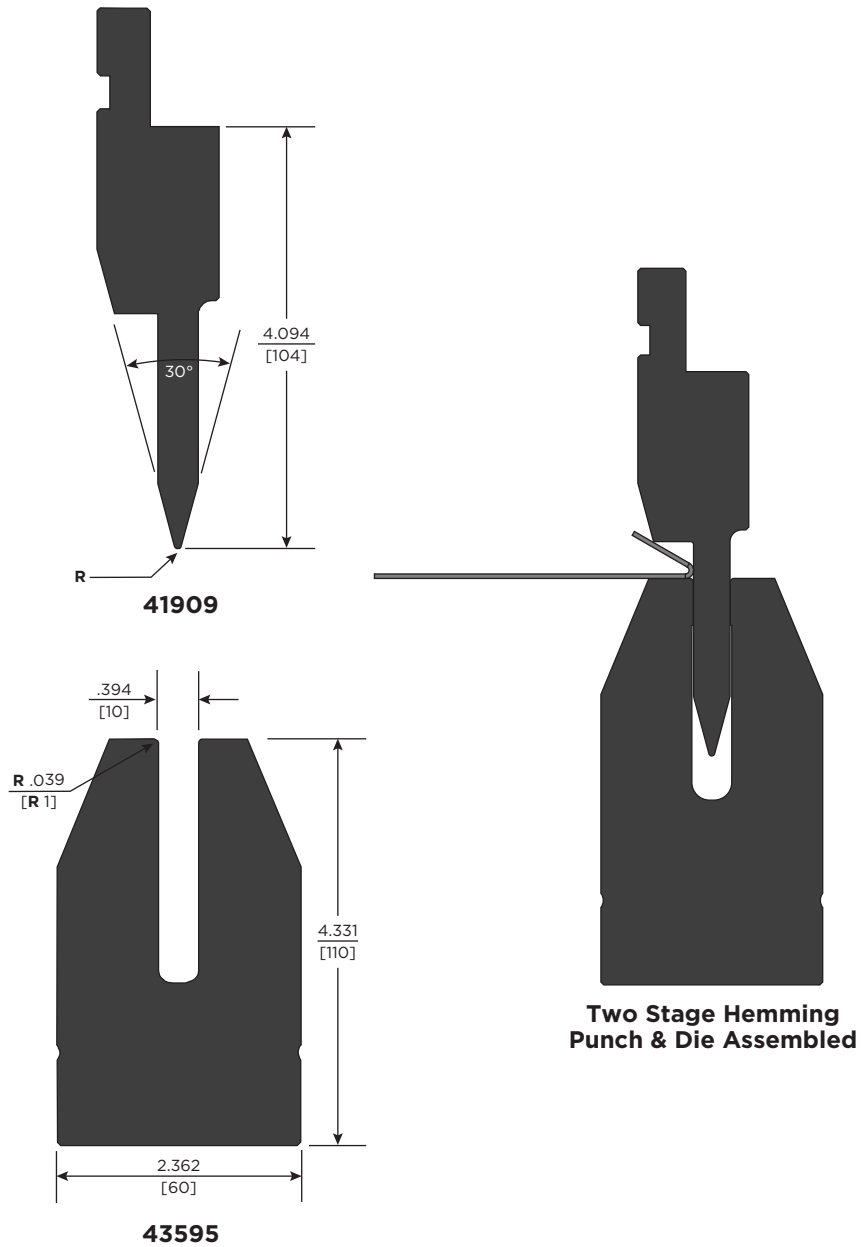
Cat. No.	Max. Ton feet [m]	Max. Material	V1 inch [mm]	Weight lbs/in [kg/mm]	LT 32.87" [835mm]	ST 16.34" [415mm]
43522	20 [67]	20 GA. CRS	.236 [6.0]	0.33 [.006]		
43523	20 [67]	16 GA. CRS	.315 [8.0]			
43524	20 [67]	14 GA. CRS	.394 [10.0]			
43528	25 [83]	14 GA. CRS	.394 [10.0]	1.01 [.018]		

Nitrex® (HRC-70) standard on all dies.

= 30 lbs. / 13.6kg or more



# TWO STAGE HEMMING PUNCH & DIE



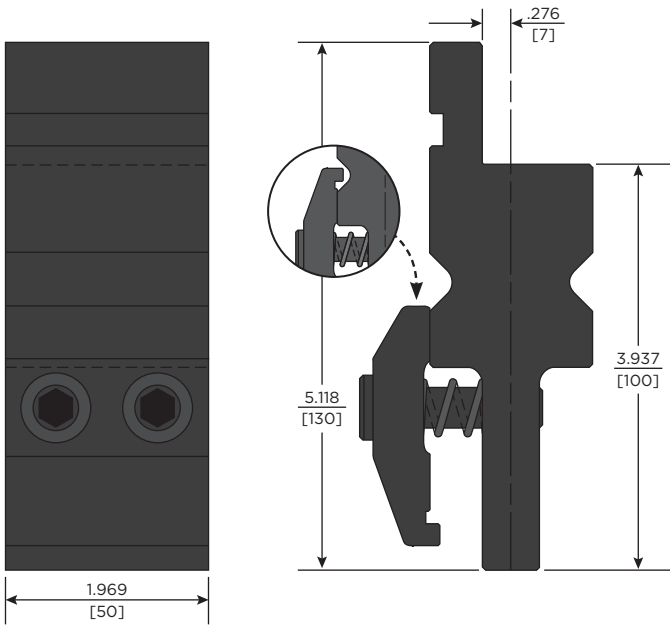
EUROPEAN TRADITIONAL

Cat. No.		Max. Ton feet [m]	R Radius inch [mm]	Height inch [mm]	Weight lbs/in [kg/mm]	LT 32.87" [835mm]	ST 16.34" [415mm]	XT 32.87" [835mm]
Straight	Beveled							
41909c		30 [100]	.008 [.0]	4.130 [105]	1.01 [.018]			
41909	41909B		.030 [.8]	4.094 [104]				
43595				.039 [1]	4.331 [110]	2.17 [.039]		

16 ga. maximum material. Nitrex® (HRC-70) standard on all dies.

= 30 lbs. / 13.6kg or more

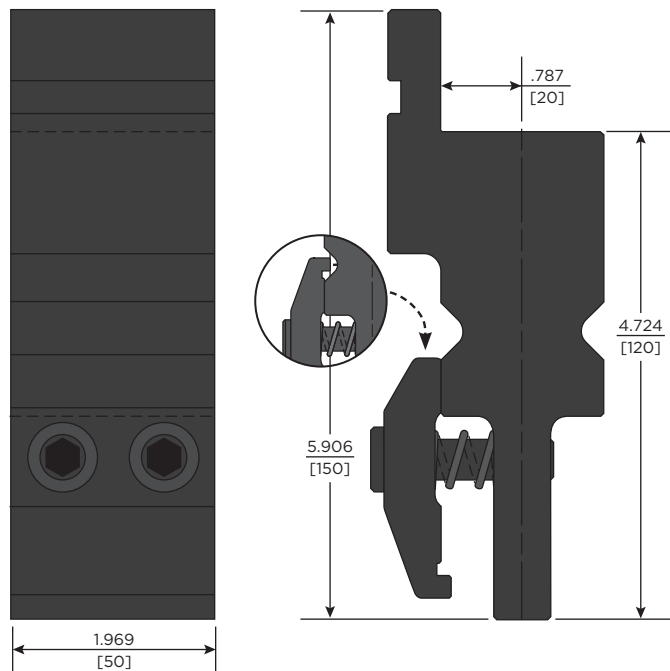
## Z1 NARROW PUNCH HOLDER



Cat. No.		Max. Ton	Weight	Price
Straight	Beveled	feet [m]	lbs [kg]	
<b>Z1 NARROW PUNCH HOLDER</b>				
43000	43000B	30 [100]	4 [1.48]	

The clamp plate included with this punch holder will accommodate a punch with or without a safety groove.

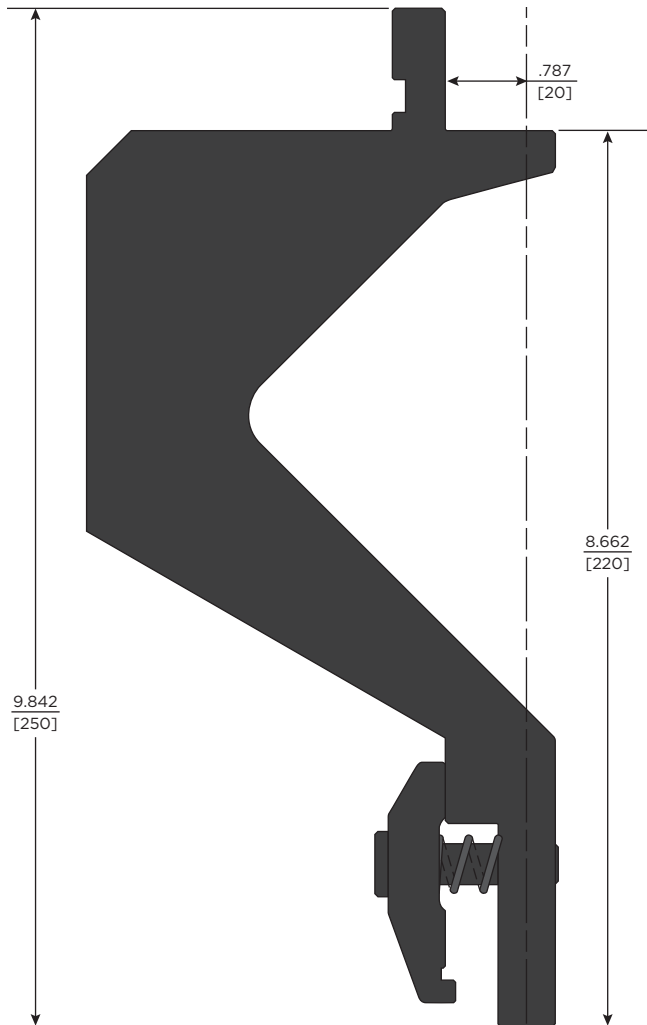
## Z2 NARROW PUNCH HOLDER



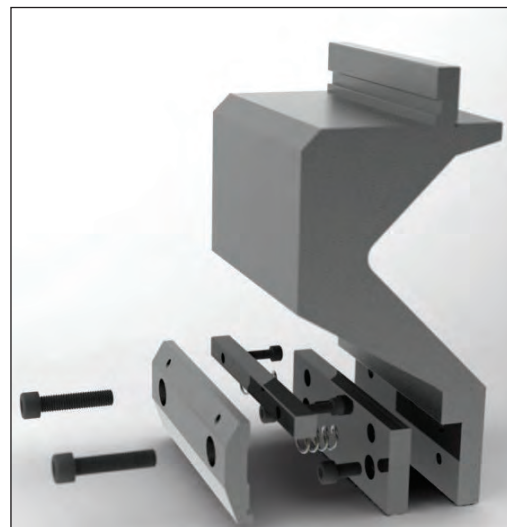
Cat. No.		Max. Ton	Weight	Price
Straight	Beveled	feet [m]	lbs [kg]	
<b>Z2 NARROW PUNCH HOLDER</b>				
43001	43001B	30 [100]	5 [1.97]	

The clamp plate included with this punch holder will accommodate a punch with or without a safety groove.

## Z2 DEEP PUNCH HOLDER



**43002**  
**Z2 Punch Holder**

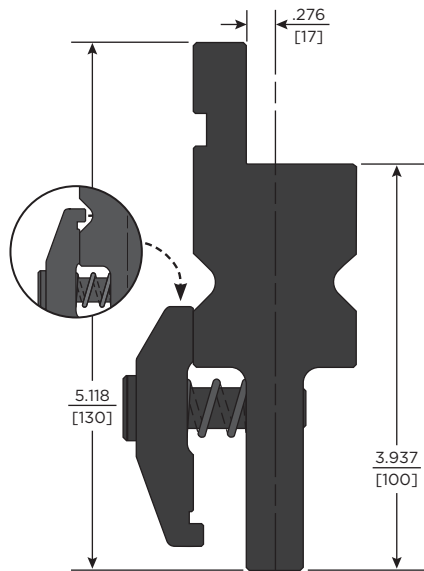
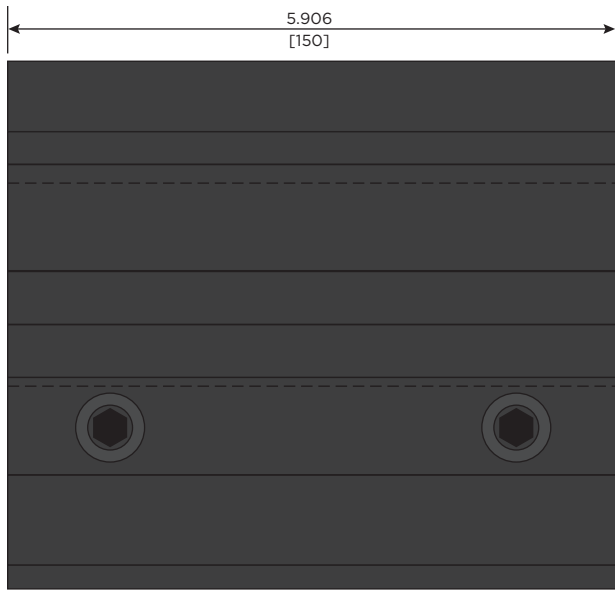


**980079**  
**Z1 Conversion Kit**

Cat. No.	Max. Ton feet [m]	Weight lbs [kg]	Length inch [mm]	Price
43002	15 [50]	29 [13.13]	5.906 [150]	
980079	Z1 Conversion Kit	5 [1.9]	5.906 [150]	

*Punch holder #43002 is designed for Z2 style upper beams, but may be modified for a Z1 center by using Kit #980079.*

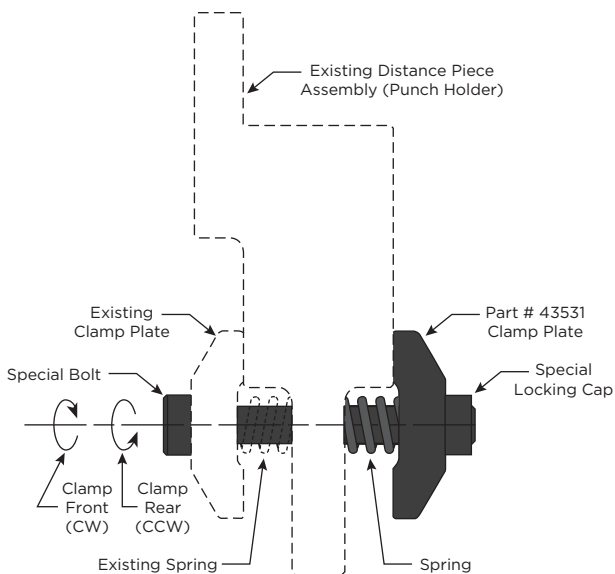
## STACKING PUNCH HOLDER



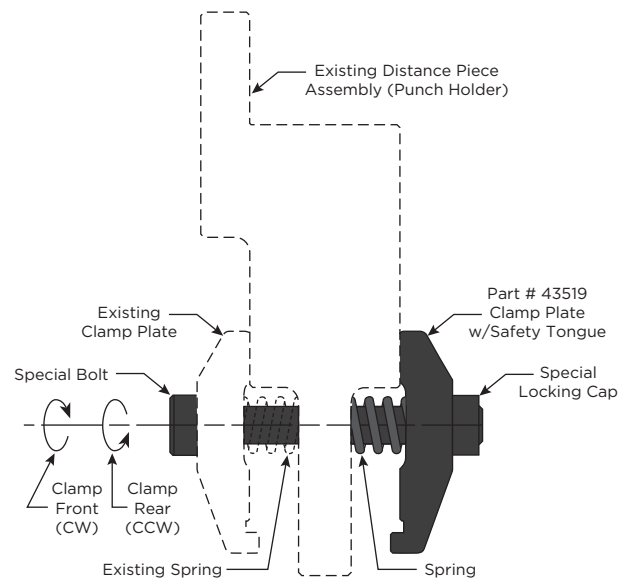
Cat. No.	Max. Ton feet [m]	Weight lbs [kg]	Price
43003	30 [100]	10 [4.32]	

The clamp plate included with this punch holder will accommodate a punch with or without a safety groove. Beveled tang available upon request.

## DUAL CLAMPING KITS



42710 Shown

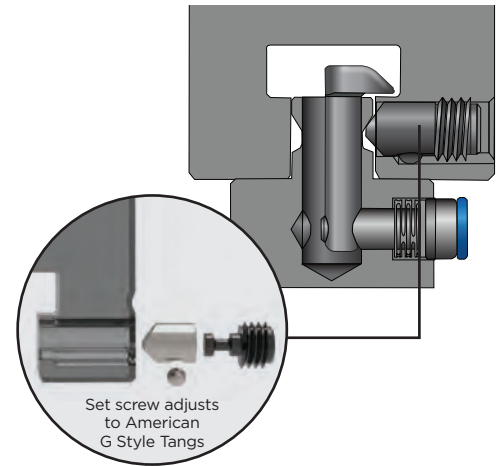
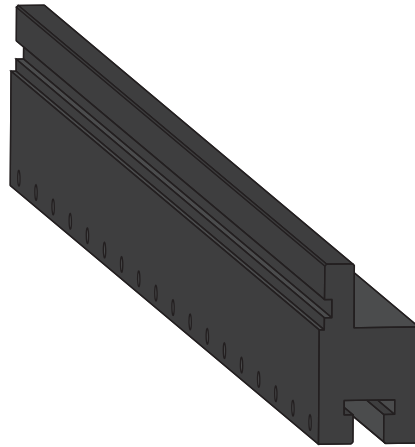
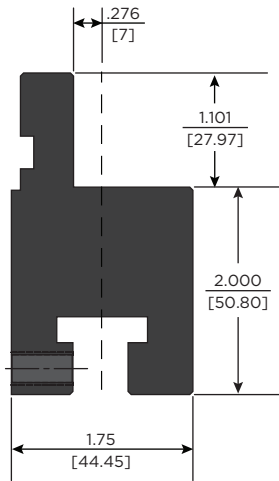


42720 Shown

Cat. No.	Description	Weight lbs [kg]	Price
42710	Flat Clamp Kit	2 [0.83]	
43531	Flat Clamp Plate	2 [0.69]	

Cat. No.	Description	Weight lbs [kg]	Price
42720	Safety Clamp Kit	3 [0.99]	
43519	Safety Clamp Plate	2 [0.85]	

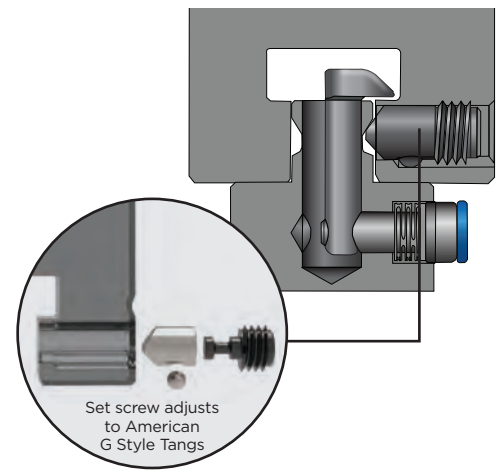
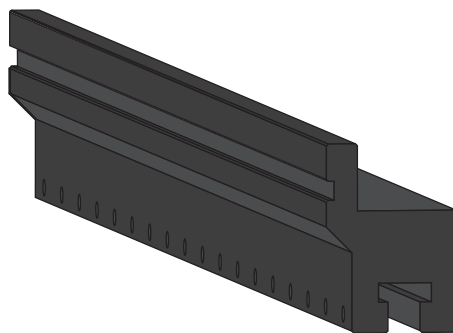
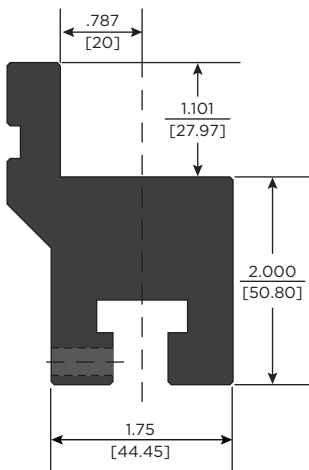
## EUROPEAN Z1 TO AMERICAN PUNCH ADAPTER



Cat. No.		Max. Ton feet [m]	Weight lbs/in [kg/mm]	L	S	X
Straight	Groove			36" [915mm]	18" [457mm]	36" [915mm]
43851	43861	30 [100]	1.01 [.018]			

All holders include clamping set screws every 2" [50.8mm]. All tonnages are based on direct load and do not apply for thrusting applications. #43851 is a self-seating punch holder for American G Style Punches.

## EUROPEAN Z2 TO AMERICAN PUNCH ADAPTER

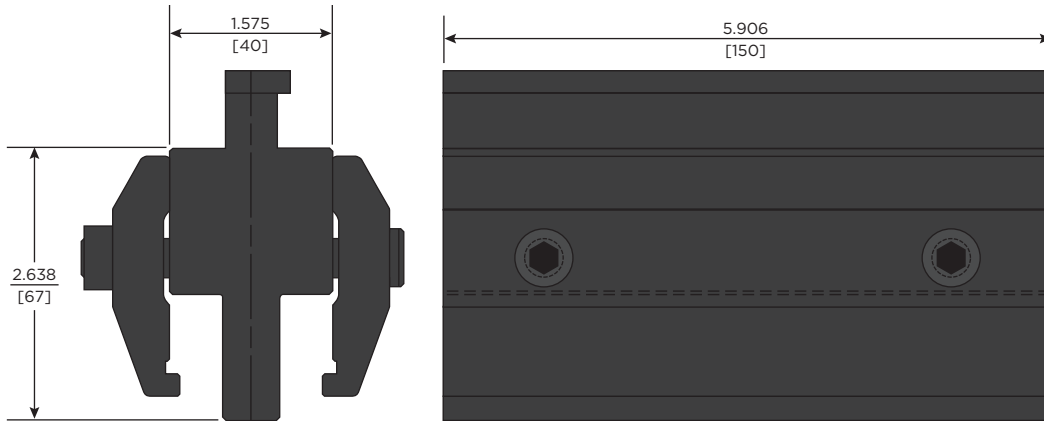


Cat. No.		Max. Ton feet [m]	Weight lbs/in [kg/mm]	L	S	X
Straight	Groove			36" [915mm]	18" [457mm]	36" [915mm]
43852	43862	30 [100]	1.16 [.021]			

All holders include clamping set screws every 2" [50.8mm]. All tonnages are based on direct load and do not apply for thrusting applications. #43852 is a self-seating punch holder for American G Style Punches.

= 30 lbs. / 13.6kg or more

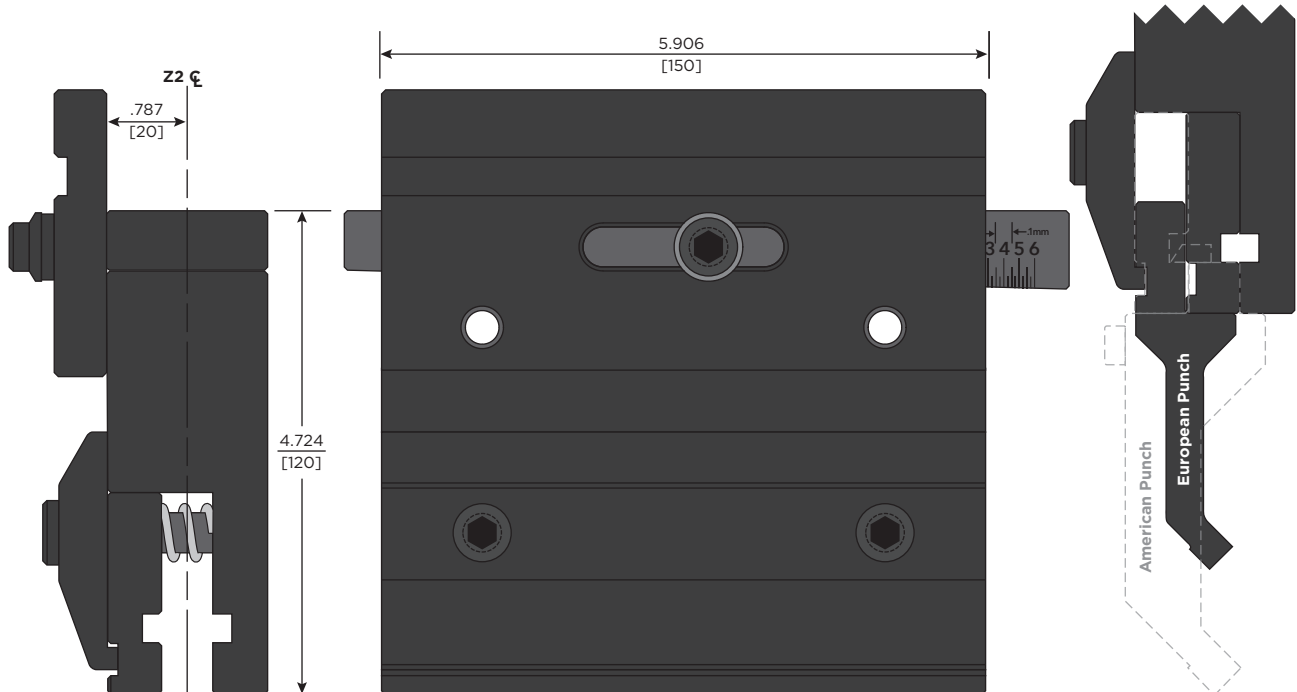
## AMERICAN TO EUROPEAN PUNCH ADAPTER



Cat. No.	Description	Max. Ton feet [m]	Weight lbs [kg]	5.906" [150mm]
43004	American to European Punch Adapter	30 [100]	10 [4.17]	

For Conventional Press Brakes without punch holder height adjustment.

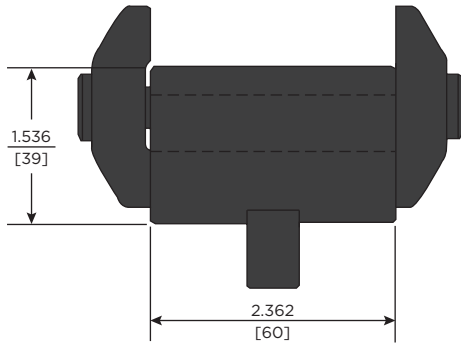
## Z2 SERIES W/DUAL AMERICAN & EUROPEAN CLAMPING




Cat. No.	Description	Max. Ton feet [m]	Weight lbs [kg]	5.906" [150mm]
43853	Z2 Series with Dual American & European Clamping	30 [100]	15 [6.5]	



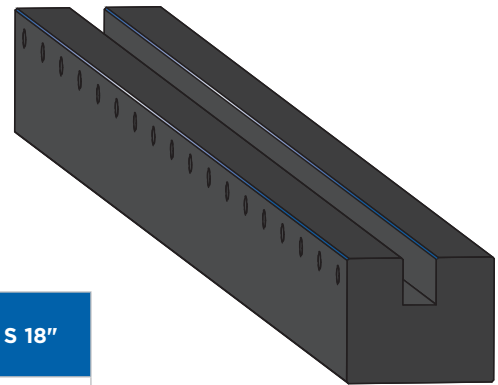
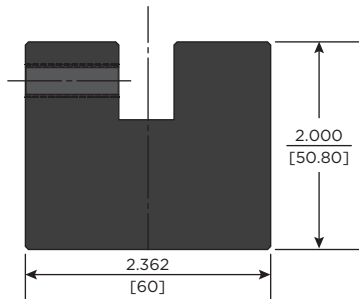
## AMERICAN TO EUROPEAN DIE ADAPTER




Cat. No.	Description	Max. Ton/ft.	Weight lbs/in [kg/mm]	L 32.87"	S 16.34"
43006	American to European Die Holder	40	1.54 [.027]		


Please verify press brake tongue slot width when ordering.

## EUROPEAN TO AMERICAN DIE ADAPTER



Cat. No.	Description	Max. Ton/ft.	Weight lbs/in [kg/mm]	L 36"	S 18"
43590	European to American Die Holder	40	1.54 [.027]		

EUROPEAN TRADITIONAL

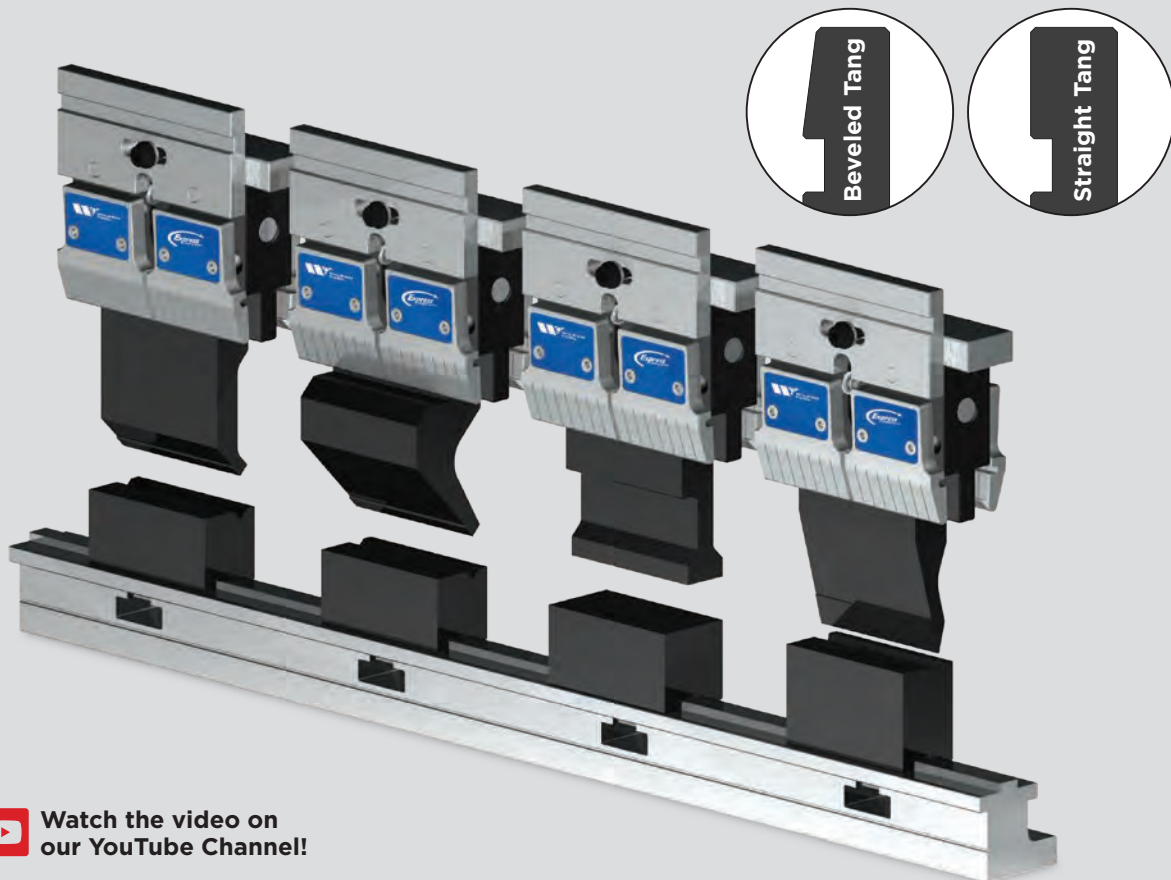
 = 30 lbs. / 13.6kg or more

# EUROPEAN STAGED TOOLING

## REDUCE YOUR SETUP TIME WITH STAGED TOOLING

As smaller press brake runs become more routine, valuable production time is often lost on performing multiple setups. Press brake fabricators can significantly improve productivity by minimizing setup time with staged bending solutions from Wilson Tool International. Our progressive approach to press brake tooling can improve workflow and help make even complex short runs more cost effective.

Punches are commonly loaded into a segmented holder. This allows for shorter punches to be used for box bending since the punch holder creates space for the part, and also increases the height of the punch. All punches are available with a straight or beveled tang.

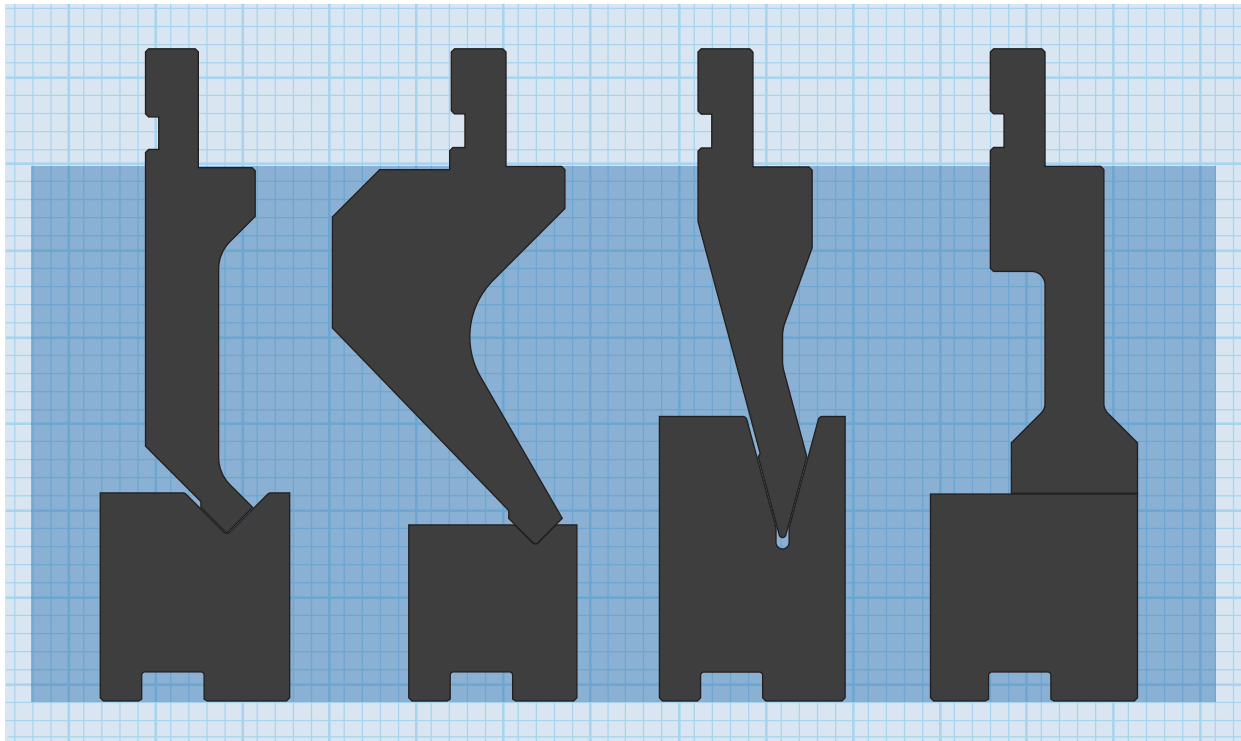


 Watch the video on  
our YouTube Channel!

## WHAT IS “STAGED” TOOLING?

In a press brake, stage bending is the process of developing multiple tooling setups that have a common shut height. This enables press brake operators to carry out multiple bends with a single setup. Groups of tools are set up progressively along the press brake, then all bends on a single part are performed in succession. This simplifies complex jobs by eliminating unproductive, repetitive tasks – **significantly reducing setup time, part handling and work-in-progress.**

**To successfully accomplish staged tooling, each tool in a set must share a common shut height.**



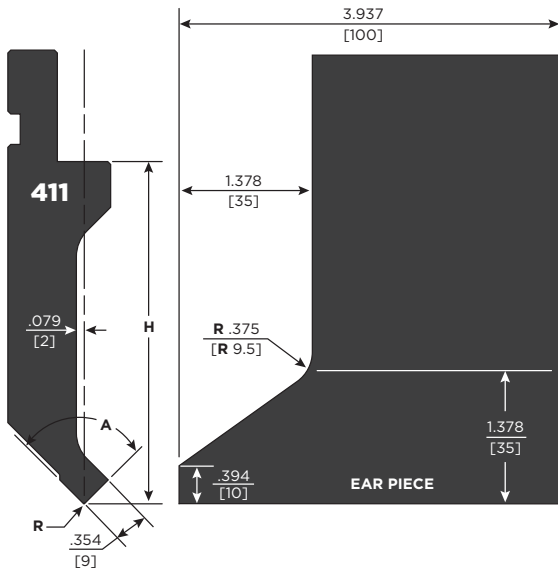
EUROPEAN STAGED

**Let Wilson Tool International save  
you time with European Staged Tooling!**

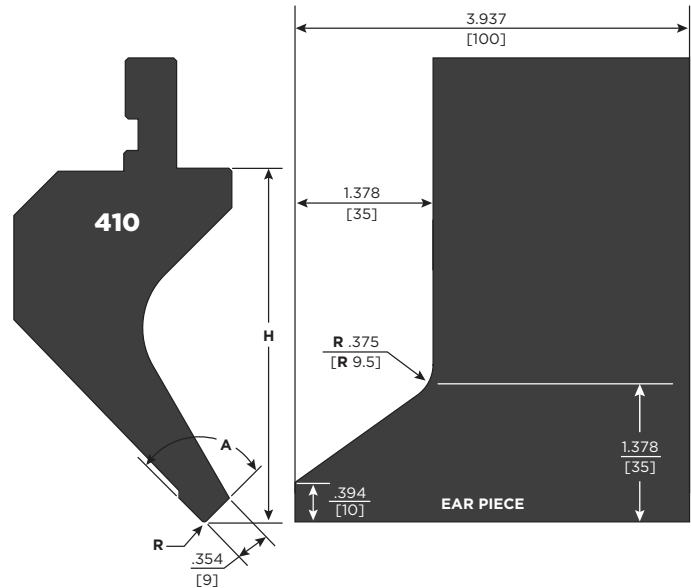
**Contact a Tooling Technician today at  
[bending@wilsontool.com](mailto:bending@wilsontool.com) or 800-445-4518.**

 Watch the video on  
our YouTube Channel!

## 88° & 90° SASH



## 88° & 90° GOOSENECK



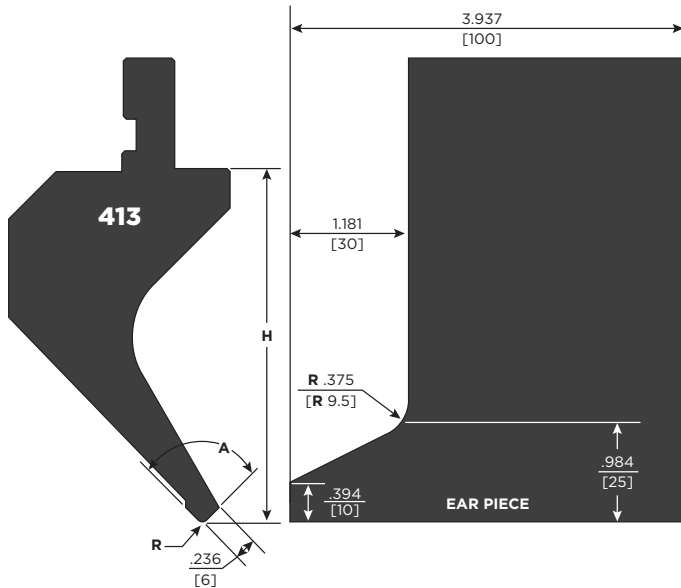
EUROPEAN STAGED

### 90mm TALL PUNCHES — STAGED TOOLING

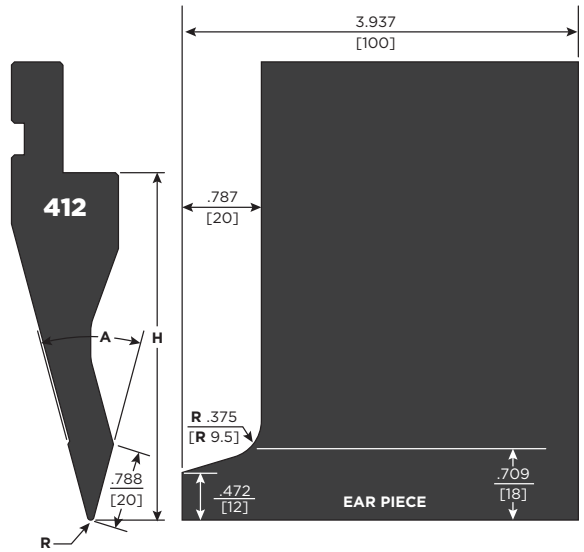
Cat. No.	R Tip Radius inch [mm]	A Angle	H Height inch [mm]	LT & ST	XT	Weight lbs/in [kg/mm]	LT	ST	XT
				Max. Ton feet [m]			32.87" [835mm]	16.34" [415mm]	32.87" [835mm]
<b>411 SERIES — 90° &amp; 88° SASH PUNCHES</b>									
41190002	.008 [0.2]	90°	3.540 [89.9]	30 [100]	12 [40]	.86 [.015]			
41190008	.030 [0.8]		3.530 [89.7]						
411c	.060 [1.5]		3.519 [89.4]						
	.090 [2.3]		3.506 [89.0]						
41188002	.008 [0.2]	88°	3.540 [89.9]	30 [100]	12 [40]				
	41188008		.030 [0.8]				3.529 [89.6]		
411c	.060 [1.5]		3.517 [89.3]						
	.090 [2.3]		3.504 [89.0]						
	.120 [3.0]		3.491 [88.7]						
<b>410 SERIES — 90° &amp; 88° GOOSENECK PUNCHES</b>									
41090002	.008 [0.2]	90°	3.540 [89.9]	21 [70]	14 [47]	1.29 [.23]			
41090008	.030 [0.8]		3.530 [89.7]						
41090015	.060 [1.5]		3.519 [89.4]						
410c	.090 [2.3]		3.506 [89.0]						
	.120 [3.0]	3.494 [88.8]							
40602	.008 [0.2]	88°	3.540 [89.9]	21 [70]	14 [47]				
40608	.030 [0.8]		3.529 [89.6]						
40615	.060 [1.5]		3.517 [89.3]						
410c	.090 [2.3]		3.504 [89.0]						
	.120 [3.0]		3.491 [88.7]						



## 88° & 90° THIN TIP GOOSENECK



## 30° ACUTE

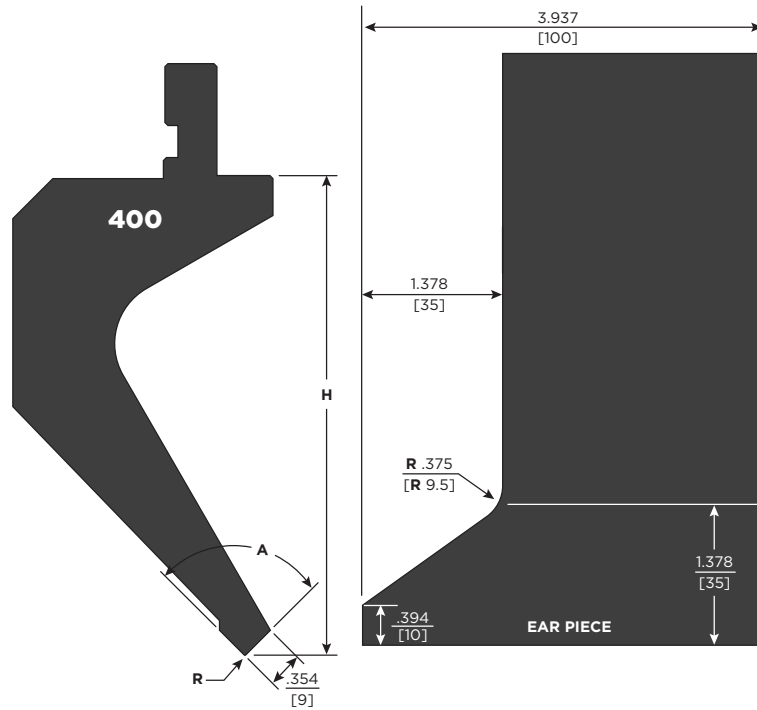


### 90mm TALL PUNCHES — STAGED TOOLING

Cat. No.	R Tip Radius inch [mm]	A Angle	H Height inch [mm]	LT & ST	XT	Weight lbs/in [kg/mm]	LT	ST	XT
				Max. Ton feet [m]			32.87" [835mm]	16.34" [415mm]	32.87" [835mm]
<b>413 SERIES — 90° &amp; 88° THIN TIP GOOSENECK PUNCHES</b>									
40712	.008 [0.2]	90°	3.540 [89.9]	15 [50]	9 [30]	1.29 [.23]			
40718	.030 [0.8]		3.530 [89.7]						
413c	.060 [1.5]		3.519 [89.4]						
	.090 [2.3]		3.506 [89.0]						
	.120 [3.0]	3.494 [88.8]							
40702	.008 [0.2]	88°	3.540 [89.9]	15 [50]	9 [30]	1.29 [.23]			
40708	.030 [0.8]		3.529 [89.6]						
413c	.090 [2.3]		3.504 [89.0]						
	.120 [3.0]		3.491 [88.7]						
<b>412 SERIES — 30° ACUTE PUNCHES</b>									
412c	.008 [0.2]	30°	3.479 [88.4]	30 [100]	6 [20]	.86 [.015]			
41230008	.030 [0.8]		3.453 [87.7]						

= 30 lbs. / 13.6kg or more

# 88° & 90° GOOSENECK



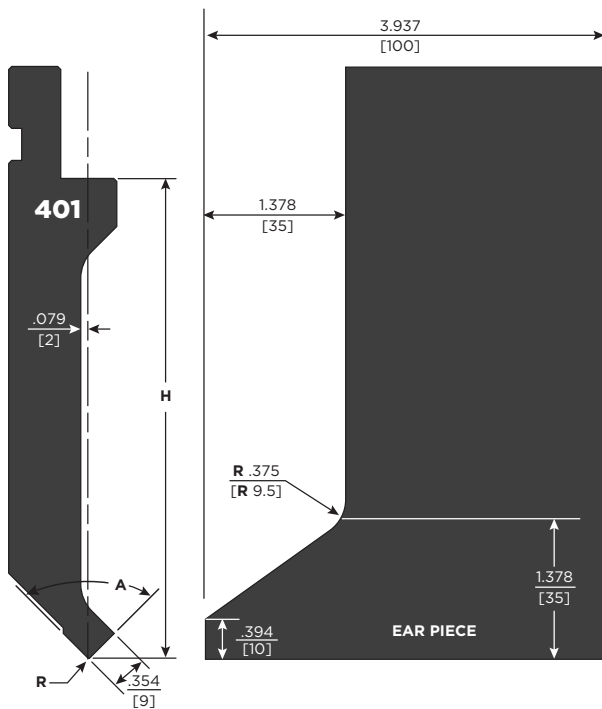
### 120mm TALL PUNCHES — STAGED TOOLING

Cat. No.	R Tip Radius inch [mm]	A Angle	H Height inch [mm]	LT & ST	XT	Weight lbs/in [kg/mm]	LT	ST	XT
				Max. Ton feet [m]			32.87" [835mm]	16.34" [415mm]	32.87" [835mm]
<b>400 SERIES — 90° &amp; 88° GOOSENECK PUNCHES</b>									
400c	.008 [0.2]	90°	4.721 [119.9]	15 [50]	9 [30]	1.68 [.030]			
	.030 [0.8]		4.711 [119.7]						
	.060 [1.5]		4.700 [119.4]						
	.090 [2.3]		4.687 [119.0]						
	.120 [3.0]		4.675 [118.8]						
40302	.008 [0.2]	88°	4.721 [119.9]	15 [50]	9 [30]	1.68 [.030]			
40308	.030 [0.8]		4.711 [119.6]						
400c	.060 [1.5]		4.698 [119.3]						
	.090 [2.3]		4.685 [119.0]						
	.120 [3.0]		4.672 [118.7]						

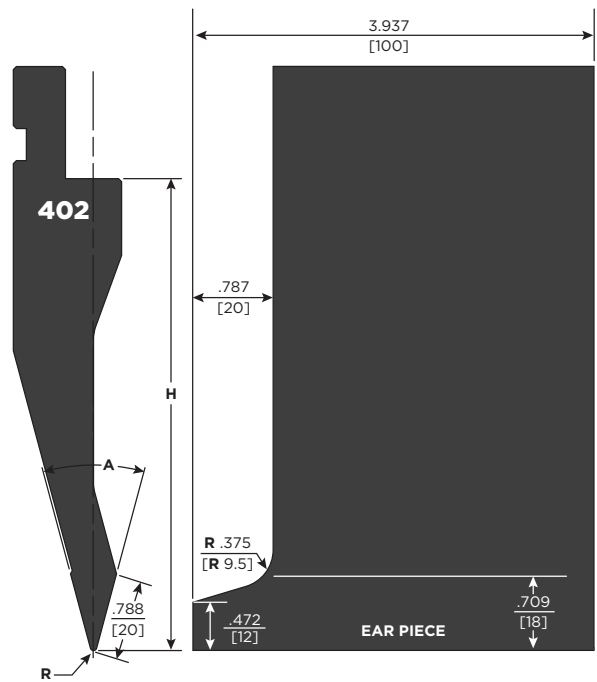
= 30 lbs. / 13.6kg or more



## 88° & 90° SASH



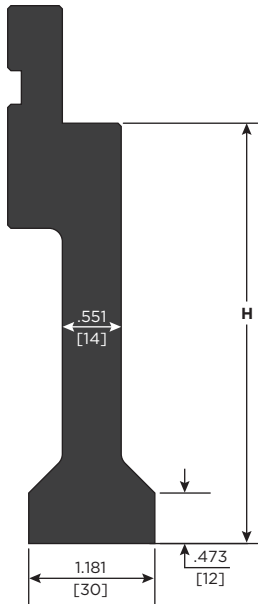
## 30° ACUTE



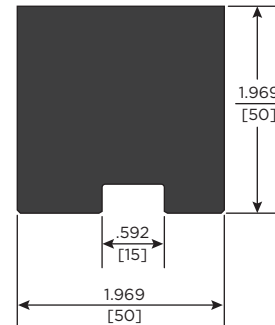
120mm TALL PUNCHES – STAGED TOOLING									
Cat. No.	R Tip Radius inch [mm]	A Angle	H Height inch [mm]	LT & ST	XT	Weight lbs/in [kg/mm]	LT	ST	XT
				Max. Ton feet [m]			32.87" [835mm]	16.34" [415mm]	32.87" [835mm]
401 SERIES – 90° & 88° SASH PUNCHES									
401c	.008 [0.2]	90°	4.721 [119.9]	30 [100]	12 [40]	1.09 [.019]			
	.030 [0.8]		4.711 [119.7]						
	.060 [1.5]		4.700 [119.4]						
	.090 [2.3]		4.687 [119.0]						
	.120 [3.0]		4.675 [118.8]						
	.008 [0.2]	88°	4.721 [119.9]	30 [100]	12 [40]				
	.030 [0.8]		4.711 [119.6]						
	.060 [1.5]		4.698 [119.3]						
	.090 [2.3]		4.685 [119.0]						
	.120 [3.0]		4.672 [118.7]						
402 SERIES – 30° ACUTE PUNCHES									
402c	.008 [0.2]	30°	4.701 [119.4]	30 [100]	6 [20]	0.99 [.018]			
	.030 [0.8]		4.634 [117.7]						


EUROPEAN STAGED

## FLATTENING PUNCH




## FLATTENING DIE



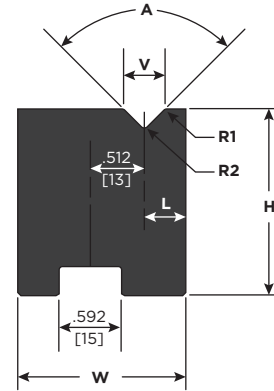
Cat. No.	Staging Family	H Height inch [mm]	Max. Ton feet [m]	Weight lbs/in [kg/mm]	LT	ST	XT
					32.87" [835mm]	16.34" [415mm]	32.87" [835mm]
<b>FLATTENING PUNCH</b>							
41400000	90mm	3.150 [80.0]	30 [100]	1.01 [.018]			
40400001	120mm	4.330 [110.0]					

Cat. No.	Max. Ton feet [m]	Weight lbs/in [kg/mm]	LT	ST	XT
			32.87" [835mm]	16.34" [415mm]	32.87" [835mm]
<b>FLATTENING DIE</b>					
42312	30 [100]	.86 [.015]			

 = 30 lbs. / 13.6kg or more



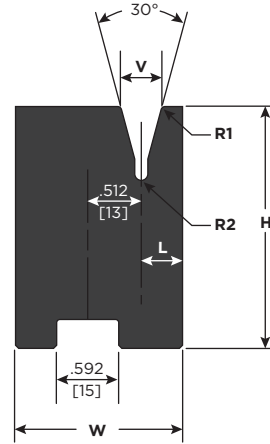
# QUICK CHANGE 90° & 88° DIES



Cat. No.	V V-Opening inch [mm]	R1 Sh. Radius inch [mm]	R2 V Radius inch [mm]	L Opening inch [mm]	W Width inch [mm]	H Height inch [mm]	Max. Ton feet [m]	Weight lbs/in [kg/mm]	LT	ST	XT
									32.87" [835mm]	16.34" [415mm]	32.87" [835mm]
<b>QC STAGED 90° DIES</b>											
45090006	.236 [6.0]	.024 [0.6]	.008 [0.2]	.394 [10.0]	1.594 [40.5]	1.693 [43.0]	30 [100]	.86 [.015]			
45090008	.315 [8.0]	.031 [0.8]		.394 [10.0]	1.594 [40.5]	1.732 [44.0]					
45090010	.394 [10.0]	.039 [1.0]		.394 [10.0]	1.594 [40.5]	1.772 [45.0]					
45090012	.472 [12.0]	.039 [1.0]		.492 [12.5]	1.693 [43.0]	1.811 [46.0]					
<b>QC STAGED 88° DIES</b>											
45088006	.236 [6.0]	.024 [0.6]	.008 [0.2]	.394 [10.0]	1.594 [40.5]	1.697 [43.1]	30 [100]	.86 [.015]			
45088008	.315 [8.0]	.031 [0.8]		.394 [10.0]	1.594 [40.5]	1.738 [44.1]					
45088010	.394 [10.0]	.039 [1.0]		.394 [10.0]	1.594 [40.5]	1.779 [45.2]					
45088012	.472 [12.0]	.039 [1.0]		.394 [10.0]	1.693 [43.0]	1.819 [46.2]					
45088016	.630 [16.0]	.059 [1.5]		.492 [12.5]	1.791 [45.5]	1.901 [48.3]		1.01 [.018]			
45088020	.787 [20.0]	.079 [2.0]		.591 [15.0]	1.791 [45.5]	1.983 [50.4]		1.29 [.23]			
45088024	.945 [24.0]	.098 [2.5]		.689 [17.5]	1.890 [48.0]	2.064 [52.4]					
45088030	1.181 [30.0]	.118 [3.0]		.886 [22.5]	2.087 [53.0]	2.186 [55.5]					

= 30 lbs. / 13.6kg or more

# QUICK CHANGE 30° DIES



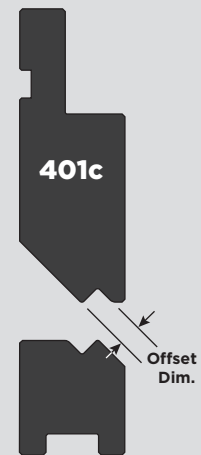
Cat. No.	V Opening inch [mm]	R1 Sh. Radius inch [mm]	R2 V Radius inch [mm]	L Opening inch [mm]	W Width inch [mm]	H Height inch [mm]	Max. Ton feet [m]	Weight lbs/in [kg/mm]	LT	ST	XT
									32.87" [835mm]	16.34" [415mm]	32.87" [835mm]
<b>QC STAGED 30° DIES</b>											
45030006	.236 [6.0]	.039 [1.0]	.063 [1.6]	.394 [10.0]	1.594 [40.5]	2.016 [51.2]	30 [100]	.86 [.015]			
45030008	.315 [8.0]	.039 [1.0]	.063 [1.6]	.394 [10.0]	1.594 [40.5]	2.163 [54.9]	30 [100]	1.01 [.018]			
45030010	.394 [10.0]	.039 [1.0]	.063 [1.6]	.394 [10.0]	1.594 [40.5]	2.310 [58.7]	23 [77]				
45030012	.472 [12.0]	.039 [1.0]	.063 [1.6]	.492 [12.5]	1.693 [43.0]	2.456 [62.4]	20 [67]	.86 [.015]			
45030016	.630 [16.0]	.063 [1.6]	.094 [2.4]	.591 [15.0]	1.791 [45.5]	2.750 [69.9]	18 [60]	1.29 [.023]			
45030020	.787 [20.0]	.079 [2.0]	.094 [2.4]	.689 [17.5]	1.890 [48.0]	3.044 [77.3]	15 [50]	1.54 [.027]			
45030024	.945 [24.0]	.098 [2.5]	.094 [2.4]	.787 [20.0]	1.988 [50.5]	3.338 [84.8]	15 [50]	1.68 [.030]			

EUROPEAN STAGED

## STAGED OFFSET TOOLS

Order staged offset tooling to meet your needs. Let us know what size, angle, staged height family and length needed and we will make it.

Contact our expert Tooling Technicians at [bending@wilsonstool.com](mailto:bending@wilsonstool.com) or 800-445-4518.

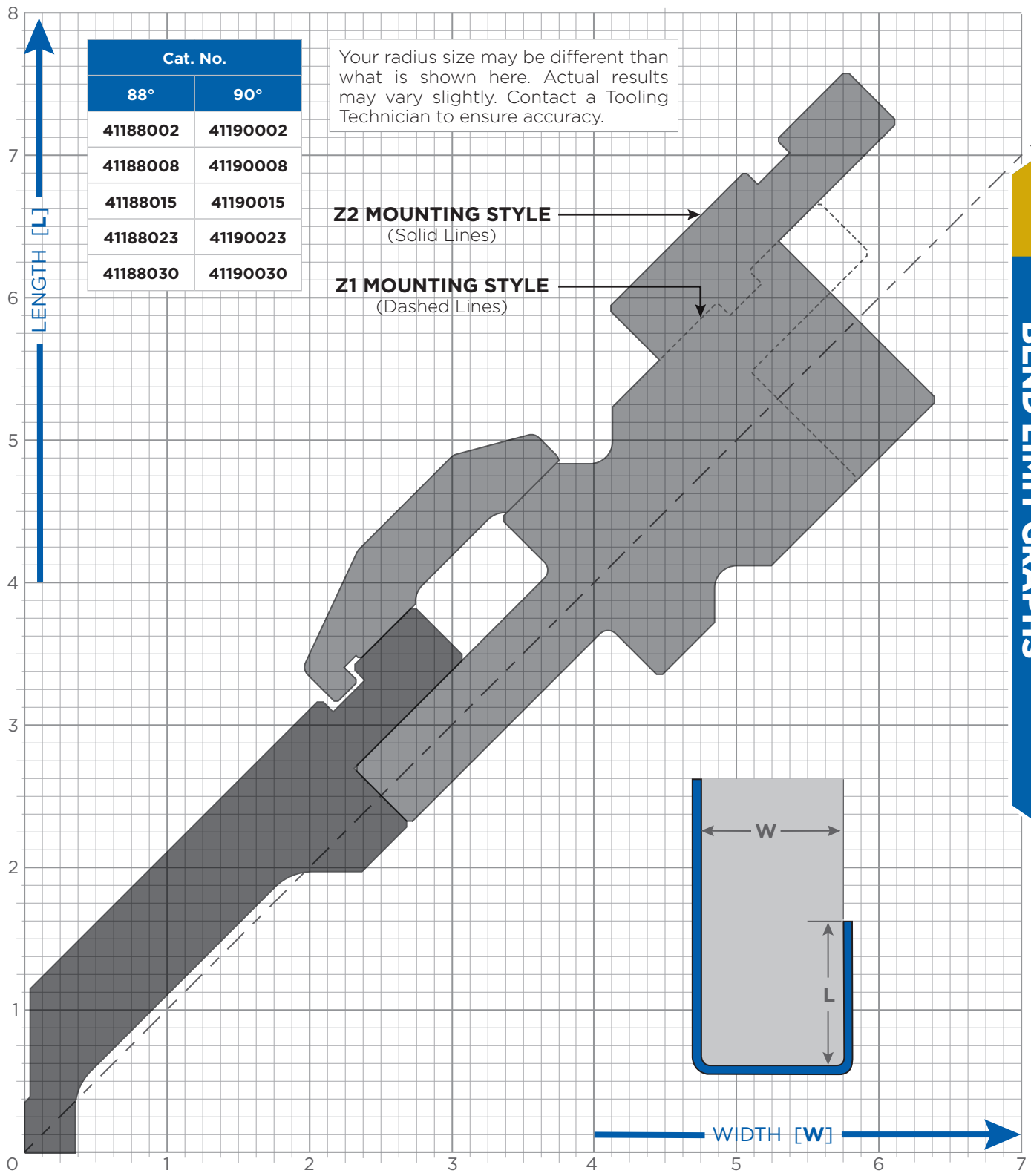


= 30 lbs. / 13.6kg or more



# SASH PUNCH (STAGED)

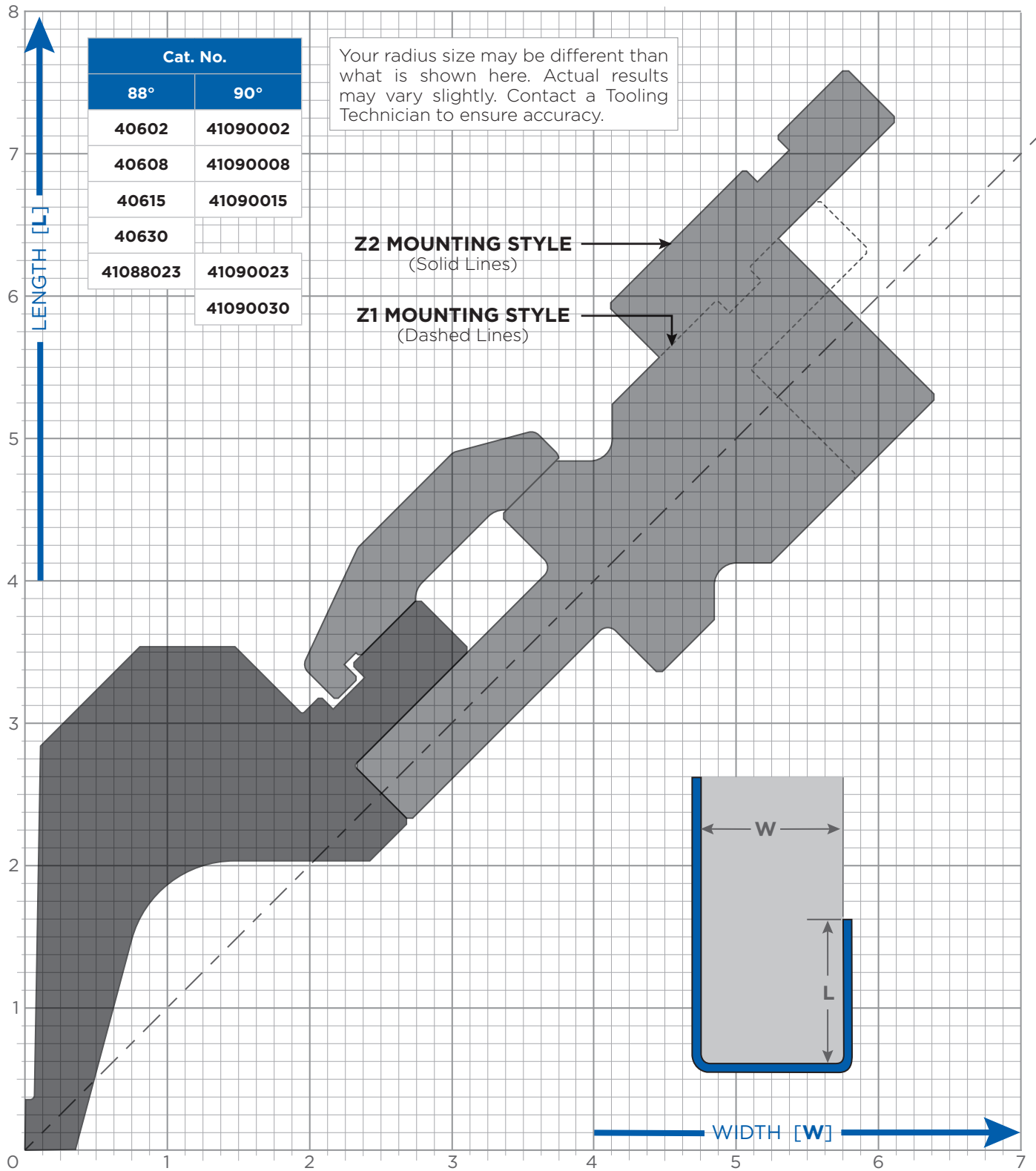
88° & 90°



# GOOSENECK PUNCH (STAGED)

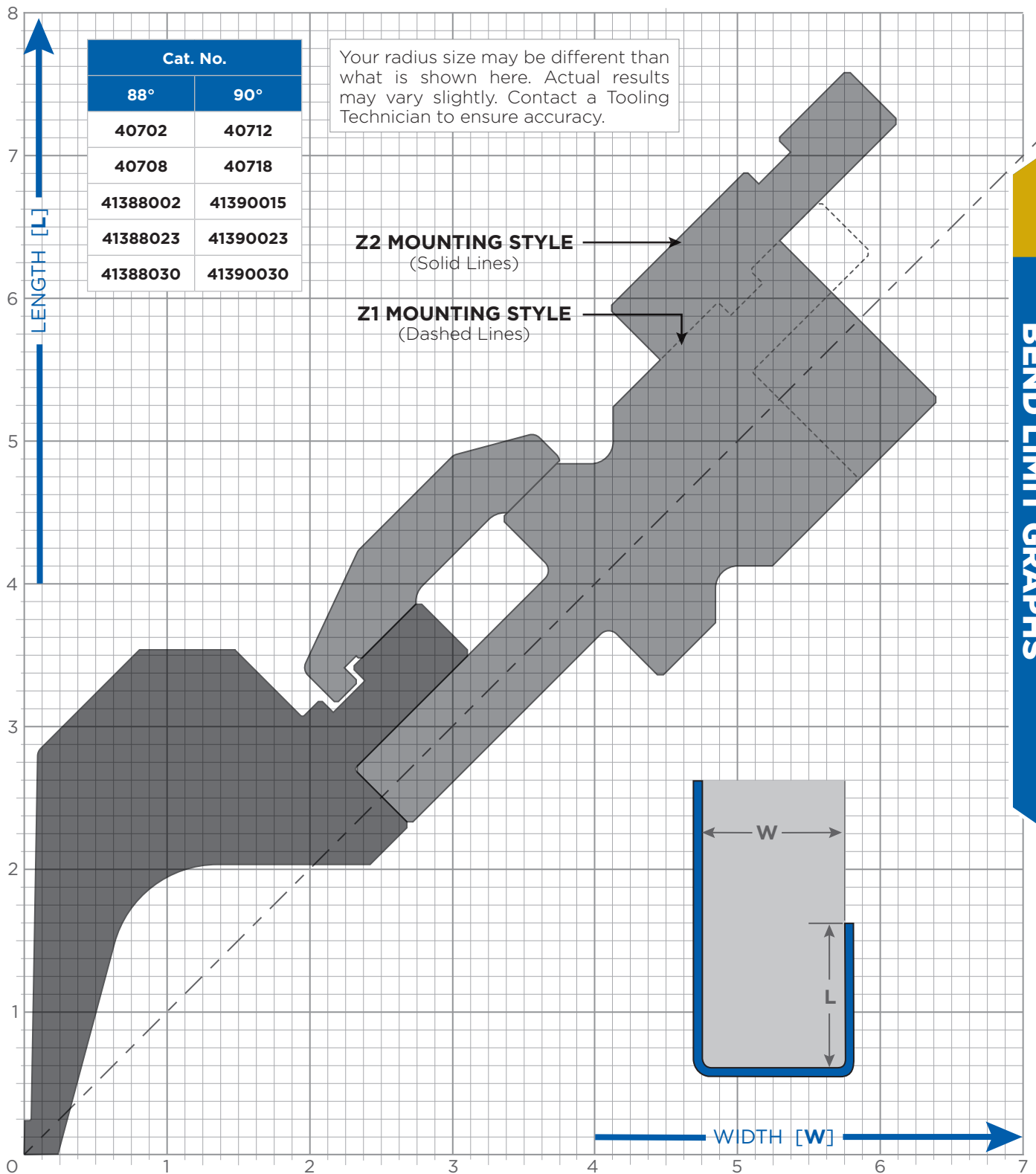
## 88° & 90°

BEND LIMIT GRAPHS



# THIN TIP GOOSENECK PUNCH (STAGED)

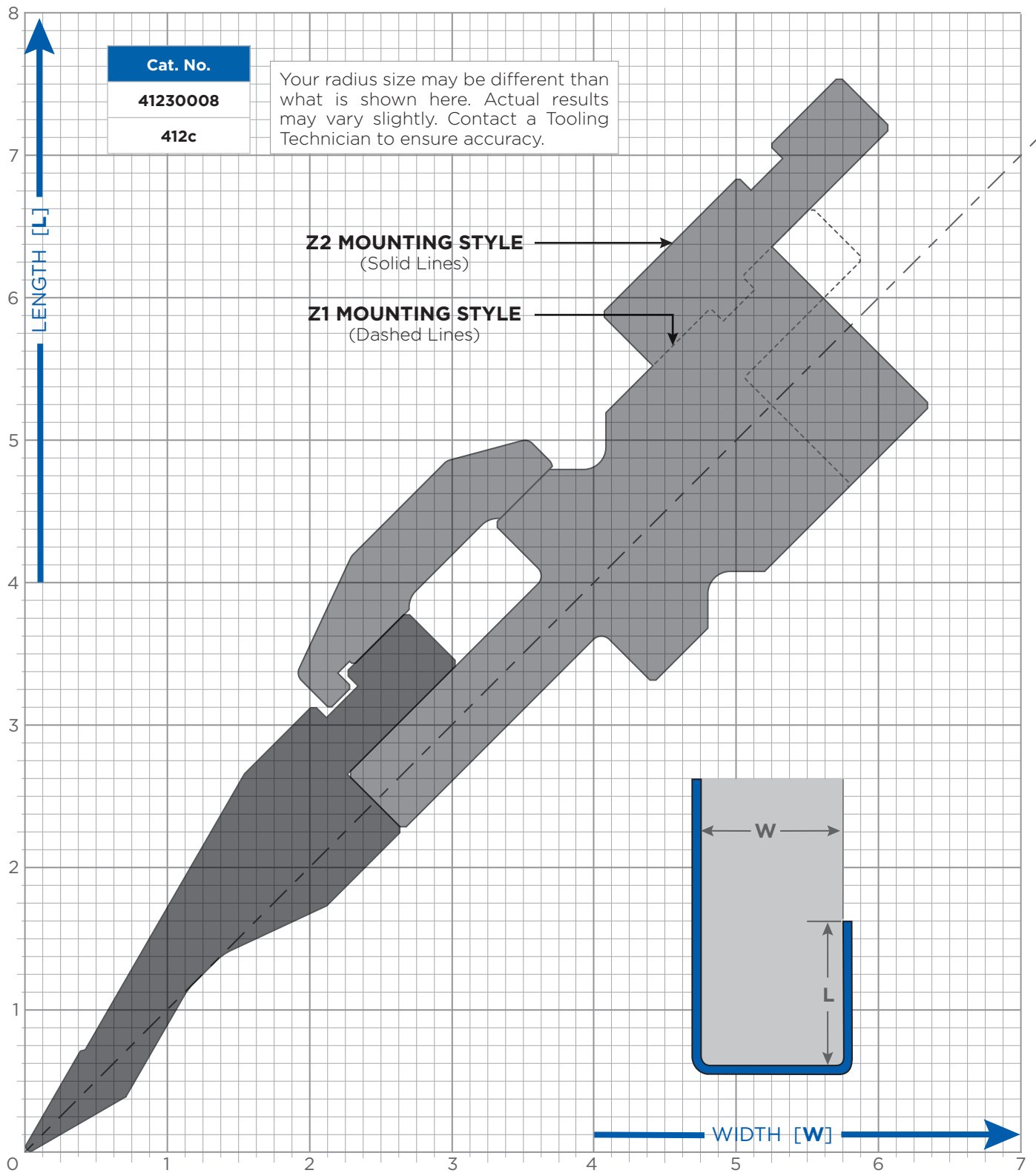
88° & 90°



# ACUTE PUNCH (STAGED)

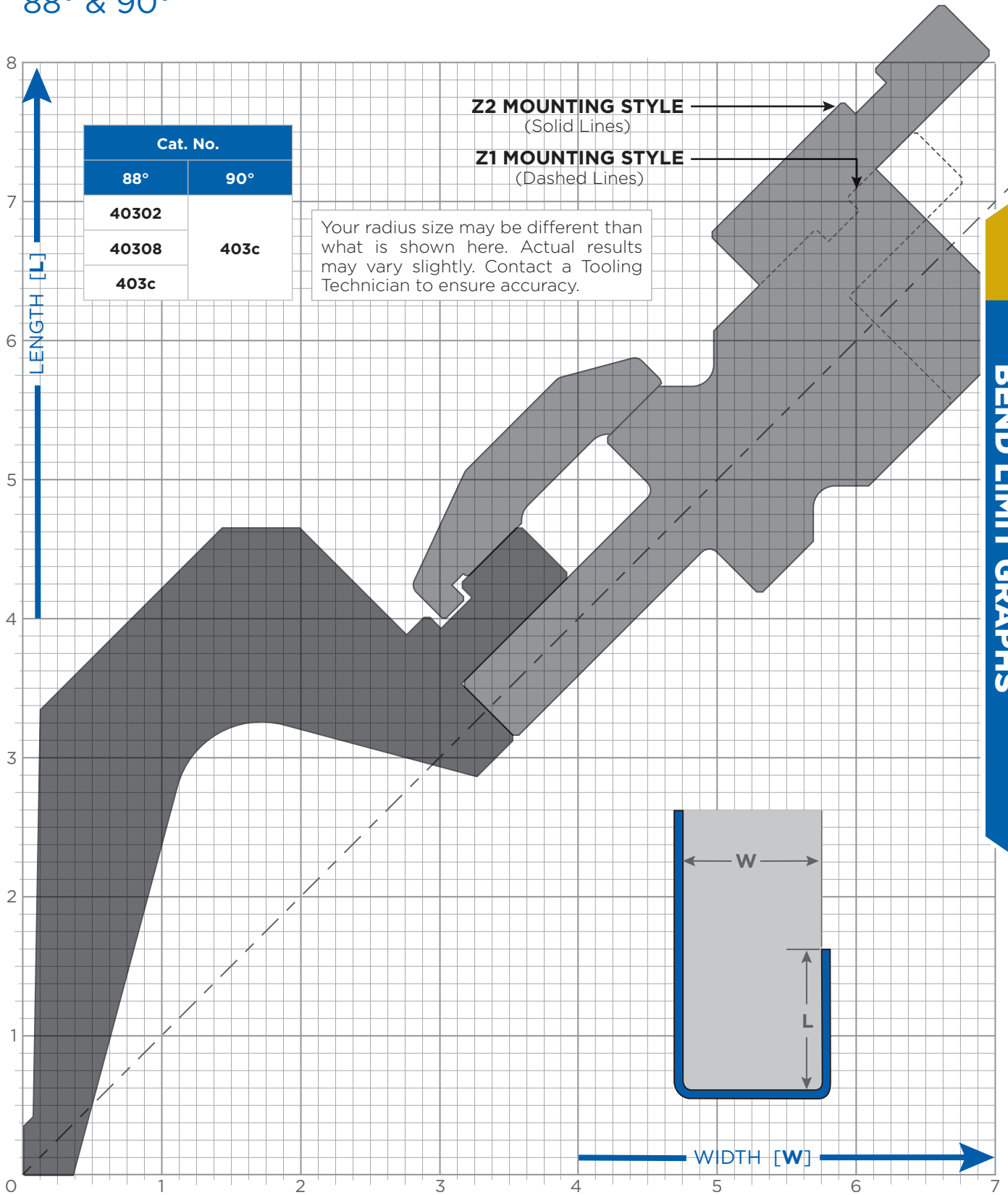
## 30°

BEND LIMIT GRAPHS



# GOOSENECK PUNCH (STAGED)

88° & 90°



Cat. No.	
88°	90°
40302	403c
40308	
403c	

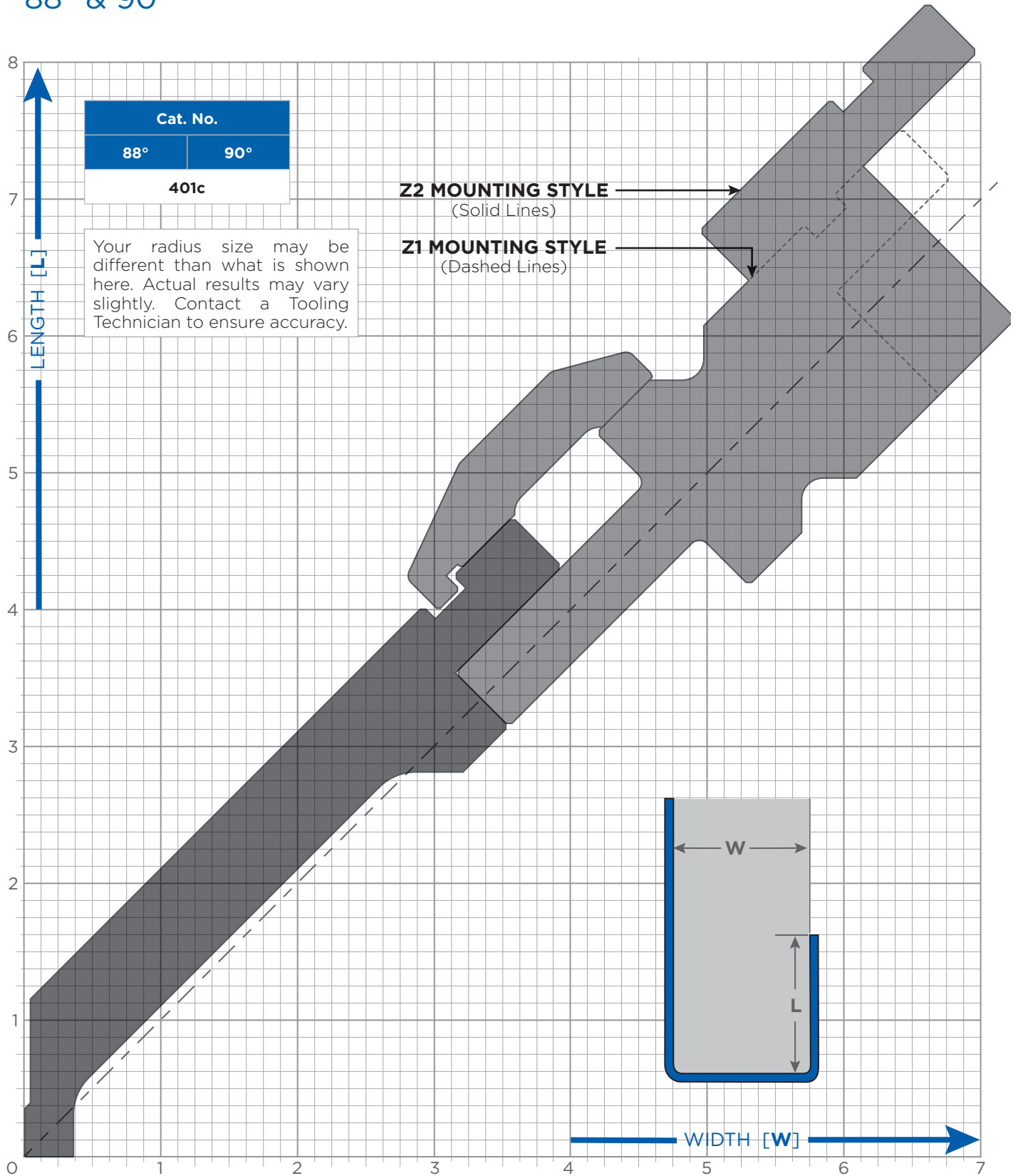
Your radius size may be different than what is shown here. Actual results may vary slightly. Contact a Tooling Technician to ensure accuracy.

BEND LIMIT GRAPHS

# SASH PUNCH (STAGED)

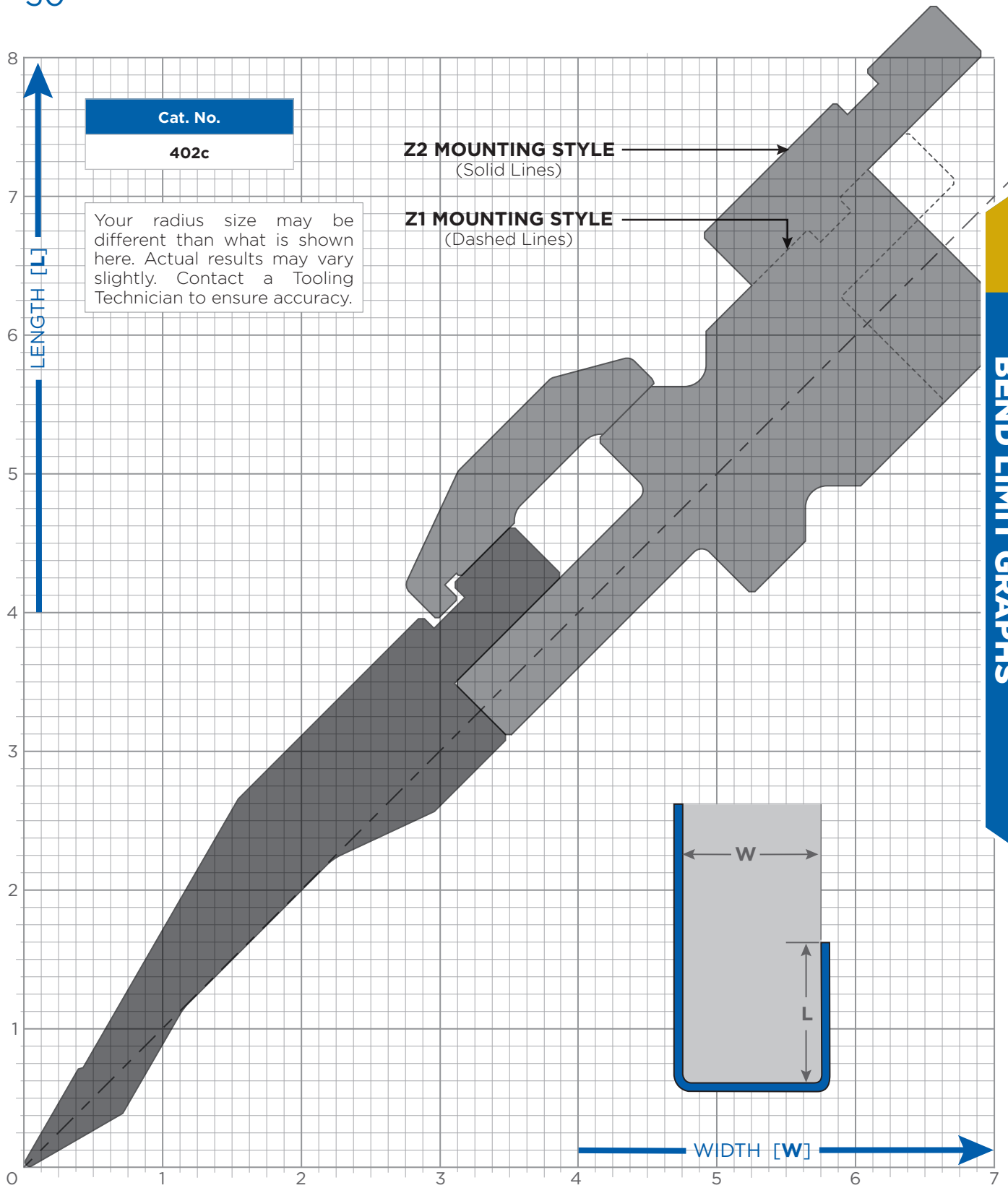
88° & 90°

BEND LIMIT GRAPHS





# ACUTE PUNCH (STAGED) 30°



# SPECIAL TOOLING



## CHALLENGE OUR “NEVER SAY NO” ATTITUDE

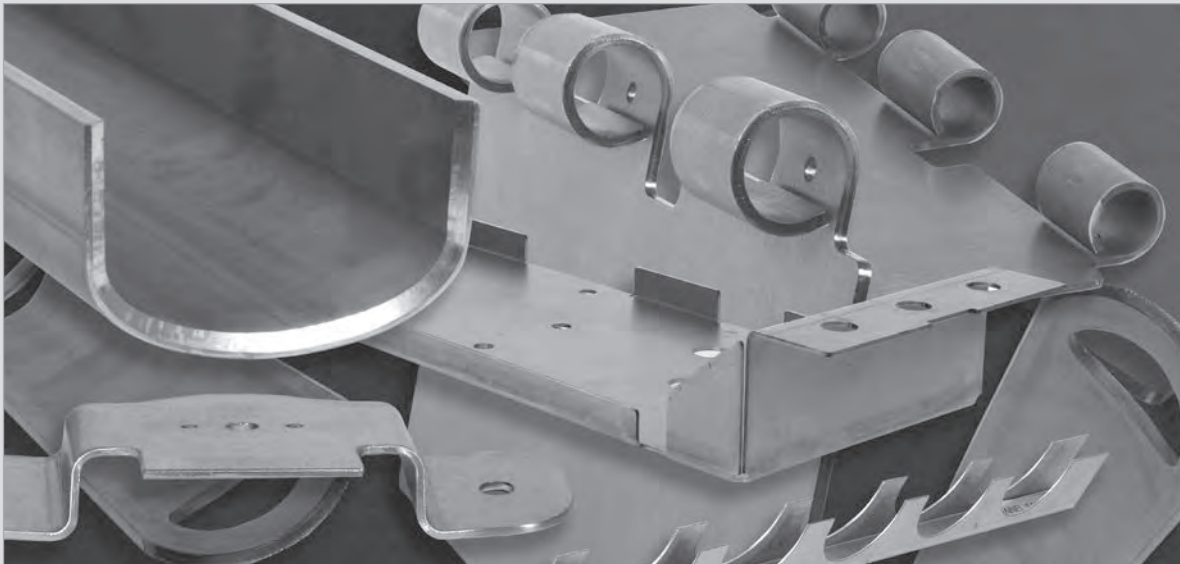
We regularly help customers with their most challenging applications. Our innovative solutions simplify complex bends and make the impossible possible. We are defined by our “never say no” attitude. Bring us your most complex problem and we will work with you until we’ve found an effective solution.

### Quality Materials — Quality Control

We combine premium materials with specialized manufacturing systems to produce extraordinary products that outlast the competition.

### Quick Quotes — Short Lead Times

With the fastest lead times in the industry, our tool might ship before the competition even provides a quote.



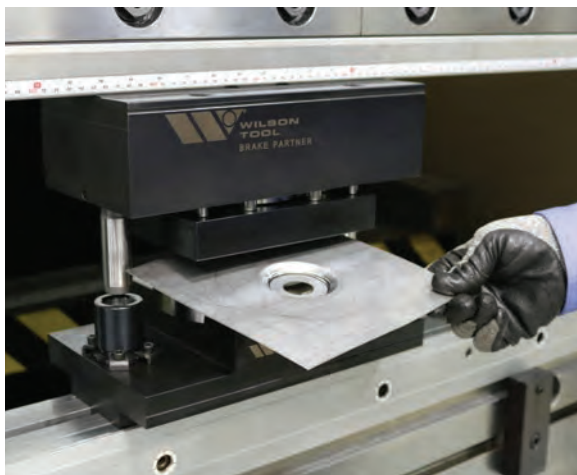
## BRAKE PARTNER®

### Make Punch Press Forms in the Press Brake

Brake Partner® from Wilson Tool International lets shops use new or existing punch press tooling to make forms in the press brake.

For fabricators who have migrated away from punch presses to laser cutting machines, or for those whose punch presses are running at full capacity, this is an especially helpful solution.

The Brake Partner, manufactured to fit in virtually any press brake, features a pressure-pad system which provides blank-holding and stripping, and can be used with or without guide posts, depending on the application.



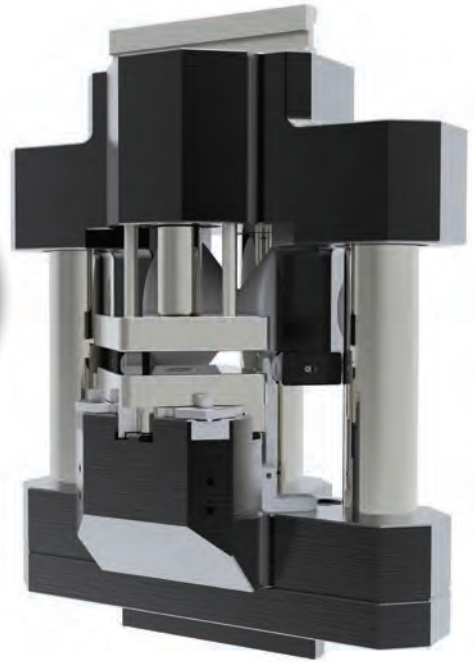
 Watch the video on our YouTube Channel!

### Enjoy These Cost Saving Benefits

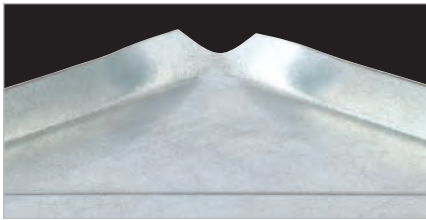
- Use existing punch press tooling
- Reduce press brake special tooling costs
- Punch press tooling has shorter lead times
- Put your existing press brakes to work on applications that were previously impossible on a punching machine
- Reduce outsourcing of punching applications
- Streamline equipment usage and create more flexibility in your shop

## CORNER FORMER

To make a four sided tray or door, the sides would traditionally be folded, the corners welded and the joint ground, to produce an acceptable finish. This process is time consuming, costly and requires a certain skill set. The Corner Former from Wilson Tool International allows you to use your existing press brake to bend up the corners, form the corners and then crop the edges to leave a clean, finished look without the need for welding, grinding and finishing.



### 3 SIMPLE STEPS TO A FINISHED CORNER



#### Step 1: Bend with Flare

All four corners are bent like any other part except your standard die will have an engineered relief to achieve an intentionally flared bend at the ends.



#### Step 2: Corner Former

After the engineered flare, the part is moved to the corner forming step to roll the edge. You now have a complete corner with extra material that needs to be trimmed.

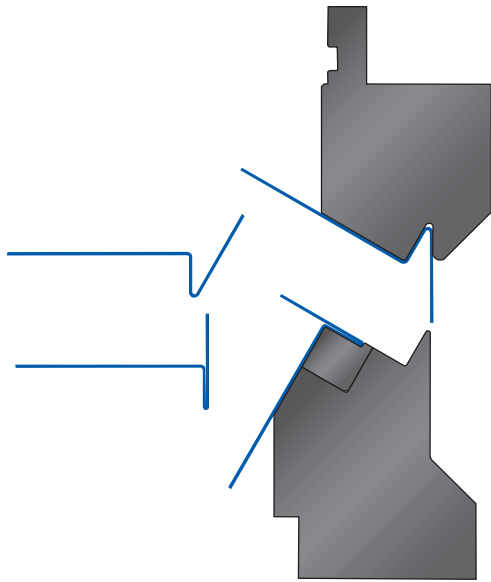


#### Step 3: Corner Cropper/Trim

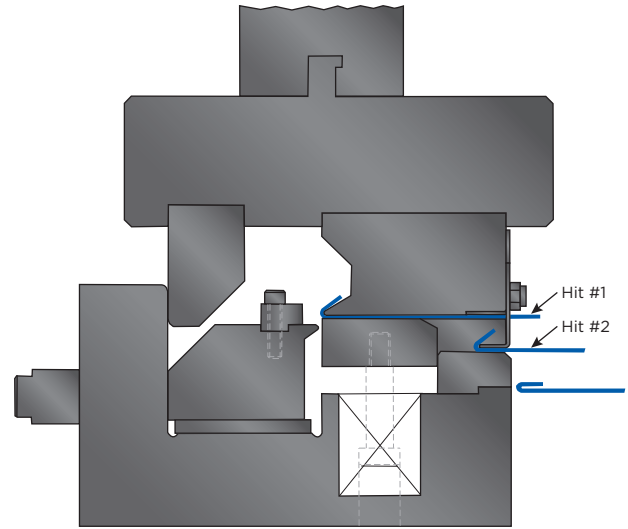
In a quick and simple one-hit action, the corner cropper cuts the extra material flush to the edges of the tray or door. You have now made your part in one handling with little or no additional post processing needed.

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

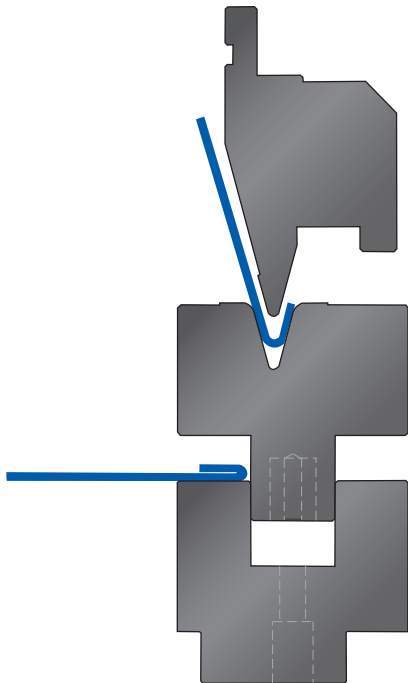
# CUSTOM HEMMING



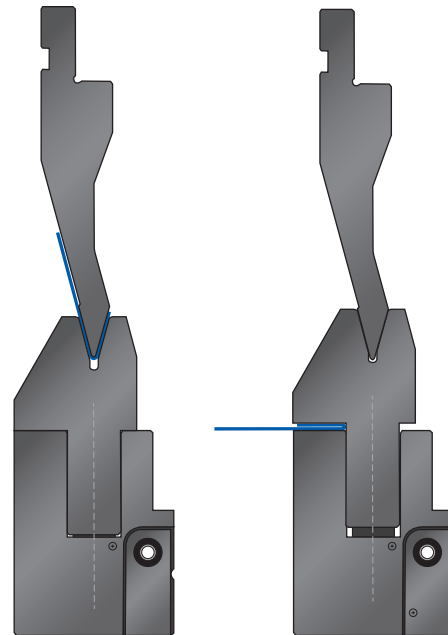
**AH1 — ANGLE HEM**  
Typically used to form seams in excess of 1/2 inch.



**FSH1 — FLAT SHEET HEM**



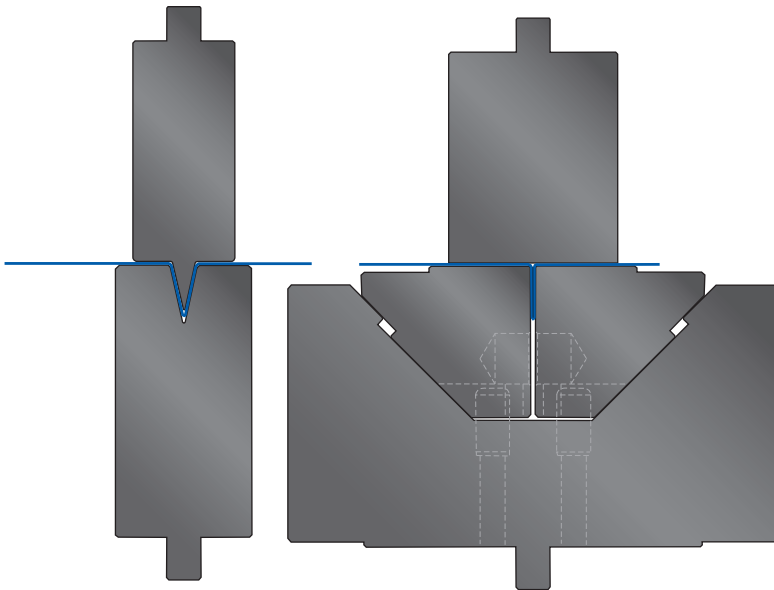
**HDH1 — HEAVY DUTY HEM**  
Heavy duty hemming for thick gauge applications.



**PH1 — PNEUMATIC HEM**  
This tool set introduces pneumatic cylinders to rapidly open and close the pre-form insert. This set removes the inconsistency associated with pre-forming or acute bending on a spring actuated insert.

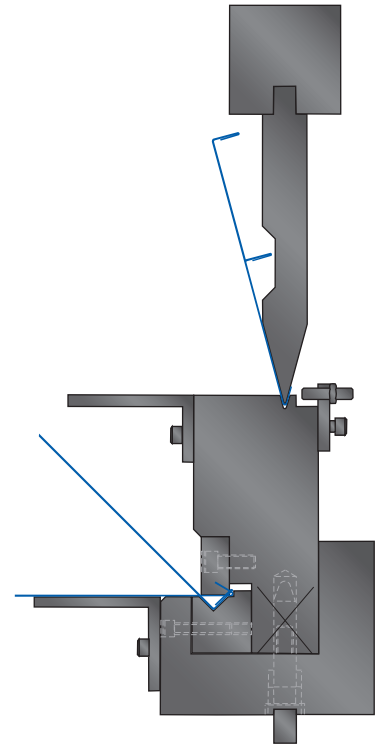
**SPECIALS**

## CUSTOM HEMMING

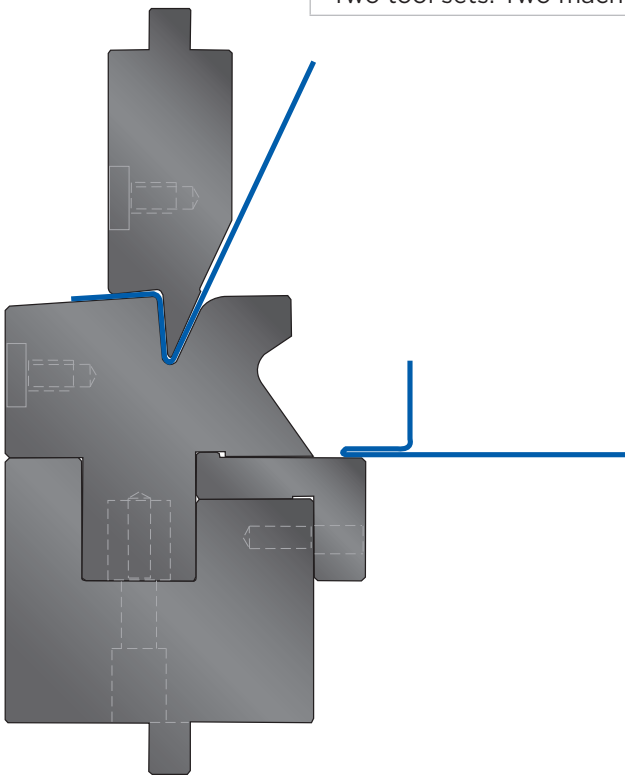


### SH1 — SEAM HEM

Two tool sets. Two machine strokes.

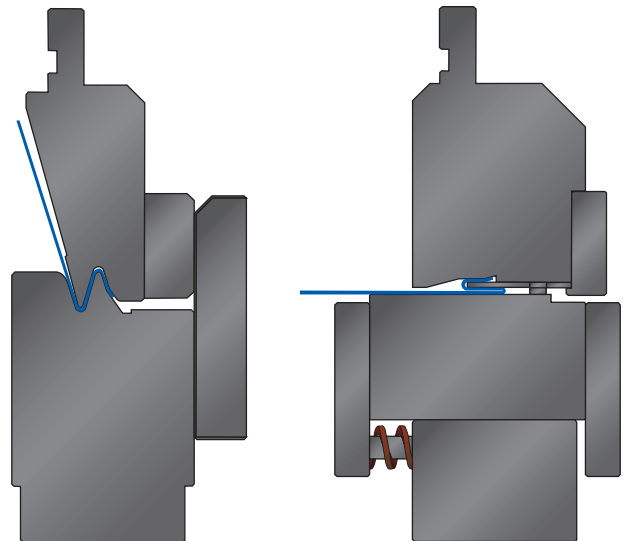


### SSH2 — STANDING SEAM HEM



### SSH1 — STANDING SEAM HEM

Used to form a standing seam in two strokes. The first stroke forms an acute angle offset, the second stroke closes the seam.

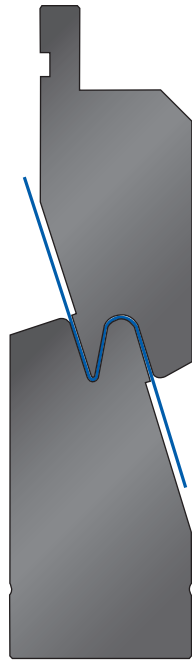


### ZH1 — Z HEM

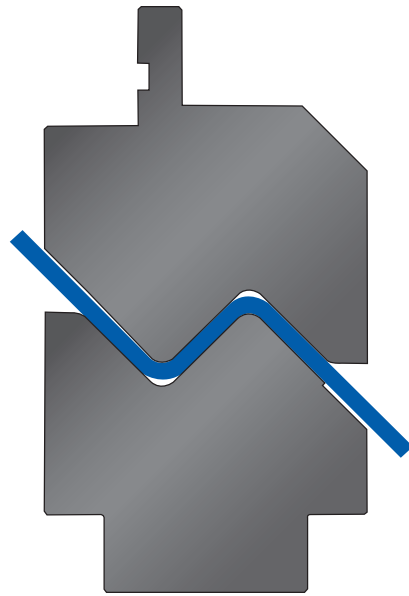
Creates a Z-hem or a Clip hem. Shim can be built in to maintain a gap in the hem. Two tool sets. Two machine strokes.

# OFFSET TOOLS

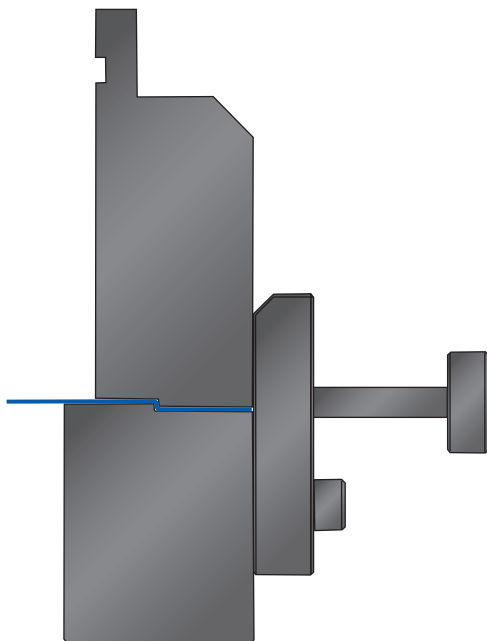
 Watch the video on our YouTube Channel!



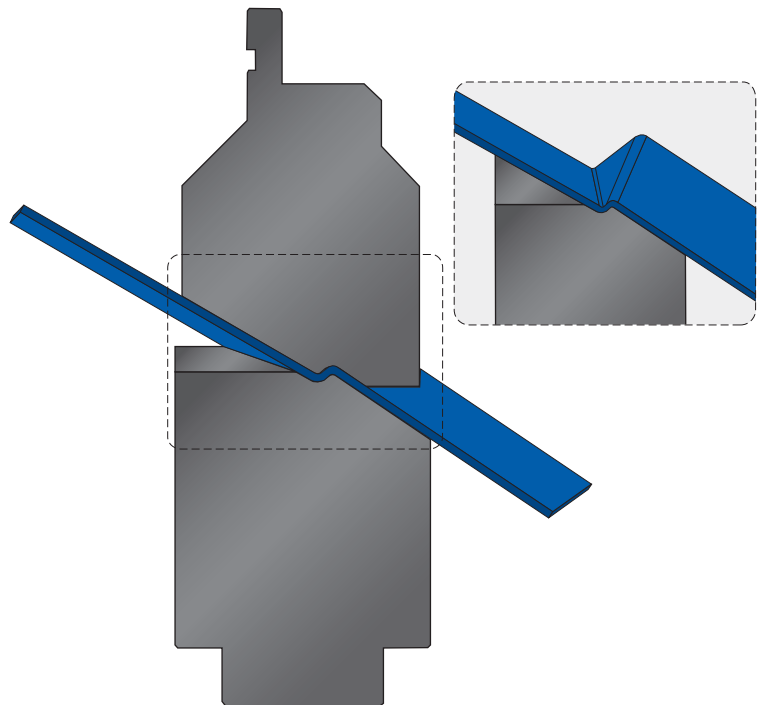
**AO1 – ANGLED OFFSET**



**LO1 – LARGE OFFSET**  
Used for heavy gauge, large offset bending.



**HO1 – HORIZONTAL OFFSET**  
For offsets that are approximately one material thickness. Prevents material whip up. Thrust plates and adjustable back gauging are provided.



**NPO1 – NON PARALLEL OFFSET**  
For offsets that have non-parallel flanges. Inset shows punch hidden for a clear view of the formed sheet.

**SPECIALS**



## ADJUSTABLE DIES

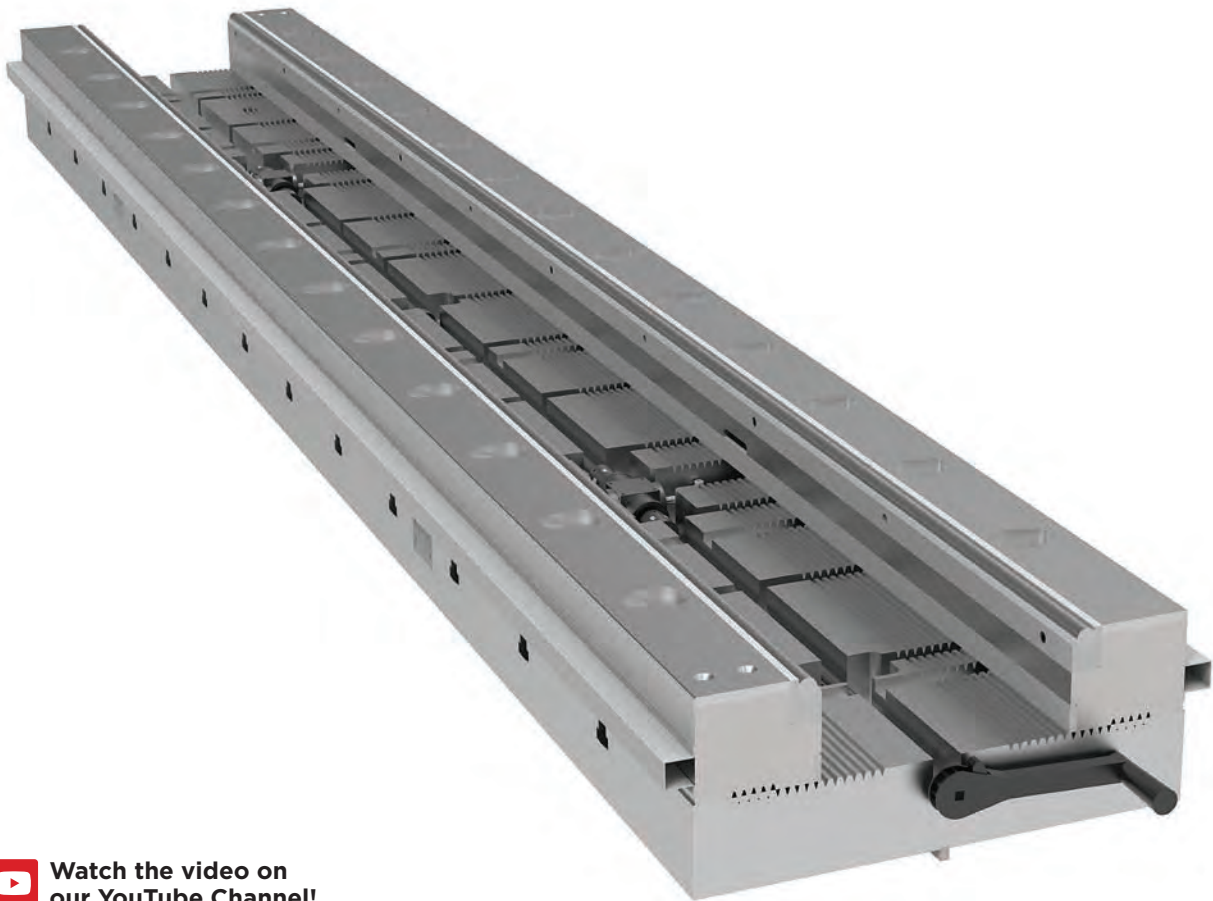
Adjustable dies are a great solution when bending thick materials and you need the flexibility to adjust the width of the V opening. Instead of buying several dies, adjustable dies enable you to alter the width, rather than changing out the die.

### Adjustable Die Features

- Riding on spring-loaded ball bearings, openings are easily adjusted by one operator
- Available openings range from 1 to 24 inches and can be adjusted in 1-inch increments
- Capable of withstanding tonnage of up to 200 tons per foot, allowing easy thick material bending
- Induction hardened and hard chrome rollers help reduce required tonnage by as much as 20%
- Chrome rollers can be replaced at your facility

### Adjustable Die Options

- Die assembly can be configured to remain on the press permanently and function as a standard die holder
- Cover bellows are available to keep the grooves that are used to adjust the dies free from dirt and dust
- Available clamping options for side blocks include manual and automated release and/or movement
- Available with Manual, Ball Screw, Hydraulic and CNC options



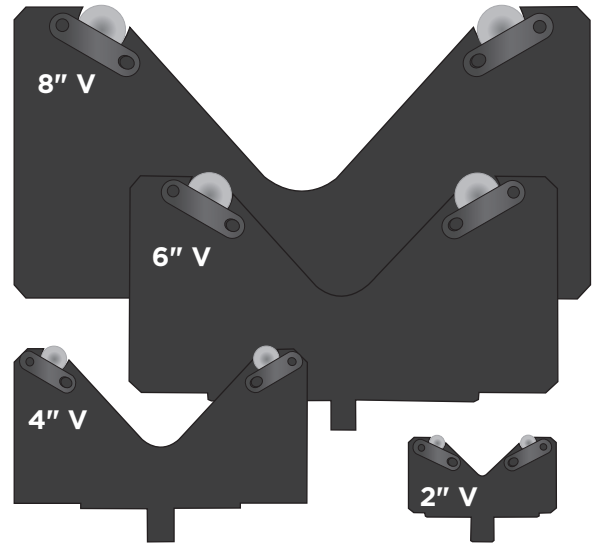
 Watch the video on  
our YouTube Channel!



## REPLACEABLE SHOULDER DIES

Dies that have a replaceable shoulder radius are ideal for extreme wear conditions like heavy plate and abrasive materials. Replacing the shoulder insert saves on replacement cost.

Since the radius is able to rotate during bending, friction and tonnage are reduced, resulting in reduced part marking and less tonnage on tooling and machinery.



## DOVETAIL HOLDER AND RADIUS

### Lighten Your Load with Two-Piece Punches

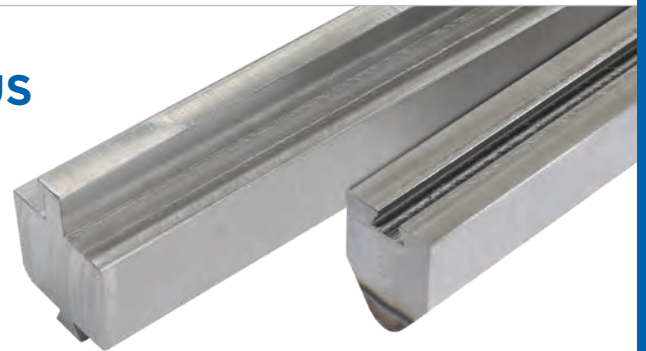
Replaceable radius punches help limit tooling costs, reduce setup time and lighten tool changes. Tip inserts simply slide on and off the universal punch body, increasing the flexibility of each punch and minimizing heavy lifting for the operator.

### Replaceable Radius Punch Highlights

- Setup is as simple as sliding the tip insert on and off the tool body
- No adjustment is required between punch radius changes
- Tip is lighter than a standard punch for easier tool changes
- Lighter tools reduces need for multiple operators
- Lighter tools creates a safer handling environment for operators
- Tool costs are minimized when purchasing one body with multiple tips
- Various angles and radii can be loaded into the same punch holder

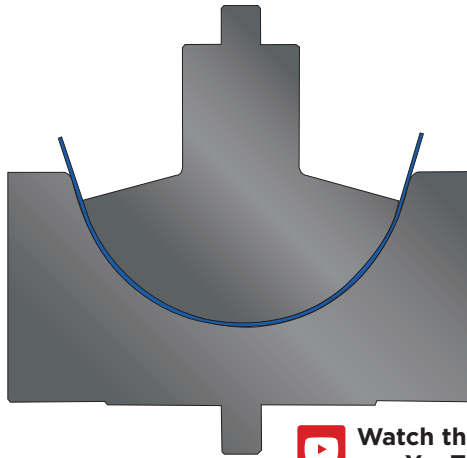
### Details

- Made to suit specific needs
- Designed to tackle light or heavy-duty bending
- Ground and induction hardened for optimal life and performance
- Dovetail or “T” style attachment feature



 Watch the video on our YouTube Channel!

## LARGE RADII

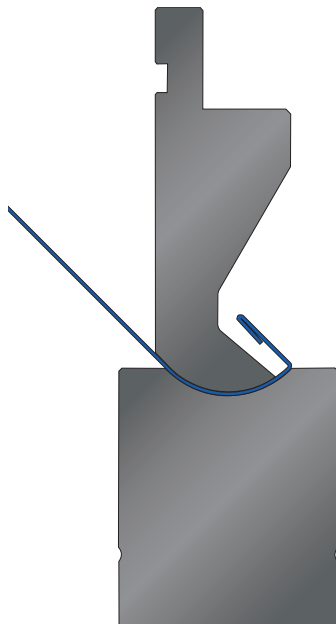


 Watch the video on our YouTube Channel!

### LR1 – LARGE RADIUS

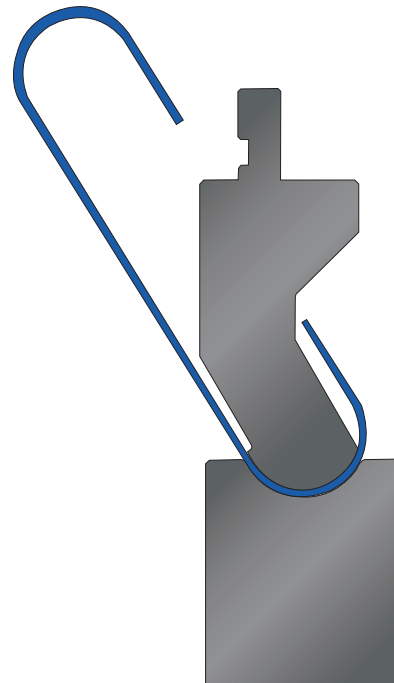
Bottoming radius set with spring-back allowance built in. It is manufactured to form a radius in a specific type and thickness of material for tight tolerance requirements.

SPECIALS



### LR2 – MULTI-HIT RADIUS

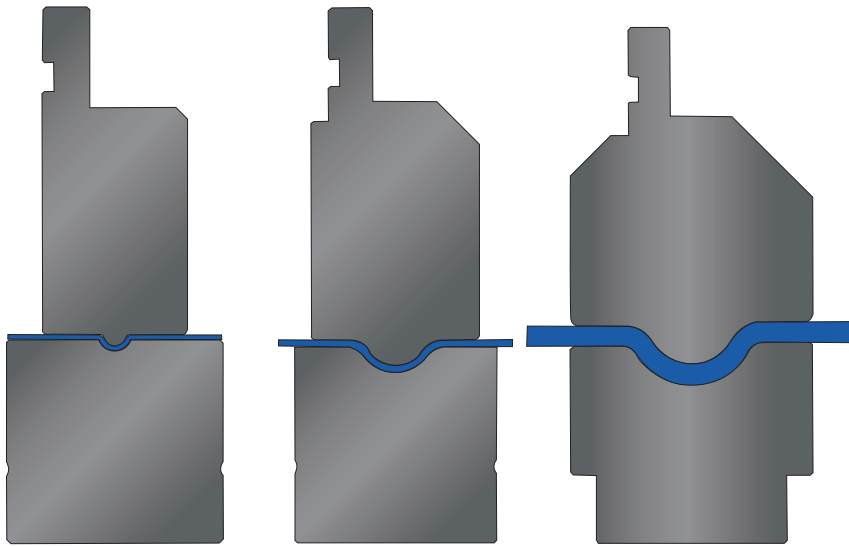
Used when a full radius is required before the flange. The solution may require multiple strokes.



### LR3 – MULTI-HIT RADIUS

Used when the return flange starts at the radius end. The solution may require multiple strokes.

## STRENGTHENING RIB

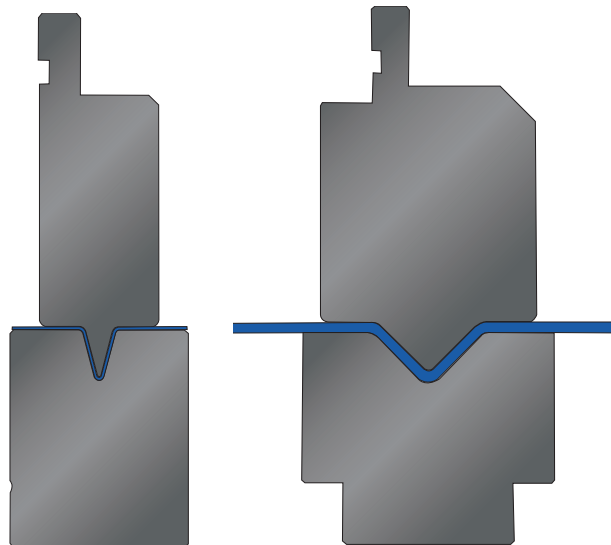


### SR1 — STRENGTHENING RIB

Produce a strengthening rib in one stroke. Spring back allowance is built in. Closed end and open end ribs are available.

 Watch the video on our YouTube Channel!

## V-RIB

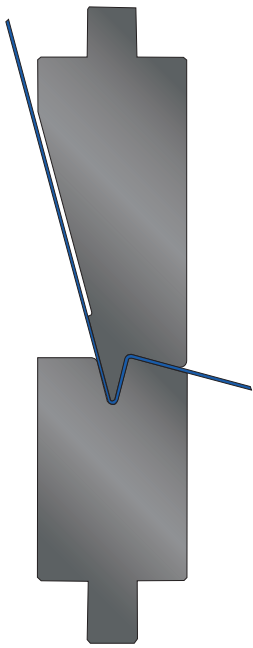


### VR1 — V RIB

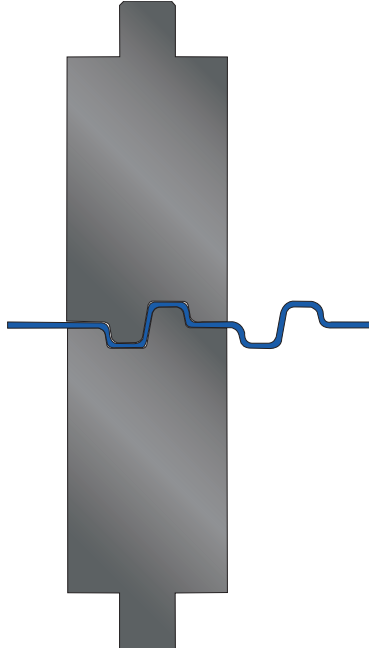
Produce a V rib in one stroke. Spring back allowance is built in.

# FORMING

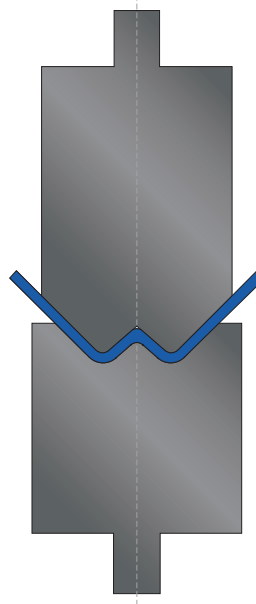
SPECIALS



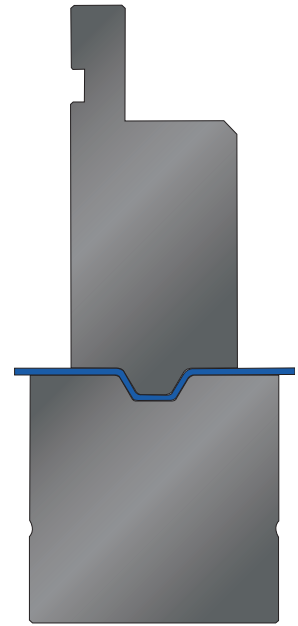
**FM1 — FORMING**



**FM2 — FORMING**

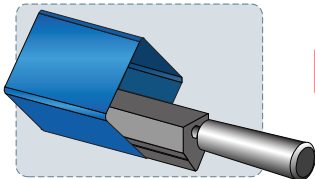
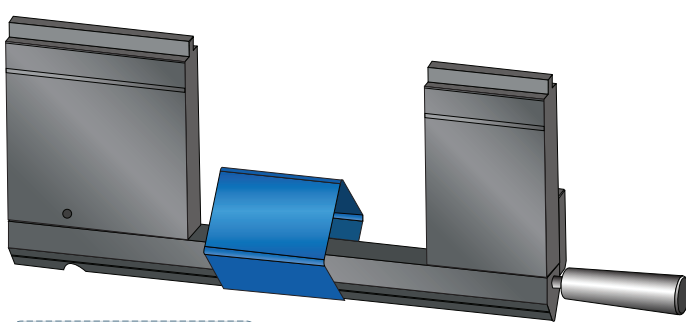


**FM3 — FORMING**



**OH1 — OPEN HAT**

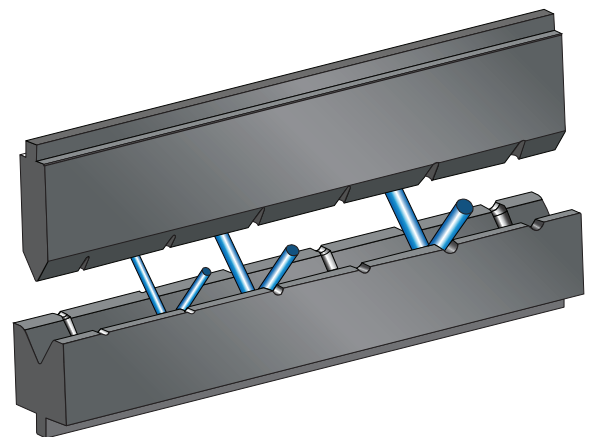
A large variety of custom forming sets are available. Custom built to suit any specific requirement. Call for specific application requirements.



Watch the video on our YouTube Channel!

**W1 — WINDOW**

Used when minimum return flange clearance is required.



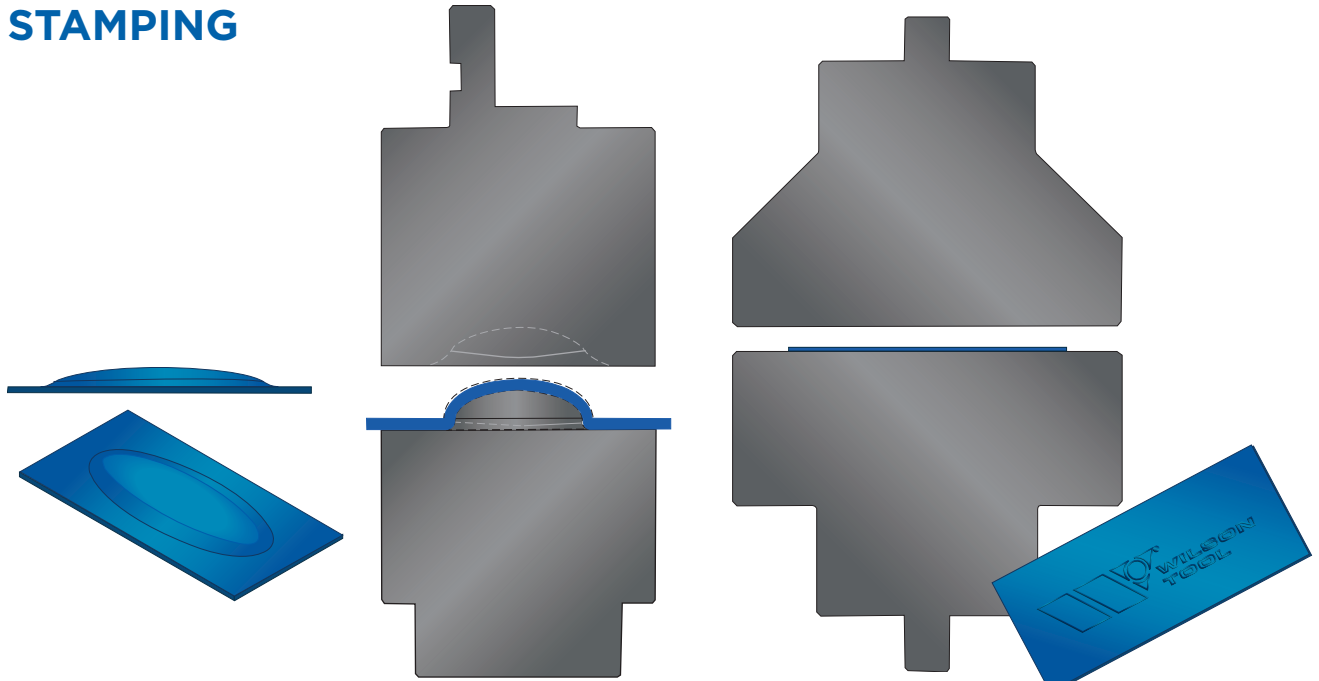
Watch the video on our YouTube Channel!

**RB1 — ROD BENDING**

Provides nesting for the rod during the forming process.



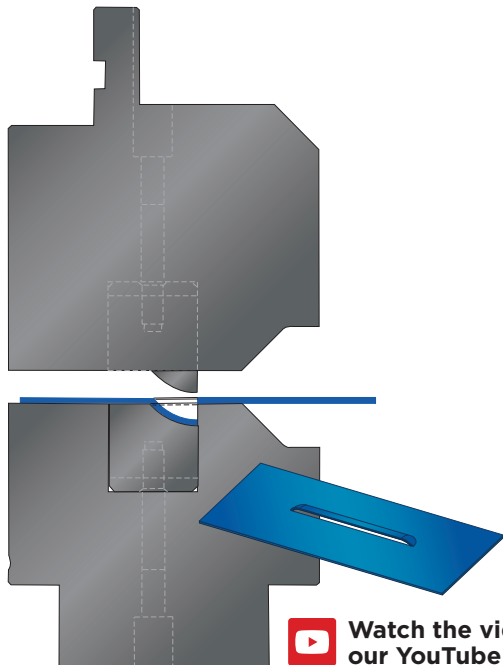
# STAMPING



## EM1 – EMBOSS

A variety of raised emboss and chisel point emboss sets are available.

## LG1 – LOGO



## LL1 – LOUVER

Multiple louver configurations are available. For louver forming, sheet must be pre-slit.

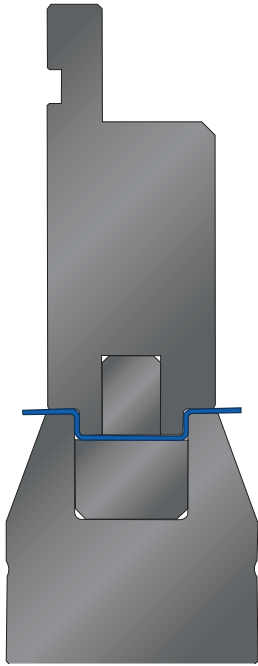


## LS1 – LETTERSTAMP

Provides chisel point embossing with interchangeable characters. Single row or multi-row available.

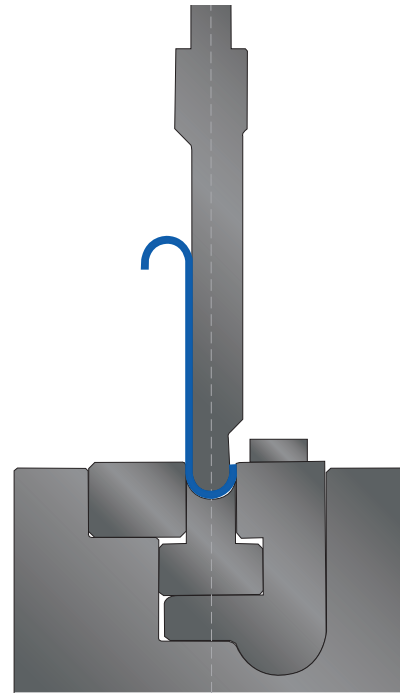
Cat. No.	Description	Size	Price
6LSP25	Punch Character Holder	—	
65300003-500	Flattening Block Die	—	
6898	Character	3/32"	
6896	Character	1/8"	

## MECHANICAL



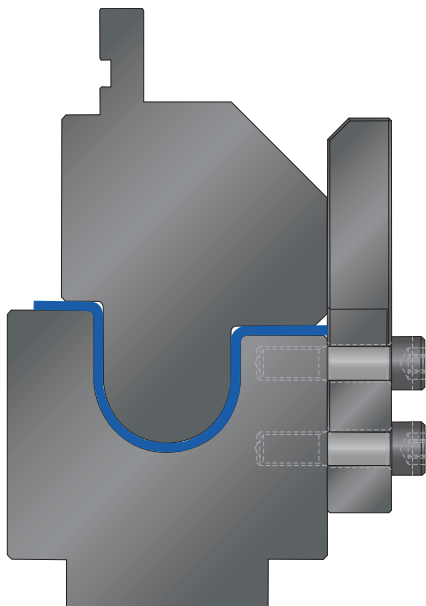
### HT1 — HAT CHANNEL

Provides straight wall or angled wall hat channel bending in one stroke. Spring back allowance built in.



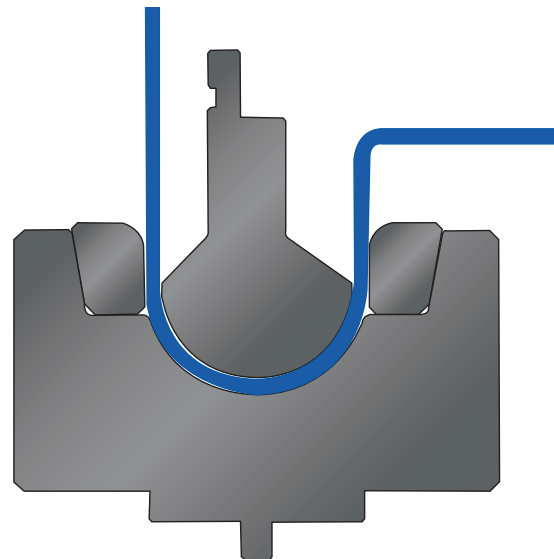
### UC1 — U CHANNEL

Recommended for applications where considerable spring back is encountered. Secondary flattening operations may be required.



### UC2 — U CHANNEL

Recommended for applications where considerable spring back is encountered. Secondary flattening operations may be required.

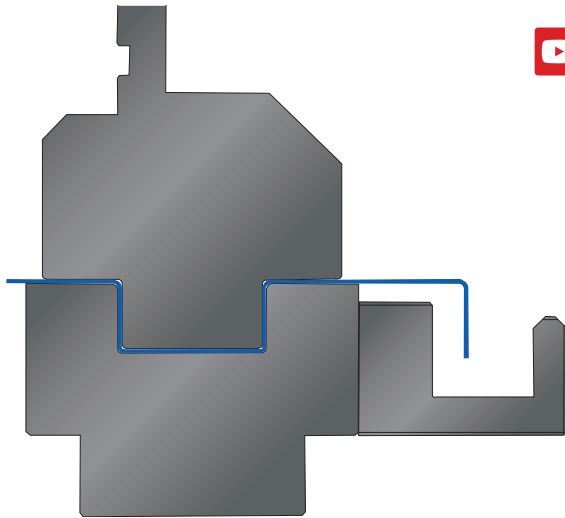


### UC3 — U CHANNEL

Recommended for applications where considerable spring back is encountered. Secondary flattening operations may be required.

# MECHANICAL

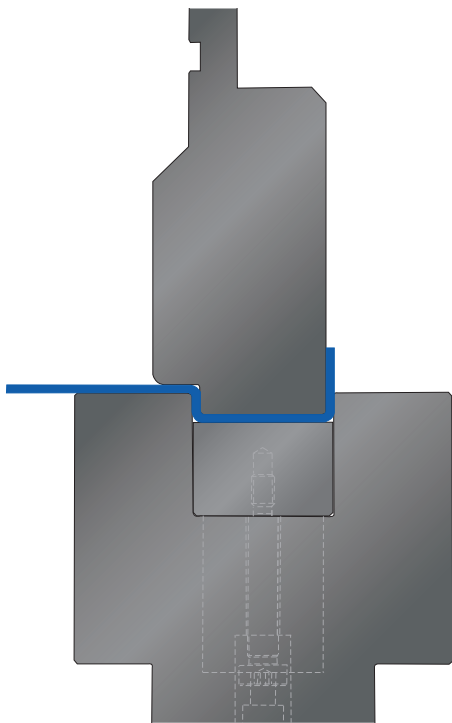
Watch the video on our YouTube Channel!



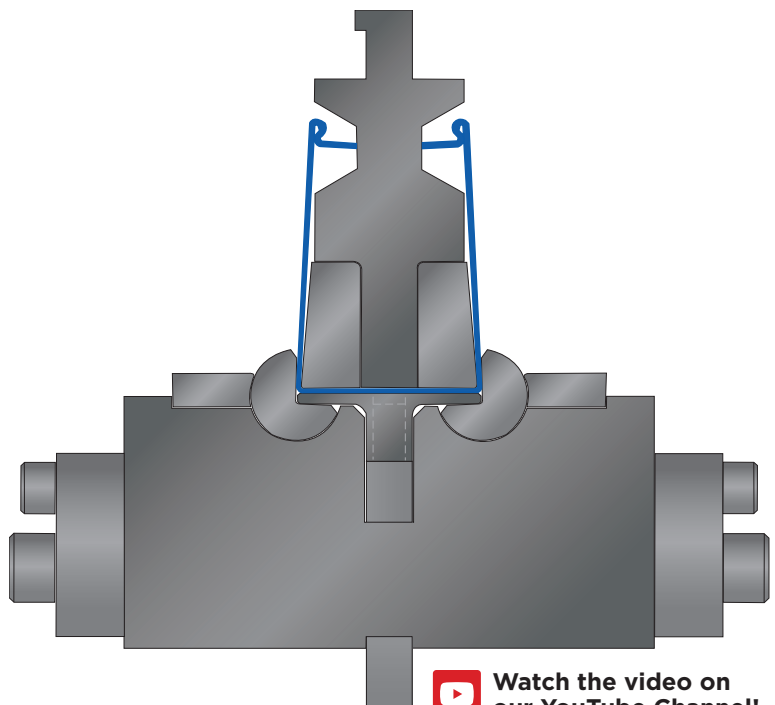
**C1 – CHANNEL**  
For deep channels when the channel bottom needs to remain flat.



**C2 – CHANNEL**  
For deep channels when the channel bottom needs to remain flat.



**C3 – CHANNEL**  
For deep channels when the channel bottom needs to remain flat.

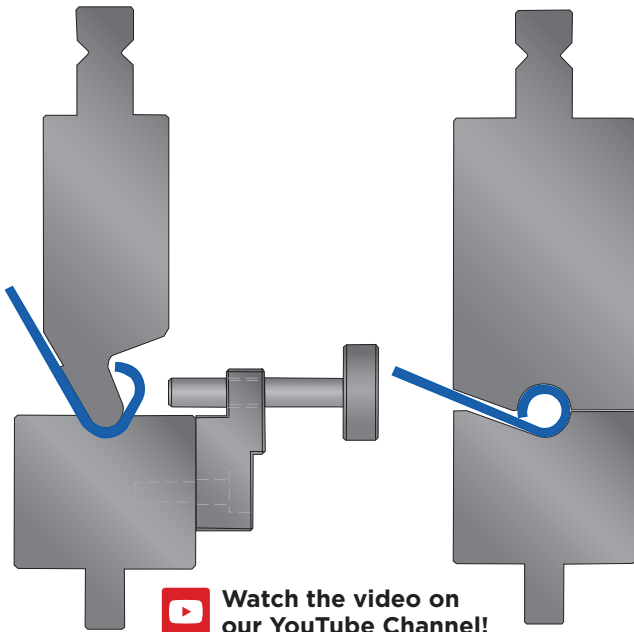


Watch the video on our YouTube Channel!

**C4 – ROTARY BEND CHANNEL**  
For deep channels when the channel bottom needs to remain flat.

**SPECIALS**

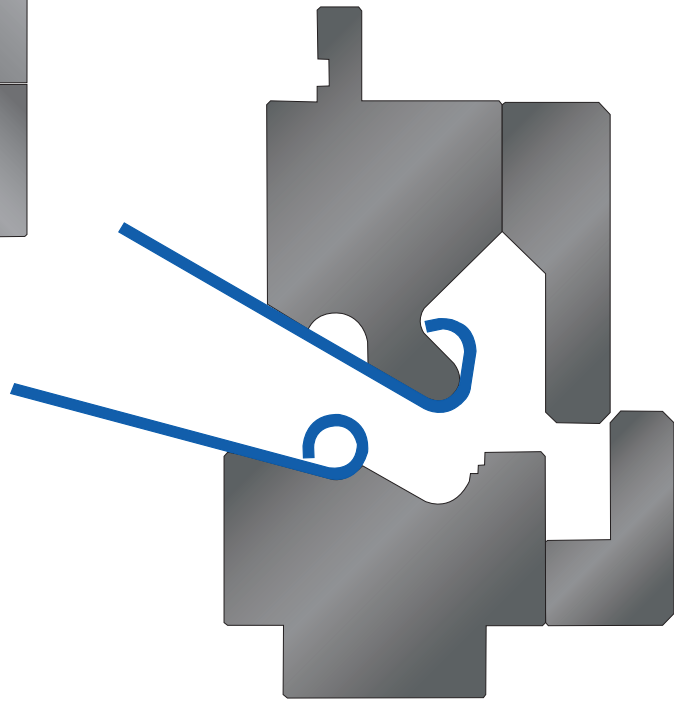
## MECHANICAL



 Watch the video on our YouTube Channel!

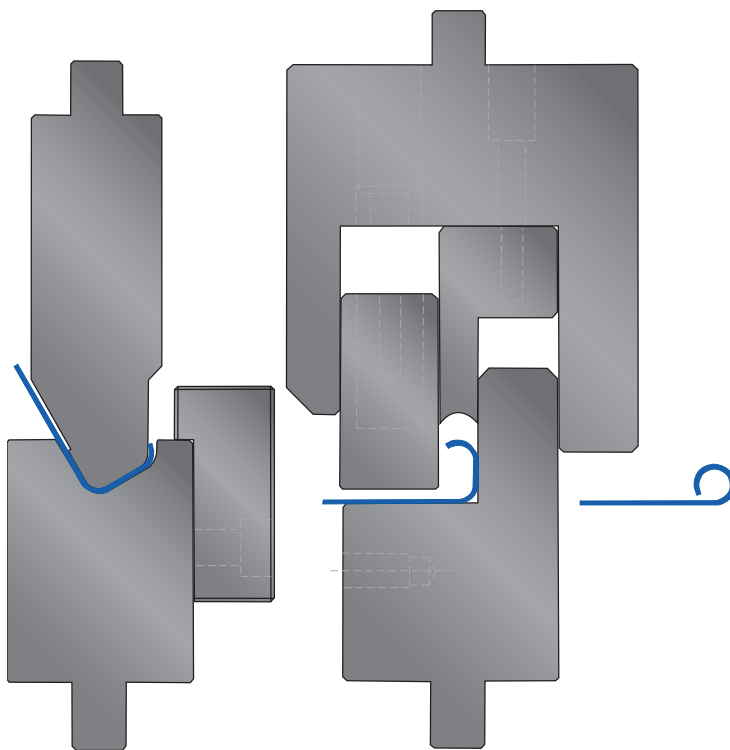
### CL1 – CURL TOOL SET

Two tool sets, three machine strokes.



### CL2 – CURL TOOL SET

Typically used for thick materials and large diameter curls.  
One tool set, three machine strokes.

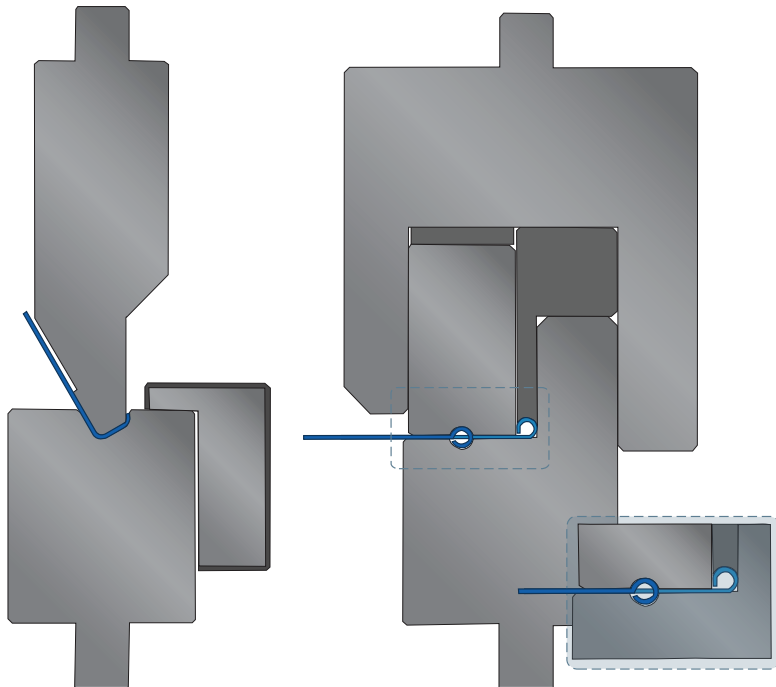


### CL3 – CURL

Used for hinges and corner beading.  
Two tool sets, two machine strokes.

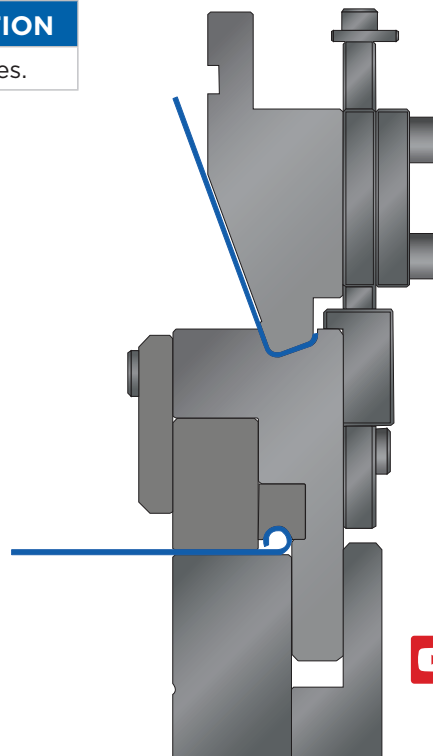


# MECHANICAL



 Watch the video on our YouTube Channel!

**CL4 – CENTER CURL APPLICATION**  
Two tool sets, three machine strokes.

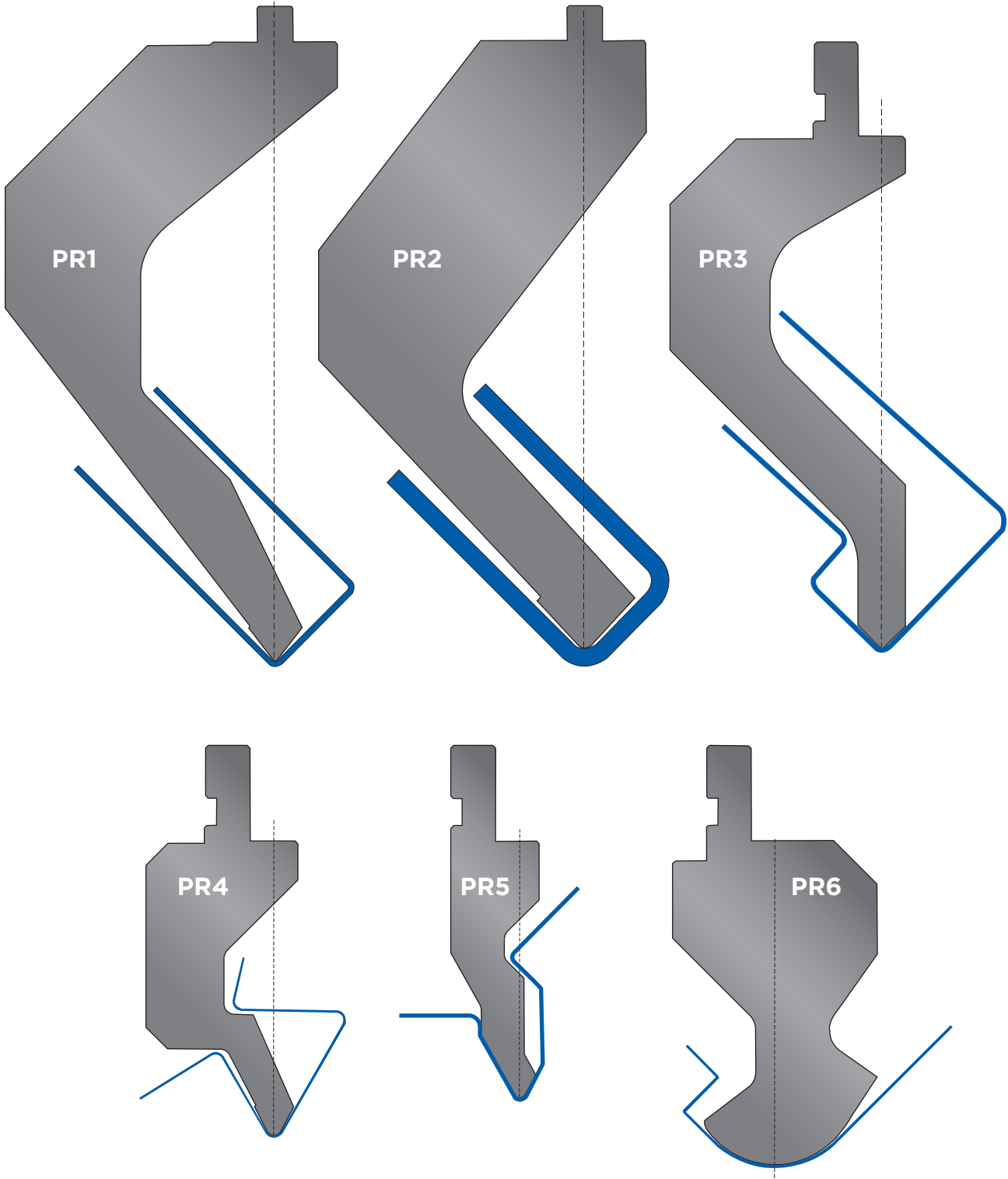


 Watch the video on our YouTube Channel!

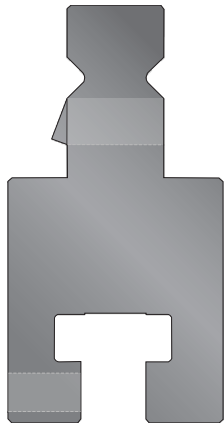
**CL5 DOUBLE DECKER TOOL SET**  
Used for hinges and corner beading.  
One tool set, two machine strokes.

**SPECIALS**

## SPECIAL SHAPE PUNCHES



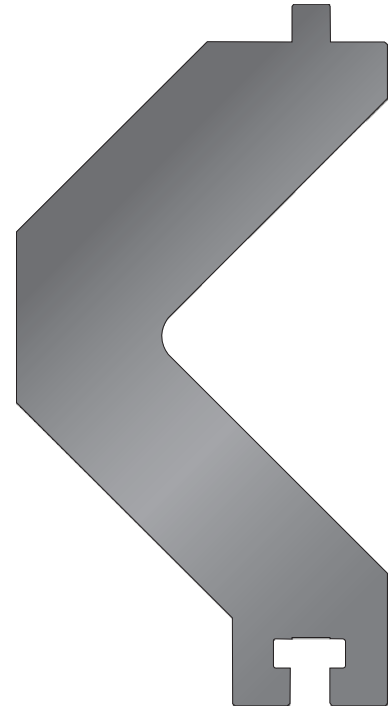
# PUNCH HOLDERS



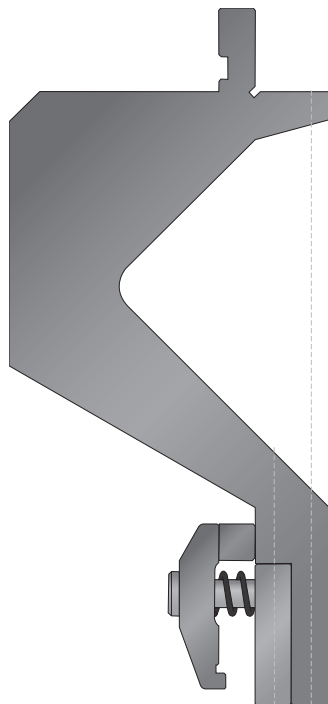
**WT — AMERICAN**



**AMERICAN SELF-SEAT HOLDER**



**AMERICAN DEEP GOOSENECK HOLDER**



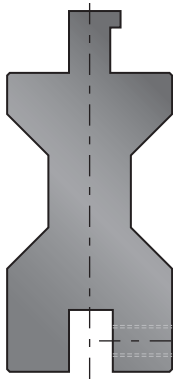
**EURO Z1 OR Z2 CLAMPING**  
Cat. No. 43002

**PUNCH HOLDERS**

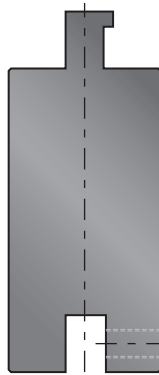
Stack punch holders to make a taller punch to bend tall side flanges or to replace worn OEM punch holders that need replacement. These holders can be made in small sections or one piece to fit the length of your brake.

**SPECIALS**

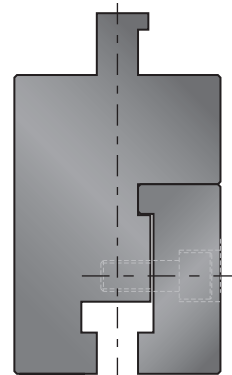
## PUNCH HOLDERS



**RA1 — DOG BONE**



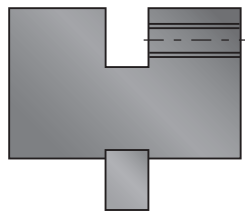
**RA2 — SET SCREW**



**RA3 — CLAMP PLATE**

Holders are commonly made to replace any original OEM punch and/or die holders or to accommodate part configuration. These designs can be one solid length or sections that are easier to handle.

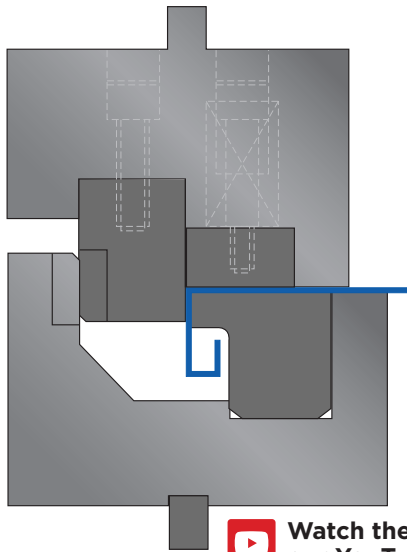
## DIE HOLDERS



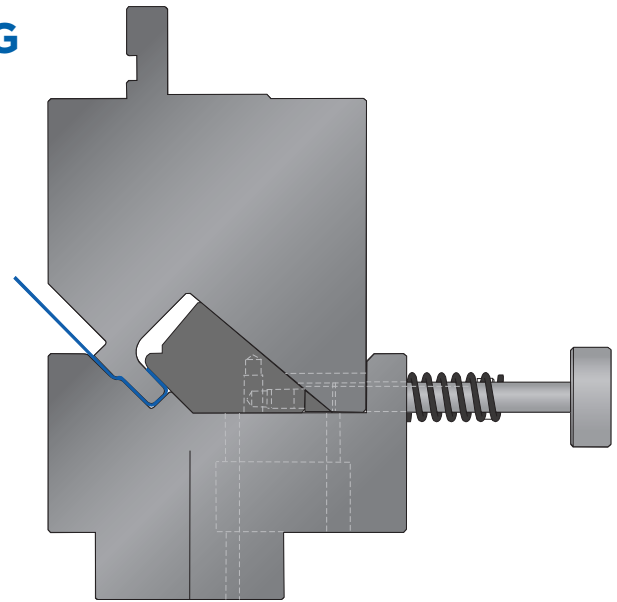
**DIE HOLDERS**

Die holders can raise the die to help with down flange interference or to replace worn OEM die holders that need replacement. These holders can be made in small sections or one piece to fit the length of your brake.

# WIPING AND ROTARY BENDING

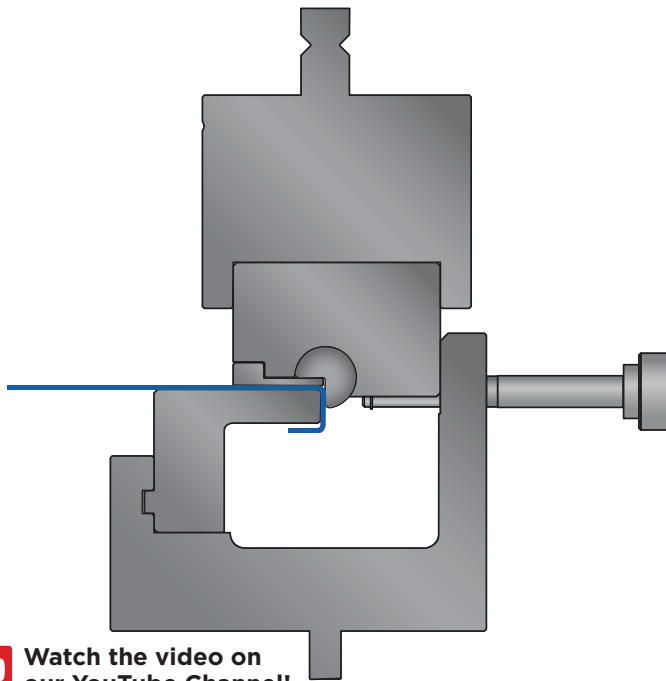


Watch the video on our YouTube Channel!

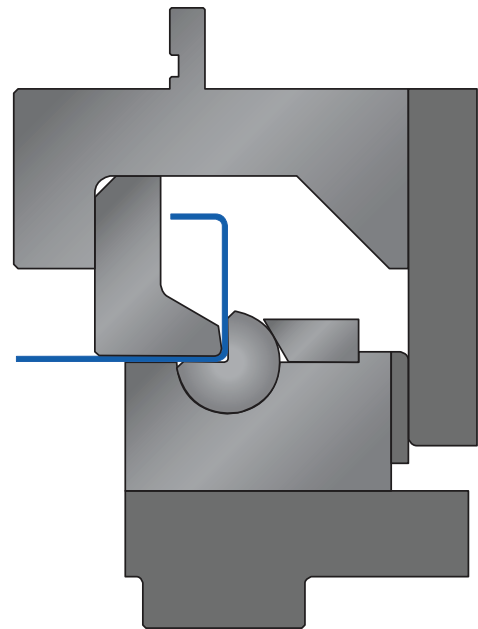


**WD1 – WIPE DOWN**  
 Holds the sheet flat while wiping the flange down. Ideal for large panels and high production.

**WO1 – WIPING FORM**  
 Holds the sheet flat while wiping the flange down. Ideal for large panels and high production.



Watch the video on our YouTube Channel!



Watch the video on our YouTube Channel!

**RTD – FORM DOWN**

**RTU – FORM UP**

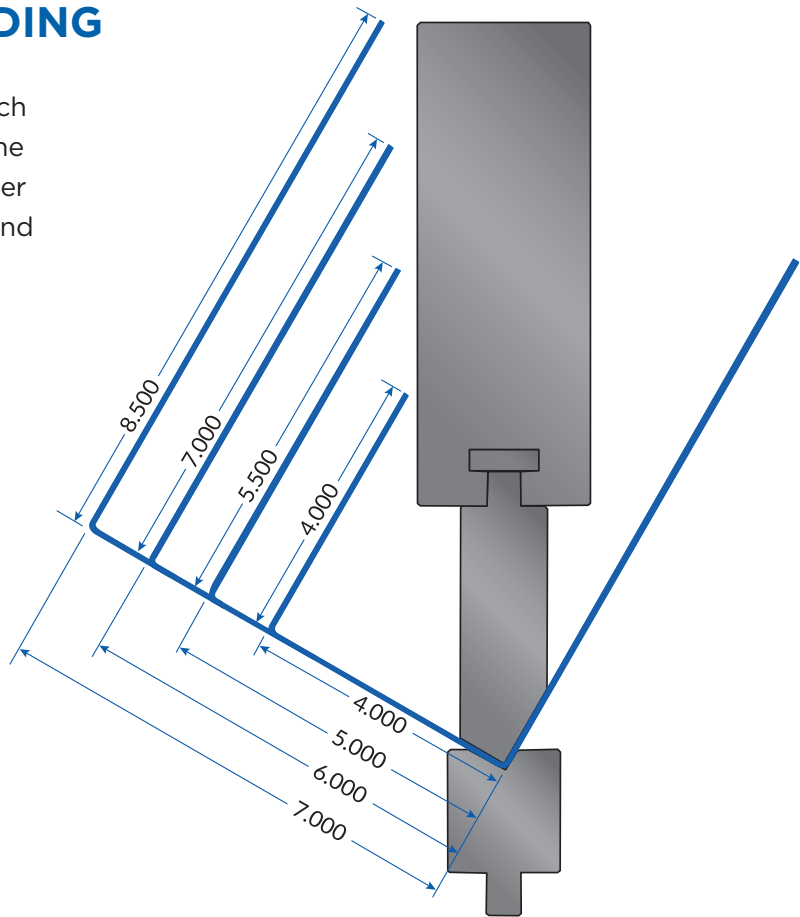
**ROTARY FLANGE FORMING**

Holds sheet flat while forming. Overbend allowance is built in to compensate for material springback. Ideal for large panels and high production.

**SPECIALS**

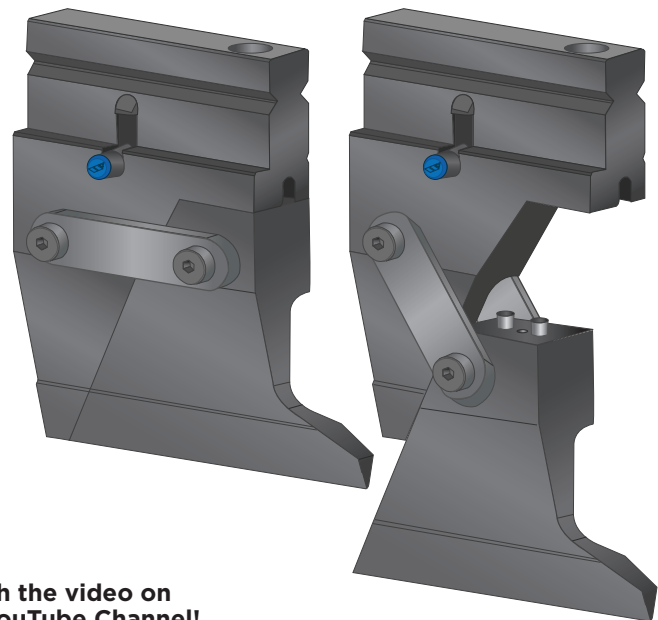
## 30/60 DEEP BOX BENDING

When forming a 4-sided box, the punch must be sufficient height to prevent the pre-formed side from striking the upper beam. This is a thrusting application and not suitable for all press brakes.



## SWING EAR SECTIONS

- Box bending with return flanges.
- Standard bend length 150mm each ear on all punch profiles. 100mm length available on select profiles.
- Ear(s) recess/fall in left to right .50-.75", not to be confused with vertical movement. There will be approximately 1.0-1.5" of relief to rotate and drop the finished part.
- Punch profile will match the standard profile only in height, angle and radius. Width will be wider where hinged.



 Watch the video on our YouTube Channel!

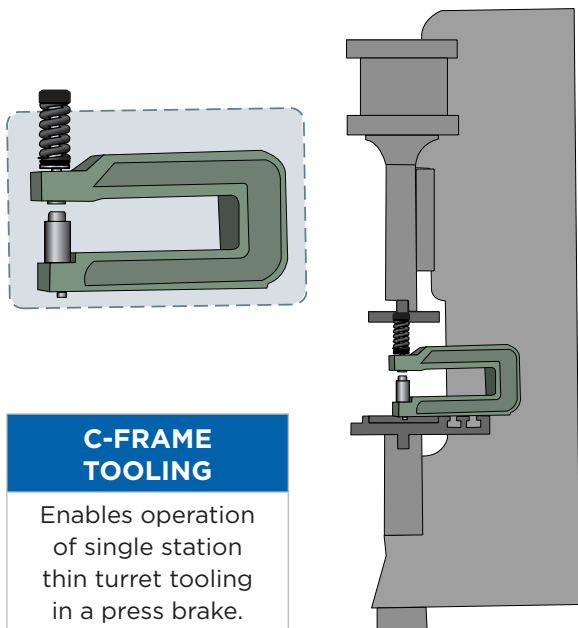
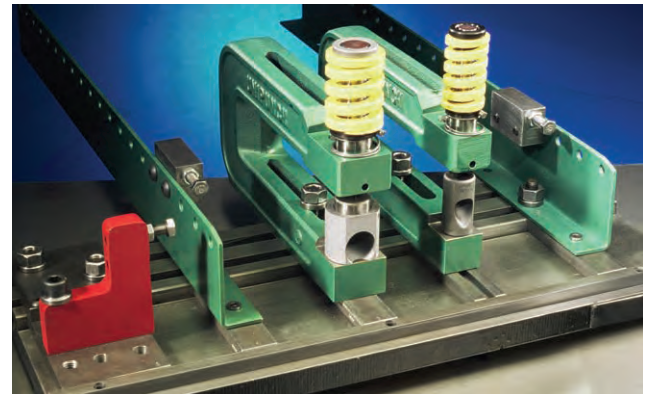
## C-FRAME TOOLING

### Creating Prototypes in Press Brakes

Unispacers fit into the recess in the Bed Rail and permit straight line punching of prototypes in flat metal, extrusions and structural shapes. If the preliminary hole locations change, Unispacers offer a quick and easy method to relocate the holes... simply reposition the Unispacers on the Bed Rail. For a staggered line of holes, use the slotted side of the Unispacer.

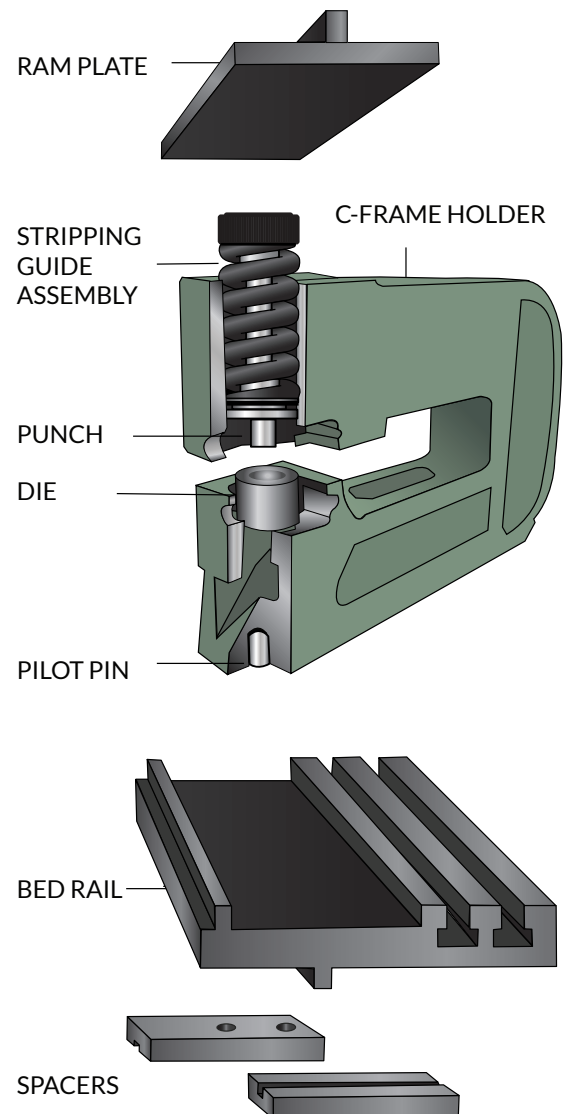
### Bed Rail / Unispacer Method

- For prototype or short run straight line punching applications with varying part lengths.
- Quick and easy set up and relocation of holes makes this a preferred mounting method.
- Unispacer fits into Bed Rail recess.
- Unispacer has two .376" diameter holes on one side to accept unit pilot pins and .376" slot on opposite side for unit front to back adjustment.



#### C-FRAME TOOLING

Enables operation of single station thin turret tooling in a press brake.



## PRESS BRAKE SPECIALS CHECKLIST

Company:	
Contact:	
Phone:	Sales Engineer:
Quote #:	Sales Desk Contact:

### MACHINE SPECIFICATIONS

BRAKE MAKE / MODEL	
OPEN HEIGHT	
TONNAGE	

### TOOLING AND APPLICATION

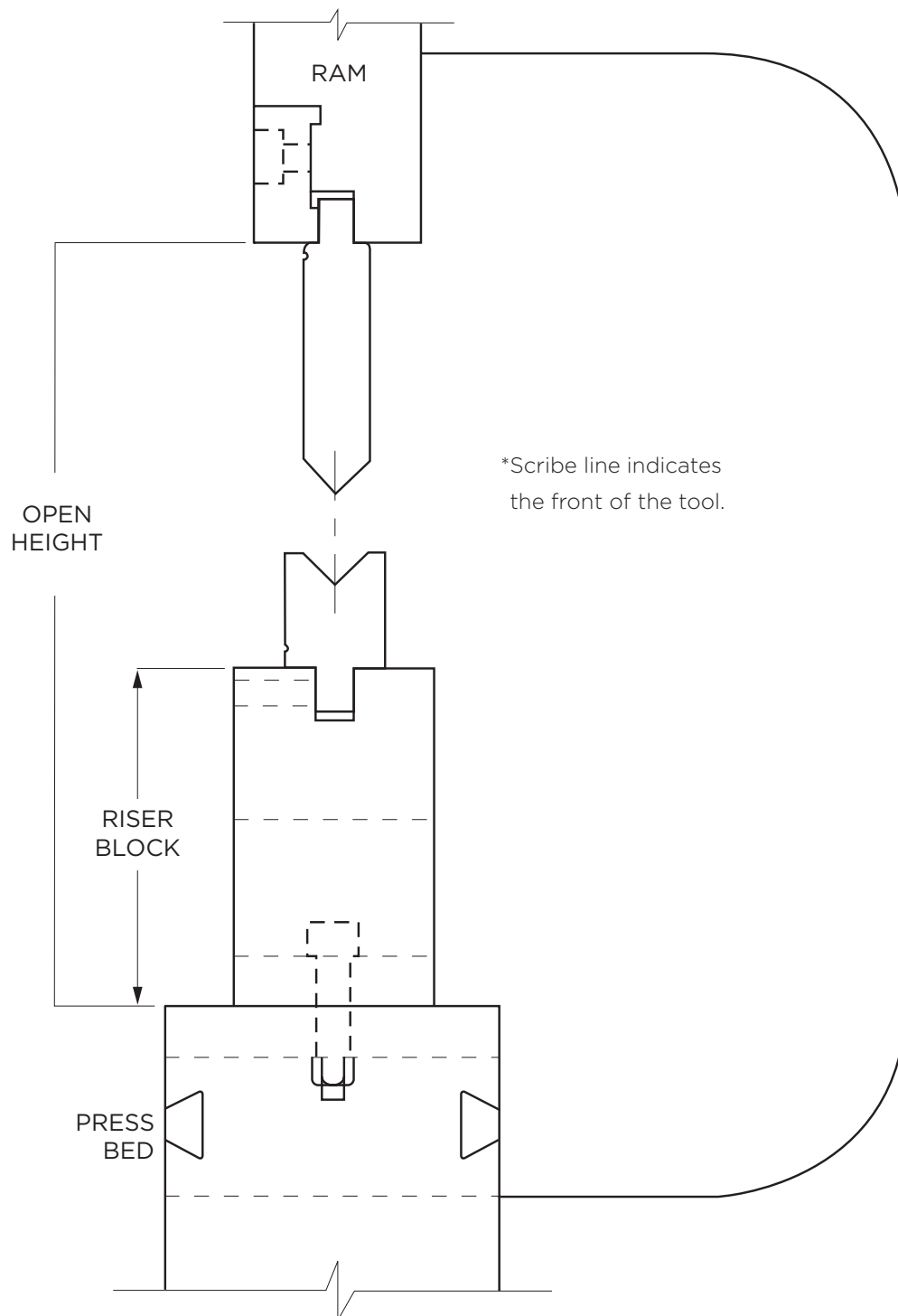
TOOLING TYPE	<input type="checkbox"/> American <input type="checkbox"/> European <input type="checkbox"/> WT <input type="checkbox"/> Other:		
LENGTH OF BEND			
MATERIAL TYPE		THICKNESS	
Is customer currently performing this bend? <input type="checkbox"/> Yes <input type="checkbox"/> No If YES, specify if this is a <input type="checkbox"/> Wilson Tool Repeat <input type="checkbox"/> Replicate Customer Tool <input type="checkbox"/> Redesign			
Explain:			

### TOLERANCE BLOCK

PART RADII TOLERANCE	<i>Tolerances tighter than <math>\pm 5\%</math> may affect price/lead time.</i>
PART BEND ANGLE TOLERANCE	<i>Tolerances tighter than <math>\pm 3\%</math> may affect price/lead time.</i>
ESTIMATED ANNUAL USAGE	



## TYPICAL PRESS SETUP


















## TONNAGE ESTIMATES

### Making Multiple Bends Formula on a Press Brake

For shape as shown, in mild steel with radii equal to the metal thickness unless otherwise noted.

**MULTIPLY METAL THICKNESS BY FACTOR = TONS PER FT.**

SHAPE	DESCRIPTION	AIRFORM	BOTTOMING
	VEE DIE	60	150
	WIPING	—	250
	OFFSET	150	300/600
	MATERIAL THICK OFFSET	300	600
	CHANNEL	300	600
	VEE RIB	200	600
	W DIE	300	600
	OPEN HAT CHANNEL	300	450
	SQUARE HAT CHANNEL	—	600
	PREFORM CURL	—	300
	PREFORM CURL	—	200
	CLOSED CURL	—	300
	RADIUS	—	180/300
	(Air) TEAR DROP	—	200
	CRUSHED HEM	—	400
<b>SHAPE CONSIDERATIONS</b>		Large Radii Angle Variation Concave/Convex sides	Material Thick Radii Min. Angle Variation Maintain Flatness

<b>Stainless Steel</b>	[18-8 Annealed] Type 304	<b>1.55</b>
	3303-H14 [1/2Hard]	<b>.35</b>
<b>Aluminum</b>	5052-H34 [1/2Hard]	<b>.65</b>
	6061-T64	<b>.75</b>
<b>Brass</b>	70/30 [1/2Hard]	<b>1.10</b>



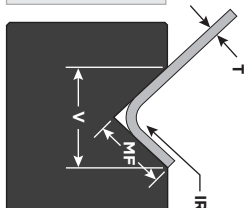
# AIR BENDING FORCE CHART

## IMPERIAL TONNAGE & METRIC V-OPENINGS

NOTE: Formulas and chart are for reference only.

T = Material Thickness; V = V-Opening; MF = Minimum Flange Length; IR = Inside Radius

**STANDARD FORMULAS FOR SELECTING A V-OPENING**  
 Material Thickness: 2.6mm or Less = T x 6  
 3.00mm - 8.0mm = T x 8  
 9.00mm - 12.00mm = T x 10  
 14.00mm & Thicker = T x 12



GAUGE	DEC. Inch [mm]	TONS PER FOOT																							
		V (mm)	4	6	7	8	10	12	14	16	18	20	25	32	40	50	63	80	100	125	160	200	250		
		V (in.)	0.157	0.236	0.276	0.315	0.394	0.472	0.551	0.630	0.709	0.787	0.984	1.260	1.575	1.969	2.480	3.150	3.937	4.921	6.299	7.874	9.843		
		MF	0.110	0.165	0.193	0.220	0.276	0.331	0.397	0.454	0.510	0.567	0.709	0.945	1.181	1.476	1.860	2.362	2.953	3.789	4.850	6.063	7.579		
		IR	0.026	0.039	0.046	0.052	0.066	0.079	0.092	0.105	0.118	0.131	0.164	0.210	0.262	0.328	0.413	0.525	0.656	0.820	1.050	1.312	1.640		
20	0.036 [.91]		5.4	<b>3.6</b>	3.0	2.5	2.0	1.7																	
18	0.048 [1.2]			7.2	<b>5.8</b>	4.8	3.7	2.7																	
16	0.060 [1.5]					7.8	<b>6.0</b>	5.0	4.2	2.0															
14	0.075 [1.9]						11.3	<b>7.5</b>	7.1	5.6	3.1														
13	0.090 [2.3]							12.5	<b>10.1</b>	8.2	7.2	4.1													
12	0.105 [2.7]							15.8	<b>13.0</b>	10.5	9.5	7.5	5.4												
11	0.120 [3]								16.1	<b>10.5</b>	10.1	10.1	7.5	5.6	4.0										
10	0.135 [3.4]									16.1	13.1	12.0	10.1	8.1	5.0	3.8									
9	0.150 [3.8]										13.1	12.0	10.1	8.1	6.2	4.7	3.5								
3/16"	0.188 [4.8]											12.0	10.1	8.1	6.2	4.7	3.5								
1/4"	0.250 [6.35]												12.0	10.1	8.1	6.2	4.7	3.5							
5/16"	0.313 [8]													12.0	10.1	8.1	6.2	4.7	3.5						
3/8"	0.375 [9.5]														12.0	10.1	8.1	6.2	4.7	3.5					
1/2"	0.500 [12.7]															12.0	10.1	8.1	6.2	4.7	3.5				
5/8"	0.625 [16]																12.0	10.1	8.1	6.2	4.7	3.5			
3/4"	0.750 [19]																	12.0	10.1	8.1	6.2	4.7	3.5		
1"	1.000 [25.4]																		12.0	10.1	8.1	6.2	4.7		
1-1/4"	1.250 [32]																			12.0	10.1	8.1	6.2		

Smaller v-openings generate increased tonnage and are NOT recommended.

Larger v-openings generate less tonnage.

NOTE: The chart above is based on mild steel (tensile strength of 60,000 PSI) formed to an included angle of 88°. See chart to the right for other materials. Forming to other angles will change the Minimum Flange (MF), Inside Radius (IR) and tonnage.



Watch the video on our YouTube Channel!

Soft Brass = Tons x 50%  
 Soft Aluminum = Tons x 50%  
 Heat Treated Aluminum Alloys = Tons x 100%  
 Stainless Steel = Tons x 150%  
 High Strength Steel = Tons x 275%

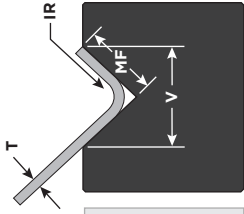
# AIR BENDING FORCE CHART IMPERIAL TONNAGE & IMPERIAL V-OPENINGS

NOTE: Formulas and chart are for reference only.

T = Material Thickness; V = V-Opening; MF = Minimum Flange Length; IR = Inside Radius

### STANDARD FORMULAS FOR SELECTING A V-OPENING

Material Thickness: .105" or Less = T x 6  
.120" - .313" = T x 8  
.375" - .500" = T x 10  
.625" & Thicker = T x 12



GAUGE	DEC. inch [mm]	TONS PER FOOT																	
		V (.in.)	0.250	0.313	0.375	0.500	0.625	0.750	0.875	1.000	1.125	1.250	1.500	2.000	2.500	3.000	3.500	4.000	5.000
20	0.036 [.9]	MF	0.180	0.225	0.270	0.360	0.450	0.540	0.630	0.720	0.810	0.900	1.080	1.440	1.800	2.159	2.519	2.879	3.599
18	0.048 [1.2]	IR	0.042	0.052	0.063	0.084	0.104	0.125	0.146	0.167	0.188	0.209	0.251	0.334	0.418	0.501	0.585	0.668	0.835
16	0.060 [1.5]		2.9	2.2	1.7	1.2	1.0												
14	0.075 [1.9]		7.0	4.0	2.9	2.2	1.6	1.3											
13	0.090 [2.3]		7.8	7.8	5.6	3.6	2.7	2.2	1.7										
12	0.105 [2.7]				11.7	6.0	4.5	3.4	3.0	2.5	2.1								
11	0.120 [3]						12.2	5.4	4.3	3.7	3.3	2.9							
10	0.135 [3.4]							10.1	6.3	5.4	4.4	4.0	3.2						
9	0.150 [3.8]								7.4	6.2	5.4	5.4	4.3	3.2					
7	0.188 [4.8]								10.5	8.8	7.2	6.2	5.4	4.3	3.2				
1/4"	0.250 [6.35]								11.3	9.6	8.4	7.0	5.6	4.1					
5/16"	0.312 [8]									13.1	11.9	9.0	6.7	5.2	3.5				
3/8"	0.375 [9.5]										16.4	14.0	11.2	7.6	5.8	4.5			
7/16"	0.438 [11.1]											28.8	22.0	15.3	11.5	9.1	7.5	6.2	7.6
1/2"	0.500 [12.7]												38.0	26.0	19.2	16.0	12.5	10.6	10.6
5/8"	0.625 [16]													41.0	29.9	24.0	19.4	16.0	12.3
3/4"	0.750 [19]														45.2	35.0	28.0	24.0	17.0
7/8"	0.875 [22]															47.9	39.0	33.1	24.0
1"	1.000 [25.4]																69.5	58.0	42.2
																		92.0	69.0
																			104.0

Larger v-openings generate less tonnage.

Smaller v-openings generate increased tonnage and are NOT recommended.

NOTE: The chart above is based on mild steel (tensile strength of 60,000 PSI) formed to an included angle of 88°. See chart to the right for other materials. Forming to other angles will change the Minimum Flange (MF), Inside Radius (IR) and tonnage.

Watch the video on our YouTube Channel!

Soft Brass = Tons x 50%  
Soft Aluminum = Tons x 50%  
Heat Treated Aluminum Alloys = Tons x 100%  
Stainless Steel = Tons x 150%  
High Strength Steel = Tons x 275%



# TOOL STORAGE AND TRANSPORTATION

## XTREME LIFT



Cat. No. 90064

- Punch support arm, and gates on both ends of roller top, keep tooling in place (Additional arms can be purchased separately)
- Rollers allow for easy loading and unloading of tooling
- Hand-pump hydraulic unit for easy raising and lowering
- Two (2) locking casters prevent unwanted cart movement

Note: The Xtreme Lift is currently only available in the U.S. market.

Cat. No.	Description
90064	Full Assembly (Xtreme Lift and Punch Support Arm)
90067	Punch Support Arm Only

Specifications	
Length Capacity	53"
Weight Capacity	500 lbs.
Height	52" max. / 21" min.
Double Tray Width	12"

## MOBILE STORAGE CART



Cat. No. 988491

Retainer top; Non-marking, non-scratching;  
Heavy duty casters (2 stationary, 2 swivel locking);  
Side-mounted handle for easy mobility

Specifications	
Drawer Weight Capacity	250 lbs.
Shelf Weight Capacity	250 lbs.
Overall Cart (W x L x T)	25-3/8" x 42-1/4" x 38"
Top Tray (W x L x D)	20-15/16" x 37-15/16" x 3/4"

# TOOL STORAGE

## 5 DRAWER TIP-UP PUNCH CABINET



**Cat. No. 91007**

### PUNCH STORAGE

- Lay down storage for laser marking visibility and easy tool identification
- Punches and dies can be stored in the same drawer
- Ergonomic handling of most tooling in and out of the cabinet

### ADDITIONAL SPECIFICATIONS

- Solid steel construction
- Mobile base with heavy duty casters
- Extended leg base to prevent tipping
- Rated capacity of 3,600 lbs.
- Drawers lined with industrial strength rubber mat
- Total weight capacity: 400 lbs. per drawer
- Retainer top with rubber mat
- Ships via truck freight



Extended wheel base prevents the cabinet from tipping.

## 10 DRAWER TOOL STORAGE CABINET



**Cat. No. 90021**

### PUNCH STORAGE

- Lay down storage for laser marking visibility and easy tool identification
- Punches and dies can be stored in the same drawer
- Ergonomic handling of most tooling in and out of the cabinet

### ADDITIONAL SPECIFICATIONS

- Solid steel construction
- Mobile base with heavy duty casters
- Extended leg base to prevent tipping
- Rated capacity of 3,600 lbs.
- Drawers lined with industrial strength rubber mat
- Total weight capacity: 400 lbs. per drawer
- Retainer top with rubber mat
- Ships via truck freight



Extended wheel base prevents the cabinet from tipping.

Cat. No.	Lead Time	Height	Width	Depth	Drawers Included
91007	5-15 days	45.5"	42.0"	24.0"	2 - 3" [76mm] 1 - 4" [101mm] 2 - 7" [175mm]
90021	5-15 days	51.5"	48.0"	27.0"	2 - 2" [50mm] 6 - 3" [76mm] 2 - 4" [101mm]

Additional tooling cabinets available.  
Contact a Tooling Technician for pricing and lead times.

### CUSTOM COLOR OPTIONS

055	Avalanche Blue	061	Frost White
051	Everest Blue	071	Light Gray
052	Classic Blue	072	Charcoal Gray
057	Midnight Blue	208	Yellow
102	Boreal Green	085	Sienna Orange
091	Black	081	Flame Red
041	Beige	616	White

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



# TOOL STORAGE

## XTREME STORAGE CABINET



- Vertical configuration for drawer access from either side
- High-capacity drawers with a keyed lock and label window open smoothly with rolling casters
- Trays can be adjusted vertically to maximize space for the height of tooling and tray inserts can be adjusted to adapt to your style of tooling, and to create a center channel from 0-59mm wide
- Drawer trays hold punches in tip-up position
- Shallow top tray in each drawer for storing small items/hand tools
- Relatively small footprint allows for placement close to the machine



Xtreme Storage Cabinet Detail	55130 (XSC312)	55131 (XSC512)
<b>Number of Drawers</b>	3	5
<b>Cabinet Height</b> (outside dim.)	48.8" (1.24m)	48.8" (1.24m)
<b>Width</b> (left to right - outside dim.)	26.0" (0.66m)	40.9" (1.04m)
<b>Depth / Tool Space</b> (front to back - inside dim.)	41.3" (1.05m)	41.3" (1.05m)
<b>Number of Tool Trays</b>	9	15
<b>Total Length* of Tooling</b> (1 tool/tray - inside dim.)	Up to 31' (9.44m)	Up to 51.5' (15.7m)
<b>Total Length* of Tooling</b> (2 tools/tray - inside dim.)	Up to 62' (18.9m)	Up to 103' (31.4m)

\*Total length does not include available storage in the top most tray in each drawer.

 Watch the video on our YouTube Channel!

ACCESSORIES



## MEASURING TOOLS

### DIGITAL ANGLE CUBE



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

### DIGITAL PROTRACTOR SET



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

### DIGITAL THICKNESS GAUGE



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



## MARK-FREE BENDING

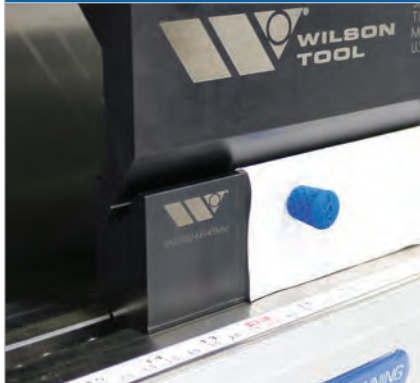
### URETHANE ROLLS — 6 in. x 100 ft.



Cat. No.	Thickness	Durometer	Description
42530	.015" [.4mm]	85A	<ul style="list-style-type: none"> <li>• More elastic than blue</li> <li>• Well suited for deeper draw applications</li> </ul>
42531	.030" [.8mm]	(Milky White)	<ul style="list-style-type: none"> <li>• Will not last as long as blue for 90° bends</li> </ul>
42532	.022" [.56mm]	95A (Blue)	<ul style="list-style-type: none"> <li>• A more ridged solution</li> <li>• lasts considerably longer than the white options in many applications</li> <li>• Harder and less elastic than blue</li> <li>• Not suited for deeper draw applications</li> </ul>

Note: This is not a good time to cheat the V opening and make it smaller. Keep in mind you are filling the V-opening with two thicknesses of urethane so it would be safer to oversize the V-opening a bit. The larger the shoulder radius, the larger the V-opening relative to the material type and thickness, the longer the life will be realized.

### PROTECTIVE FABRIC DRAPE



Forms a protective barrier between the sheet metal and the die shoulders during the bending process.

Cat. No.	Description
55335	12.5m [41'] length x 120mm [4.7"] width
987041	3/8" x 1/2" Cylinder Magnet

## HAND TOOLS

### METRIC HEX KEY WRENCH SET



Cat. No. 6105

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, 10 x 170.

### SOFT FACE HAMMER



Cat. No. 6106

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

### MAGNET SQUARE



Cat. No.  
974150

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

## GAUGING

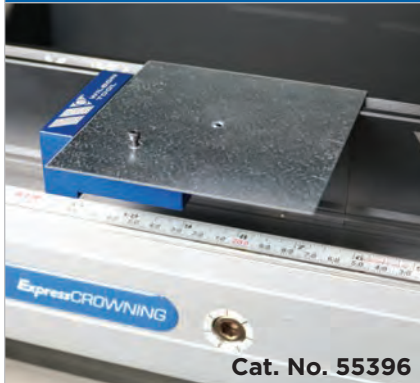
### MAGNETIC GAUGE



Use for back gauging, gauging outside the frame of the brake, front gauging, or when the part doesn't quite work with part configuration.

Cat. No.	Description
988741	Blue Threaded Cap

### MAGNETIC SQUARING BLOCK



Versatile, durable, 90° squaring block for left or right support and gauging. Strong magnets hold the lightweight tool in place while allowing for easy repositioning.

### MAGNETIC SQUARING ARM



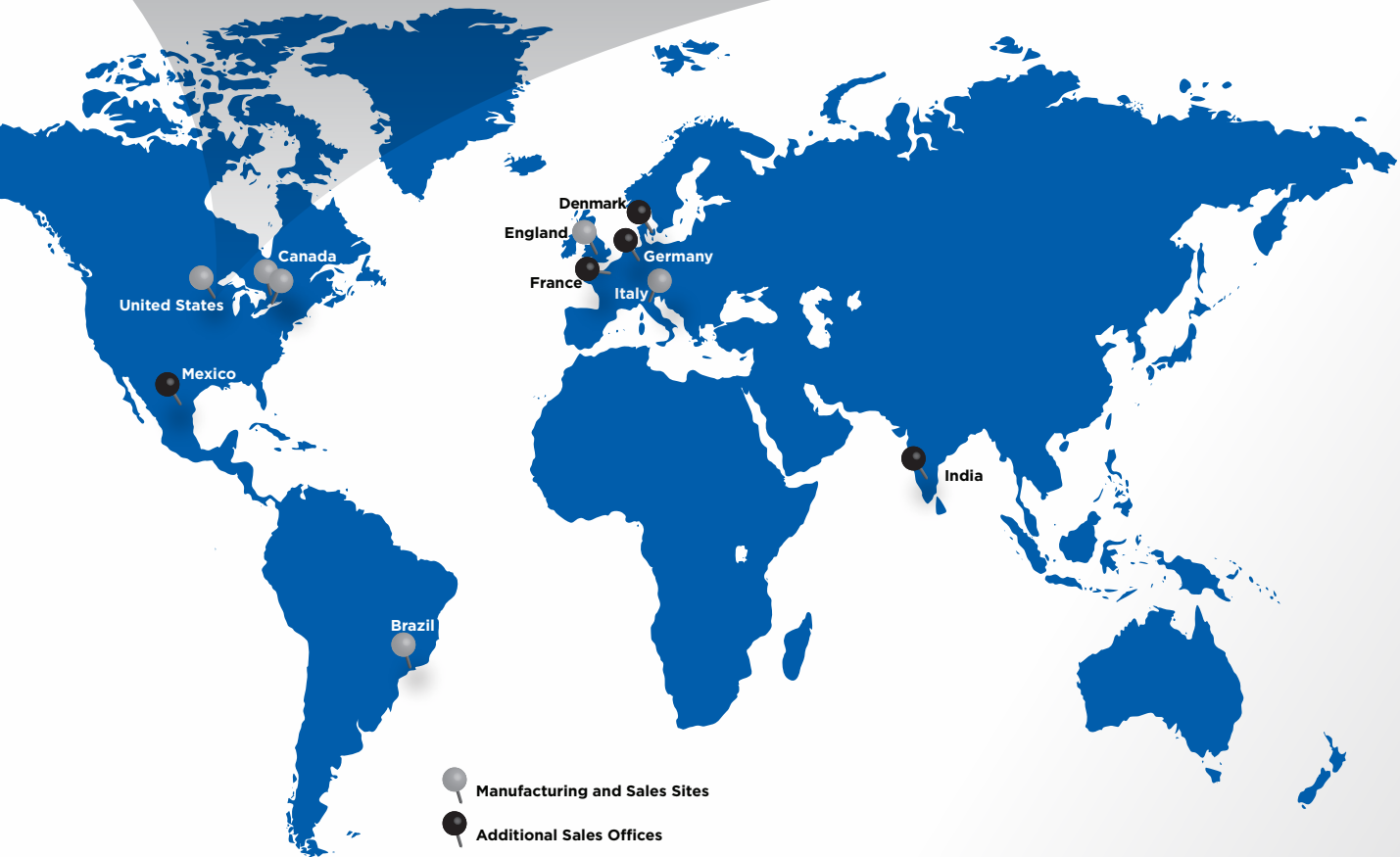
Increase bending accuracy with this simple hand tool. Suitable for any press brake die with a flat surface for easy attachment. Adjustable from 0° or 90° and is available in a left-handed or right-handed version.

Cat. No.	Description
42750L	Magnetic Squaring Arm LEFT
42750R	Magnetic Squaring Arm RIGHT

## WILSON TOOL INTERNATIONAL HEADQUARTERS

12912 Farnham Avenue N, White Bear Lake, MN 55110, USA  
**800-445-4518** | **bending@wilsontool.com**

**Canada** 800-268-4180      bending@wilsontoolcanada.com  
**Mexico** 001-800-741-2510      doblez@wilsontool.com



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