



**WT STYLE  
PRECISION™  
PRESS BRAKE  
TOOLING**

Your Choice  
for Durability and  
Performance



*Strength. Performance. Innovation.*

# FOR FASTER TOOL CHANGES, CHOOSE WT STYLE PRECISION™ TOOLING.

**W**ith WT Style Precision™ press brake tooling, Wilson Tool has developed an extremely durable tooling that significantly improves your press brake productivity with faster tool changes. Wilson's innovative push button, click-in/slide-out, locking loading and unloading mechanism, together with high-quality manufacturing makes WT Style Precision a more efficient and versatile tooling alternative. WT Style is compatible with Wila®, Trumpf® and LVD® style clamping systems.

## Push Button Tool Changes.

Load and unload tools instantly with WT Style Precision's unique click-in feature. Wilson's patented push button technology eliminates the need for special clamps, holders or dedicated upper beams, significantly reducing costly downtime. A single operator can load multiple tools easily by simply clicking each tool in place at any point along the brake.



**PRESS**



**LOAD**



**LOCK**

## Precision Ground for Consistent Results.

WT Style press brake tooling is precision ground to a tolerance of  $\pm .0004$ " (.01mm) on all critical dimensions for reliable performance and accurate results. Available standard (19.7"/500 mm) and sectionalized (41.3"/1050mm) tooling can be mixed and matched for consistent bending quality.

# NITREX® ALARGA LA VIDA DE LAS HERRAMIENTAS DE PLEGADORA.

## NITREX® MEJORA LA SUPERFICIE DE LAS MISMAS



### Alcanzando una Dureza y Durabilidad Inigualables.

La superficie Nitrex® patentada por Wilson Tool de alta resistencia incrementa la vida de las herramientas de plegadora muchas veces más que las herramientas no tratadas. Nitrex es un proceso de tratamiento de templado que permeabiliza el acero de las herramientas para lograr una dureza en la superficie de HRC-70, ofreciéndoles a los fabricantes que trabajan con plegadoras, una durabilidad y productividad inigualable.



### Reducción de Adherencia de Material. Cero Corrosión.

Nitrex también agrega lubricidad a las herramientas de plegadora que reduce fricción al deslizarse las chapas de metal sobre la apertura-V de la matriz, minimizando la adherencia de material incluso en las situaciones de plegado más difíciles. A diferencia de las herramientas de plegados comunes, las herramientas con tratamiento Nitrex experimentan, cero corrosión, resultando en limpiezas más rápidas y herramientas de mayor duración.

### Reducción en los Costos Generales de las Herramientas. Incremento de Productividad.

Nitrex otorga un incremento dramático tanto en la durabilidad y longevidad de las herramientas de plegado resultando en un significativo incremento en productividad, reduciendo los costos generales de las herramientas y una terminación superior en los productos. Solo Wilson ofrece Nitrex y está disponible en todas las herramientas standards de Wilson.

### La Superficie Nitrex de Alta Resistencia Provee:

- Dureza de superficie de HRC-70
- Vida de la herramienta considerablemente más larga
- Reducción de adherencia de material
- Resistencia de Corrosión
- Incremento de productividad
- Reducción en los costos generales de las herramientas



### Incremente la Vida de las Herramientas y Reduzca los Costos con Nitrex.

Los fabricantes de plegado en el mundo están descubriendo como Nitrex puede mejorar la productividad y reducir los costos generales de las herramientas. Para más información visite [www.wilsontool.com](http://www.wilsontool.com).



**Fortaleza. Rendimiento. Innovación.**

# ALTA PRECISIÓN. BAJO COSTE.

## WILSON DIGITAL PROTRACTOR



Medir ángulos en piezas metálicas resulta mucha más fácil con el Transportador de medición Digital Wilson. Estos transportadores ligeros, de fácil uso y altamente precisos miden ángulos de 0 a 360 grados con una precisión digital. Gracias a los fuertes imanes que lleva, es fácil de usar en largas y en pequeñas piezas. Sus características incluyen:

- Sistema de bloqueo suete y de fácil uso.
- La función de fijación asegura que nunca se pierde la lectura.
- Su capacidad de lectura "invertida" permite calcular aquellos ángulos difíciles de calcular.
- Fácil de reiniciar la lectura. Sólo presionando el botón "Zero".
- Precisión de +/- 0.01 grados.
- Todos los sets de Transportadores de medición Digital un transportador de 101.6, 203.2 y 304.8 mm, facilitando la medición de ángulos en las piezas más largas y en las pequeñas.
- Plazo de entrega en 24-48 horas.

Para más información sobre los Transportadores de medición Digital Wilson, contacte con SUPRAFORM, S.L.  
Teléfono: 936631300 -Email: [comercial@supraform.net](mailto:comercial@supraform.net)



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[www.wilsontool.com](http://www.wilsontool.com)

# Increase Your Speed and Accuracy.

## MAGNETIC SQUARING ARM



The Magnetic Squaring Arm from Wilson Tool is a flexible tool enabling you to get more parts through your press brake with higher accuracy.

### Simple and quick to fit

The arm attaches to the die with a powerful magnet. There are no screws to be tightened or fastening tools required. The Magnetic Squaring Arm attaches to any press brake die having a flat vertical surface.

### Bending parts at an angle

The Magnetic Squaring arm can be adjusted from 0° to 90°, and is available in left handed or right handed versions to meet user preference and part requirements. With the Wilson Magnetic Squaring Arm, angles can be set to match the part, ensuring that the bend is consistently in the correct location.

### Safety is built in for small parts

The Wilson Magnetic Squaring Arm provides a shelf for small parts, allowing the operators to position the part against the arm, and release their fingers from the part prior to bending to ensure safety.

### Can be used as end stop for Z bends.

When there is a Z-bend within the part, it will not lie flat after the first bend because there is a downward facing return. By positioning the angle bar on the opposite side of the slide arm, these Z-bends can be squared accurately.

Left handed model shown



For more information on how the Magnetic Squaring Arm from Wilson Tool can help improve your press brake performance, call 800-445-4518 or visit [www.wilsontool.com](http://www.wilsontool.com).



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## Wilson Urethane Rolls



### Urethane Rolls For Mark Free Bending

	Catalog #	Dimensions	Color
Standard	42530	.015 [0.4] x 6" [152]	White
Standard	42531	.030 [0.8] x 6" [152]	White
High Density	42532	.022 [0.6] x 6" [152]	Blue

For more information on Wilson Tool's line of urethane dies or urethane rolls, contact your Sales Engineer, the Press Brake Sales Desk at 800-445-4518 or email [pressbrake@wilson tool.com](mailto:pressbrake@wilson tool.com).

## Consider our V-Series™ Dies to Reduce Sheet Marking

Wilson Tool's V-Series for press brake dies incorporates rotating inserts to decrease friction and to enable better performance on certain tough-to-bend applications. Manufactured by Rolla-V, the Wilson V-Series is available for virtually all major styles of press brake tooling.

### Hard-to-bend Application Capability

Wilson V-Series dies make it much easier to produce small flanges, small bend radii, and bends closer to holes. The Wilson V-Series also enables you to bend a wide range of materials using the same die, reducing set-up time and reducing the amount of tooling required.

### Reduced Friction

Wilson V-Series dies include built-in blades that rotate so there is minimal lateral movement between the sheet and the die. This reduction in movement decreases the friction between the die and the sheet which helps to minimize sheet marking.



For more information on Wilson Tool's V-Series dies, contact your Sales Engineer, the Press Brake Sales Desk at 800-445-4518 or email [pressbrake@wilson tool.com](mailto:pressbrake@wilson tool.com).



# MORE BENDING CAPABILITY. IMPROVED PRODUCTIVITY.

## Wilson V-Series™ Press Brake Dies



Wilson Tool's V-Series for press brake dies incorporates rotating inserts to decrease friction and to enable better performance on certain tough-to-bend applications. Manufactured by Rolla-V, the Wilson V-Series is available for virtually all major styles of press brake tooling.

### Hard-to-bend Application Capability

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### Interchangeable Blade Material

The rotating blades are available in either metal or composite material. Metal blades are the most durable, while composite blades are used when minimizing sheet marking is essential. These blades are interchangeable within the same die base.

### Reduced Friction

Wilson V-Series dies include built-in blades that rotate so there is minimal lateral movement between the sheet and the die. This reduction in movement decreases the friction between the die and the sheet which helps to minimize sheet marking.



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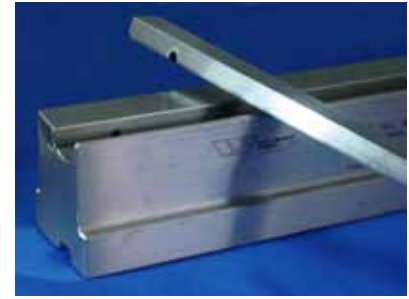
For more information on the Wilson V-Series, contact your local sales representative or contact our salesdesk at 1-800-445-4518.

[www.wilsontool.com](http://www.wilsontool.com)



## SPECIFICATION

TYPE		MODEL 1	MODEL 2	MODEL 3
Max. material thickness [mm]		2	4	8
Max. outside radius [mm]		5	9	24
Min. Bend Angle*		30°	45°	75°
Equivalent 'V' size [mm]		8	15	38
Allowable Tonnage [Ton/Ft]		33	50	50
Min. Flange **	Material Thickness [mm]	Outside Dimension [mm]		
		MODEL 1	MODEL 2	MODEL 3
	1.0	4.7	-	-
	1.6	5.4	8.7	-
	2.0	5.6	9.8	-
	3.0	-	10.2	24.3
	4.0	-	-	25.5
6.0	-	-	26.5	
Tool Length [mm]	Euro Style	S = 417.5 mm L = 815 mm X = 550 mm		
	American Style	S = 500 mm L = 1000 mm X = 550 mm		

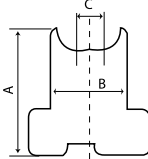
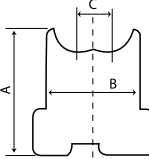
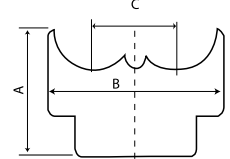
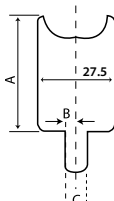
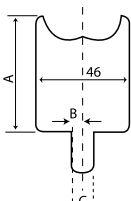
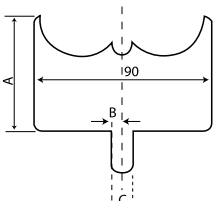


\* Min bend angle may vary depending upon punch tip radius and material thickness.

More acute angles are possible subject to condition - contact our sales desk.

\*\* These dimensions apply to bending Mild Steel and Aluminum. Dimensions may increase slightly with Stainless Steel.

## TOOL PROFILE

Euro Style				A [mm]	B [mm]	C [mm]			
Model 1				60	27.5	8			
Model 2				60	46.0	15			
Model 3				60	90.0	38			
							<b>MODEL 1</b>	<b>MODEL 2</b>	<b>MODEL 3</b>
American Style				A [mm]	B [mm]	C [mm]			
Model 1				55 or 100	6.35	12.7			
Model 2				55 or 100	6.35	12.7			
Model 3				55 or 100	6.35	12.7			

For more information on the Wilson V-Series, contact your local sales representative or contact our salesdesk at 1-800-445-4518.

[www.wilsontool.com](http://www.wilsontool.com)



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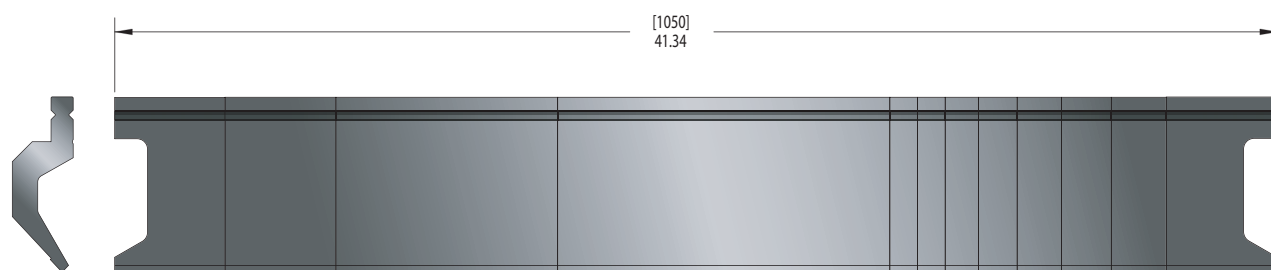
## Nitrex™ Triples Tool Life.

Wilson Tool's exclusive Nitrex high endurance surface enhancement, standard on all WT Style Precision™ tooling, increases press brake tooling life by several times that of ordinary tooling. Wilson's patented process provides a surface hardness of HRC-70, increasing long-term durability and minimizing galling in even the toughest bending situations.

## Specials Are Our Specialty.

No matter how unique your tooling needs, Wilson Tool can design and manufacture a WT Style Precision press brake tooling to your specifications. Our years of experience in the industry and the ingenuity of our manufacturing, engineering, and research and development personnel enable us to create durable, performance-driven tooling solutions for even the most challenging application.

## Standard Punch and die lengths



### Standard Lengths:

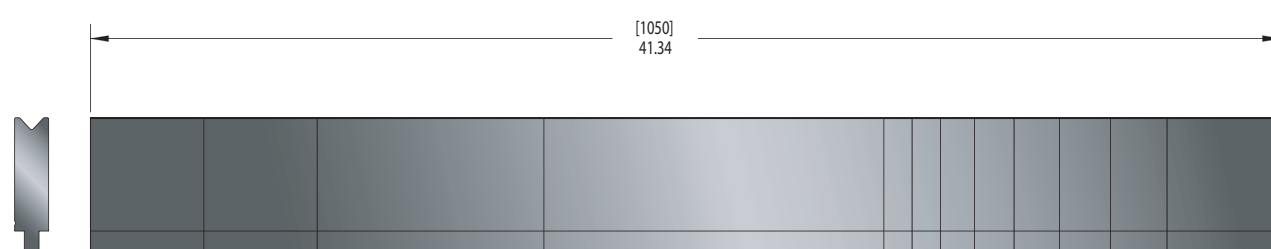
500 = 500mm (19.7")  
Sectionalized (X) = 1050mm (41.3")

### Sectionalized Lengths:

100mm (L)	(3.93")
100mm	(3.93")
200mm	(7.87")
300mm	(11.81")
(2) 25mm	(0.98)
30mm	(1.18")
35mm	(1.37")
40mm	(1.57")
45mm	(1.77")

### Features:

1. All tools can be loaded by a single operator.
2. Easy to store. Cabinets available.
3. All tools come precision cut in twelve pieces.
4. Sectionalized punches include two ear pieces (horns).
5. Nitrex™ (HRC-70) is standard for every punch and die.
6. Special tooling available. Please contact a Application Specialist at our toll free number.
7. All punches can be vertically loaded.



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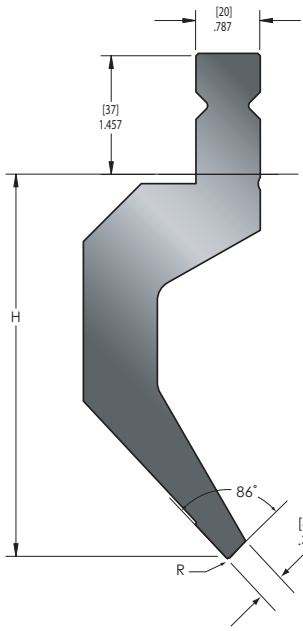
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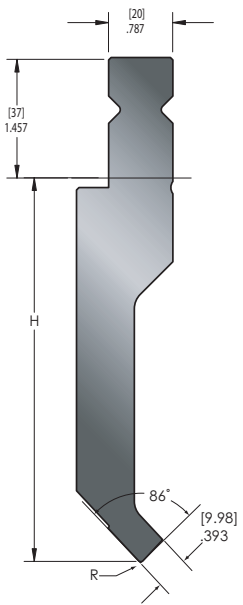
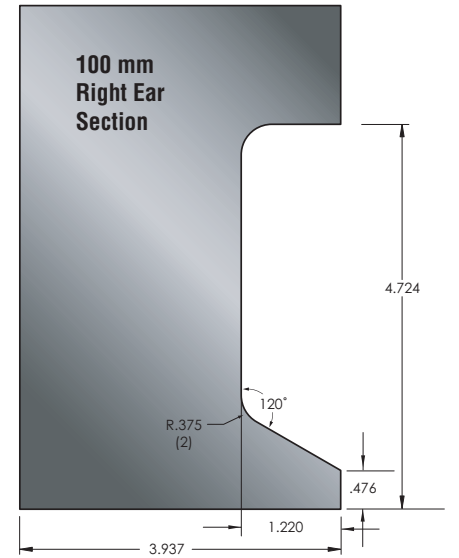
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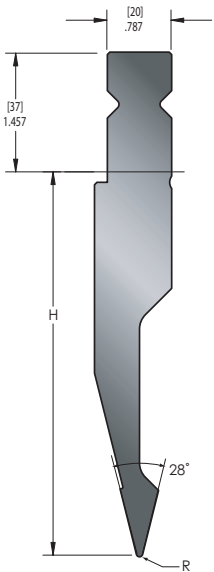
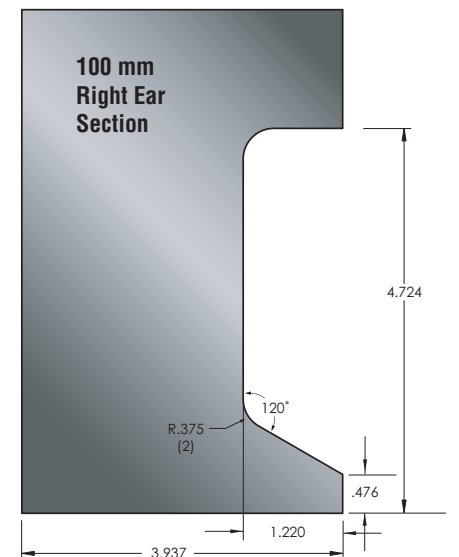
SERIES 600		86° SWAN-NECK PUNCH					500	X
	Catalog #	R Tip Radius inch [mm]	A Angle	H Height inch [mm]	MAX TON feet [meter]	19.7 [500mm]	Sectionalized 41.3 [1050mm]	
STOCK	60086010	.039 [1.0]	86	4.724 [120.0]	27 [90]			
	600C	.020 [0.5]	86	4.717 [119.8]	27 [90]			
	600C	.063 [1.6]	86	4.693 [119.2]	27 [90]			
	600C	.079 [2.0]	86	4.693 [119.2]	27 [90]			
	600C	.091 [2.3]	86	4.685 [119.0]	27 [90]			
	600C	.098 [2.5]	86	4.685 [119.0]	27 [90]			
	600C	.118 [3.0]	86	4.673 [118.7]	27 [90]			
	600C	.126 [3.2]	86	4.669 [118.6]	27 [90]			
	600C	.157 [4.0]	86	4.657 [118.3]	27 [90]			

Tooling for special application available upon request.  
2050mm, 2550mm, 3050mm & 4050mm sets available, please call for pricing.



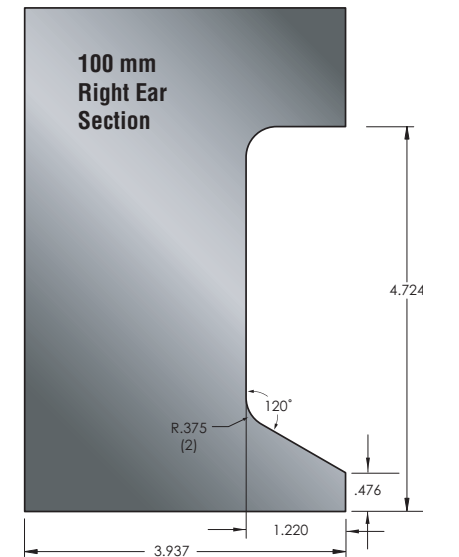
SERIES 601		86° GOOSE-NECK PUNCH					500	X
	Catalog #	R Tip Radius inch [mm]	A Angle	H Height inch [mm]	MAX TON feet [meter]	19.7 [500mm]	Sectionalized 41.3 [1050mm]	
STOCK	60186010	.039 [1.0]	86	4.724 [120.0]	27 [90]			
	601C	.020 [0.5]	86	4.717 [119.8]	27 [90]			
	601C	.063 [1.6]	86	4.693 [119.2]	27 [90]			
	601C	.079 [2.0]	86	4.693 [119.2]	27 [90]			
	601C	.091 [2.3]	86	4.685 [119.0]	27 [90]			
	601C	.098 [2.5]	86	4.685 [119.0]	27 [90]			
	601C	.118 [3.0]	86	4.677 [118.8]	27 [90]			
	601C	.126 [3.2]	86	4.669 [118.6]	27 [90]			
	601C	.157 [4.0]	86	4.657 [118.3]	27 [90]			

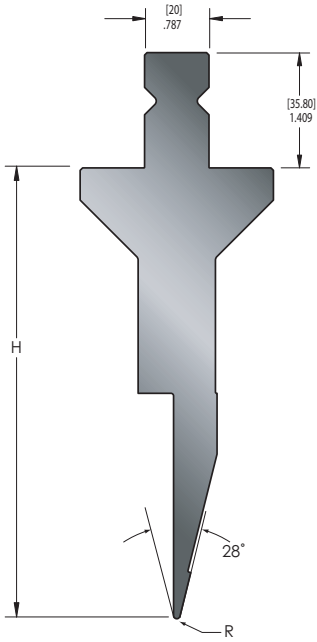
Tooling for special application available upon request.  
2050mm, 2550mm, 3050mm & 4050mm sets available, please call for pricing.



SERIES 602		28° POINTED WITH RECESS PUNCH					500	X
	Catalog #	R Tip Radius inch [mm]	A Angle	H Height inch [mm]	MAX TON feet [meter]	19.7 [500mm]	Sectionalized 41.3 [1050mm]	
STOCK	60228010	.039 [1.0]	28	4.724 [120.0]	25 [83]			
	602C	.020 [0.5]	28	4.717 [119.8]	25 [83]			
	602C	.063 [1.6]	28	4.614 [117.2]	25 [83]			
	602C	.079 [2.0]	28	4.571 [116.1]	25 [83]			
	602C	.091 [2.3]	28	4.531 [115.1]	25 [83]			
	602C	.098 [2.5]	28	4.504 [114.4]	25 [83]			
	602C	.118 [3.0]	28	4.441 [112.8]	25 [83]			
	602C	.126 [3.2]	28	4.437 [112.7]	25 [83]			
	602C	.157 [4.0]	28	4.323 [109.8]	25 [83]			

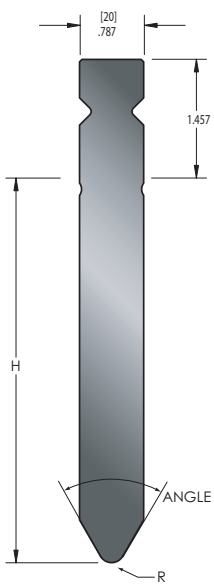
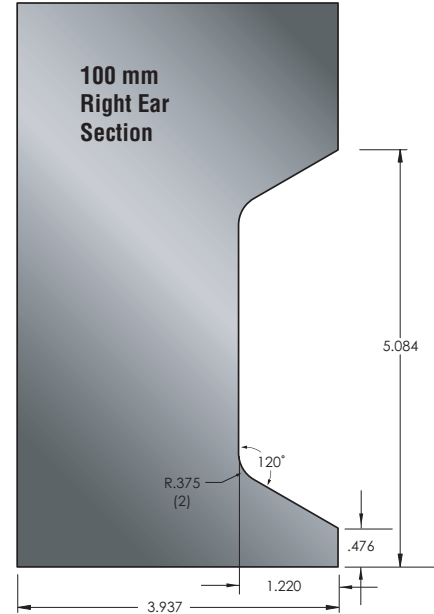
Tooling for special application available upon request.  
2050mm, 2550mm, 3050mm & 4050mm sets available, please call for pricing.





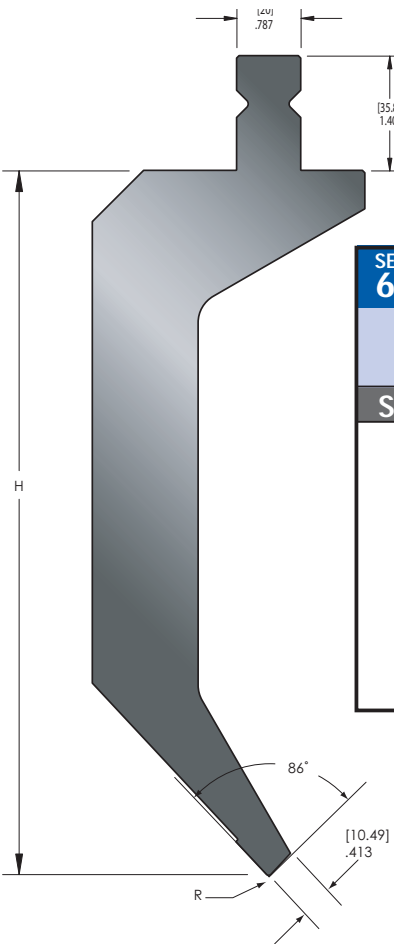
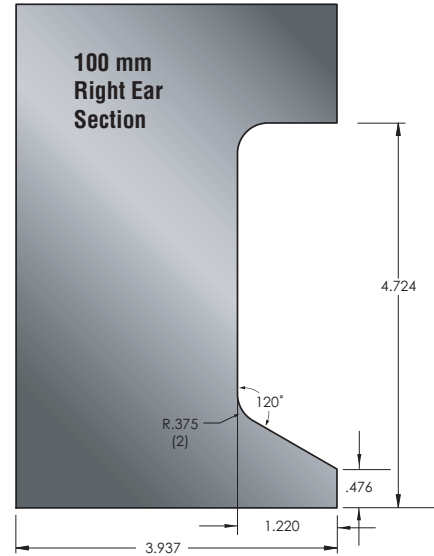
SERIES 603 28° POINTED WITH FLATTENED SPOT PUNCH							
	Catalog #	R Tip Radius inch [mm]	A Angle	H Height inch [mm]	MAX TON feet [meter]	500 19.7 [500mm]	X Sectionalized 41.3 [1050mm]
STOCK	60328010	.039 [1.0]	28	5.512 [140.0]	19 [83]		
	603C	.020 [0.5]	28	5.504 [139.8]	19 [83]		

Tooling for special application available upon request.  
2050mm, 2550mm, 3050mm & 4050mm sets available, please call for pricing.



SERIES 604 60° POINTED/90° BOTTOMING PUNCH							
	Catalog #	R Tip Radius inch [mm]	A Angle	H Height inch [mm]	MAX TON feet [meter]	500 19.7 [500mm]	X Sectionalized 41.3 [1050mm]
STOCK	60460040	.157 [4.0]	60	4.724 [120.0]	25 [83]		
	604C	.079 [2.0]	60	4.717 [119.8]	25 [83]		
	604C	.098 [2.5]	60	4.717 [119.8]	25 [83]		
	604C	.118 [3.0]	60	4.717 [119.8]	25 [83]		
	604C	.185 [4.7]	60	4.689 [119.1]	25 [83]		
	604C	.197 [5.0]	60	4.677 [118.8]	25 [83]		
	604C	.236 [6.0]	60	4.630 [117.6]	25 [83]		

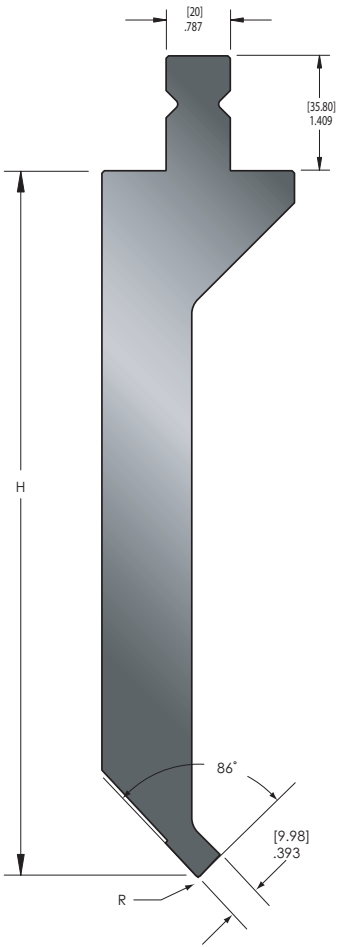
Tooling for special application available upon request.  
2050mm, 2550mm, 3050mm & 4050mm sets available, please call for pricing.



SERIES 610 86° SWAN-NECK PUNCH							
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STOCK	61086010	.039 [1.0]	86	8.661 [220.0]	27 [90]		
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	610C	.063 [1.6]	86	8.630 [219.2]	27 [90]		
	610C	.079 [2.0]	86	8.630 [219.2]	27 [90]		
	610C	.091 [2.3]	86	8.622 [219.0]	27 [90]		
	610C	.098 [2.5]	86	8.610 [218.7]	27 [90]		
	610C	.118 [3.0]	86	8.602 [218.5]	27 [90]		
	610C	.126 [3.2]	86	8.602 [218.5]	27 [90]		
	610C	.157 [4.0]	86	8.594 [218.3]	27 [90]		

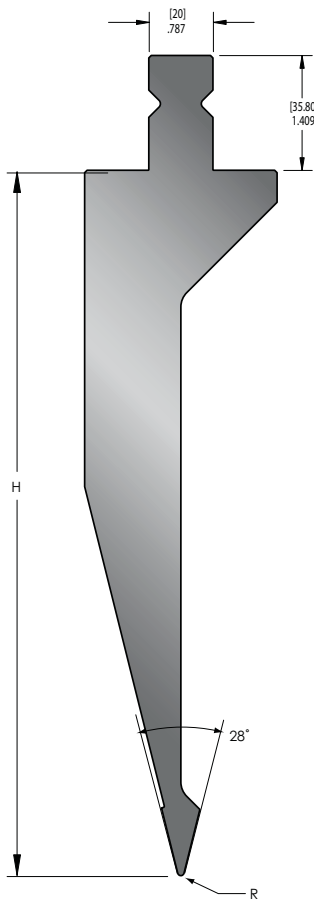
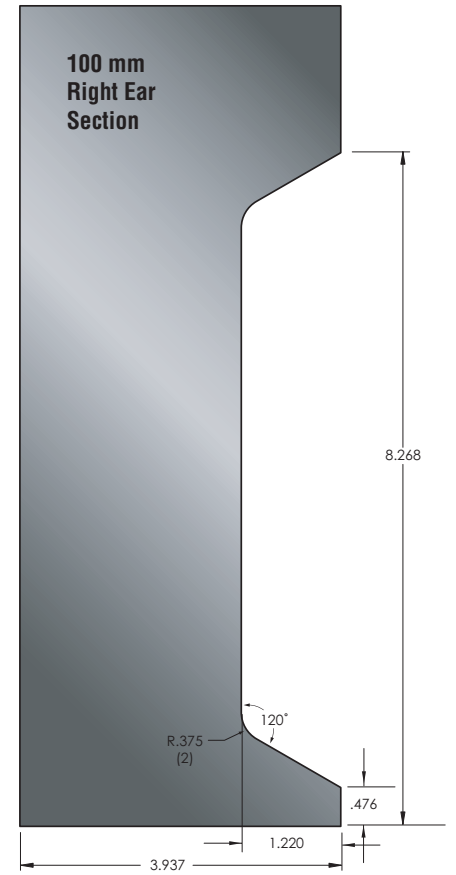
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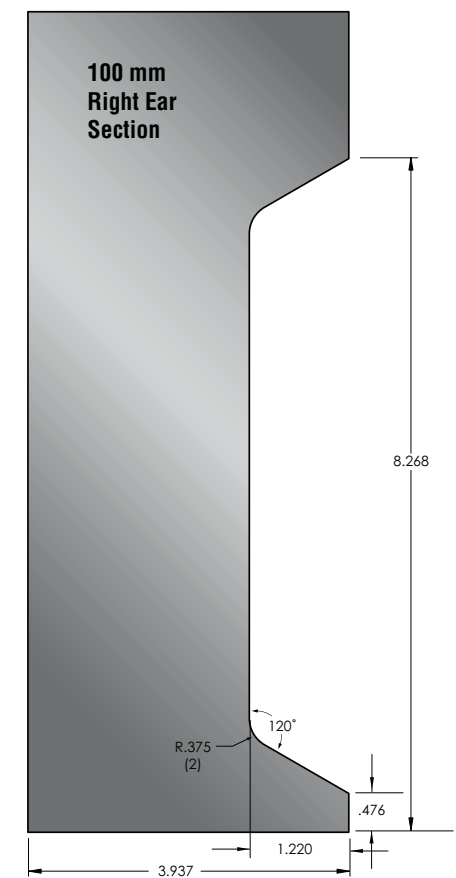
SERIES 611		86° GOOSE-NECK PUNCH					
	Catalog #	R Tip Radius inch [mm]	A Angle	H Height inch [mm]	MAX TON feet [meter]	500 19.7 [500mm]	X Sectionalized 41.3 [1050mm]
STOCK	61186010	.039 [1.0]	86	8.661 [220.0]	25 [83]		
	611C	.020 [0.5]	86	8.654 [219.8]	25 [83]		
	611C	.063 [1.6]	86	8.638 [219.4]	25 [83]		
	611C	.079 [2.0]	86	8.630 [219.2]	25 [83]		
	611C	.091 [2.3]	86	8.622 [219.0]	25 [83]		
	611C	.098 [2.5]	86	8.610 [218.7]	25 [83]		
	611C	.118 [3.0]	86	8.602 [218.5]	25 [83]		
	611C	.126 [3.2]	86	8.602 [218.5]	25 [83]		
	611C	.157 [4.0]	86	8.594 [218.3]	25 [83]		

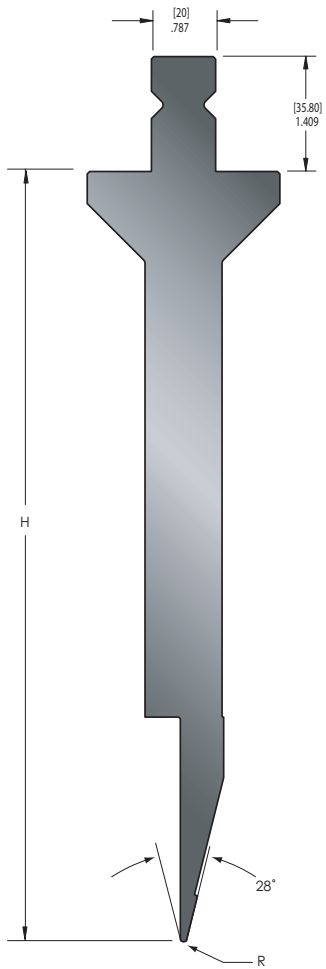
Tooling for special application available upon request.  
2050mm, 2550mm, 3050mm & 4050mm sets available, please call for pricing.



SERIES 612		28° POINTED WITH RECESS PUNCH					
	Catalog #	R Tip Radius inch [mm]	A Angle	H Height inch [mm]	MAX TON feet [meter]	500 19.7 [500mm]	X Sectionalized 41.3 [1050mm]
STOCK	61228010	.039 [1.0]	28	8.661 [220.0]	25 [77]		
	612C	.020 [0.5]	28	8.654 [219.8]	25 [77]		
	612C	.063 [1.6]	28	8.575 [217.8]	25 [77]		
	612C	.079 [2.0]	28	8.504 [216.0]	25 [77]		
	612C	.091 [2.3]	28	8.488 [215.6]	25 [77]		
	612C	.098 [2.5]	28	8.425 [214.0]	25 [77]		
	612C	.118 [3.0]	28	8.378 [212.8]	25 [77]		
	612C	.126 [3.2]	28	8.374 [212.7]	25 [77]		
	612C	.157 [4.0]	28	8.260 [209.8]	25 [77]		

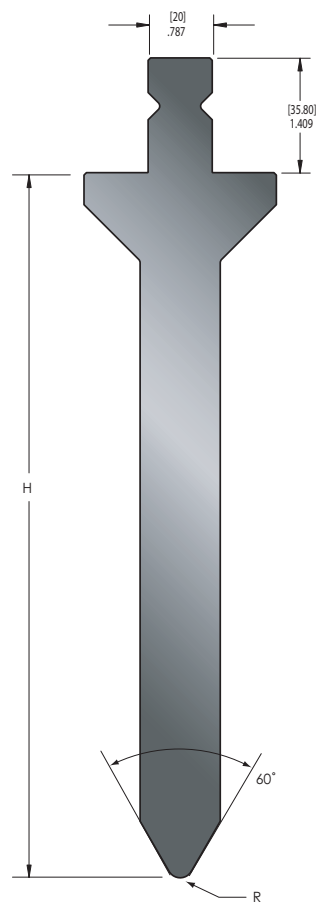
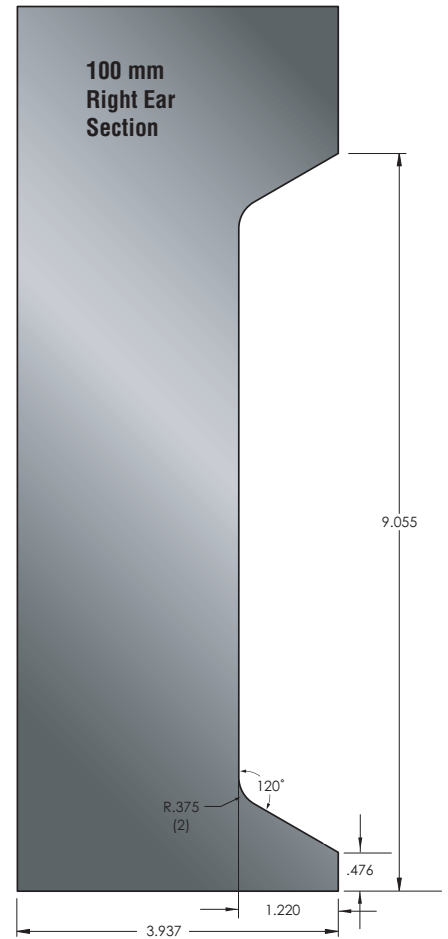
Tooling for special application available upon request.  
2050mm, 2550mm, 3050mm & 4050mm sets available, please call for pricing.





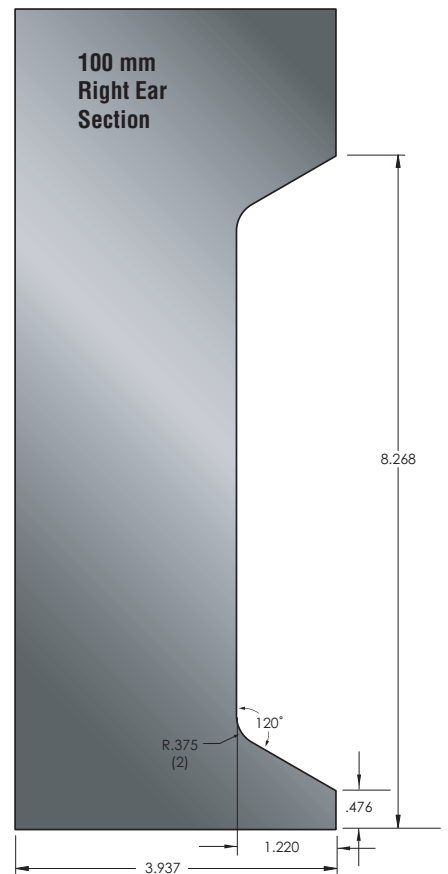
SERIES 613		28° POINTED WITH FLATTENED SPOT PUNCH					
	Catalog #	R Tip Radius inch [mm]	A Angle	H Height inch [mm]	MAX TON feet [meter]	500 19.7 [500mm]	X Sectionalized 41.3 [1050mm]
STOCK	61328010	.039 [1.0]	28	9.449 [240.0]	19 [63]		
	613C	.020 [0.5]	28	9.441 [239.8]	19 [63]		

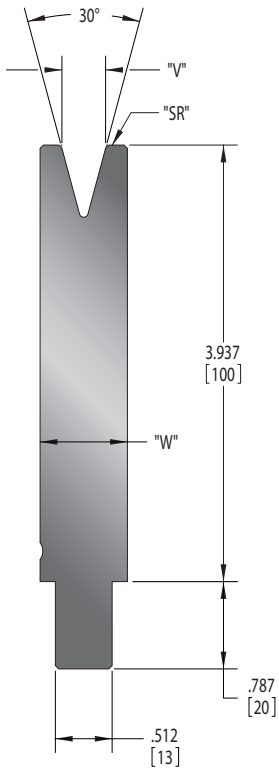
Tooling for special application available upon request.  
2050mm, 2550mm, 3050mm & 4050mm sets available, please call for pricing.



SERIES 614		60° POINTED PUNCH					
	Catalog #	R Tip Radius inch [mm]	A Angle	H Height inch [mm]	MAX TON feet [meter]	500 19.7 [500mm]	X Sectionalized 41.3 [1050mm]
STOCK	61460040	.157 [4.0]	60	8.661 [220.0]	25 [83]		
	614C	.079 [2.0]	60	8.654 [219.8]	25 [83]		
	614C	.098 [2.5]	60	8.654 [219.8]	25 [83]		
	614C	.118 [3.0]	60	8.654 [219.8]	25 [83]		
	614C	.185 [4.7]	60	8.622 [219.0]	25 [83]		
	614C	.197 [5.0]	60	8.606 [218.6]	25 [83]		
	614C	.236 [6.0]	60	8.567 [217.6]	25 [83]		
	614C	.250 [6.35]	60	8.551 [217.2]	25 [83]		

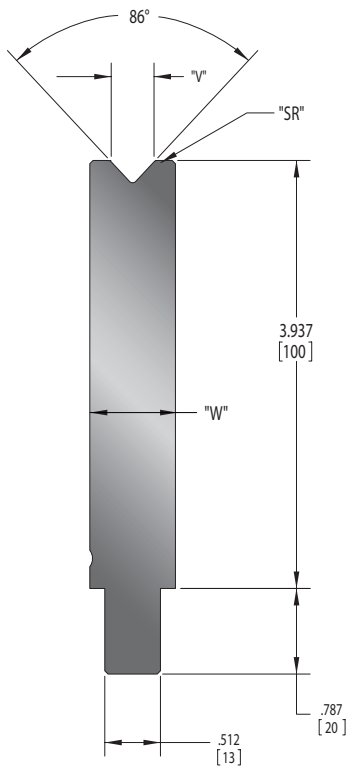
Tooling for special application available upon request.  
2050mm, 2550mm, 3050mm & 4050mm sets available, please call for pricing.





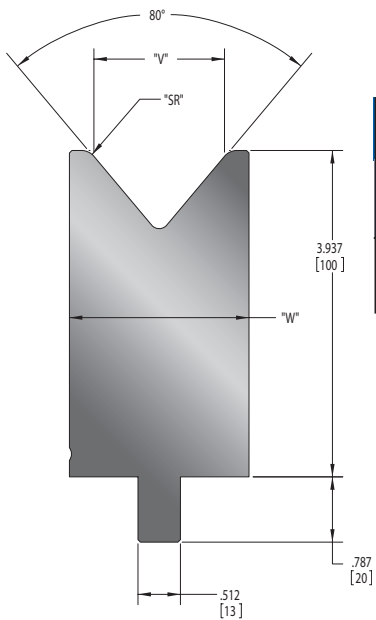
SERIES 650 30° DIES – 100mm [3.937"] TALL								
	Catalog #	A Angle	V Opening inch [mm]	W Width inch [mm]	SR Shoulder Radius	MAX TON feet [meter]	500 19.7 [500mm]	X Sectionalized 41.3 [1050mm]
STOCK	65030006	30	.236 [6]	.787 [20]	.024 [0.6]	14 [45]		
	65030008	30	.315 [8]	.787 [20]	.039 [1.0]	14 [45]		
	65030010	30	.394 [10]	.787 [20]	.039 [1.0]	14 [45]		
	65030012	30	.472 [12]	.984 [25]	.039 [1.0]	14 [45]		
	65030016	30	.630 [16]	1.181 [30]	.063 [1.6]	17 [56]		
	65030020	30	.787 [20]	1.378 [35]	.078 [3.0]	21 [67]		
	65030024	30	.945 [24]	1.575 [40]	.098 [2.5]	22 [73]		

Tooling for special application available upon request.  
2050mm, 2550mm, 3050mm & 4050mm available, please call for pricing.



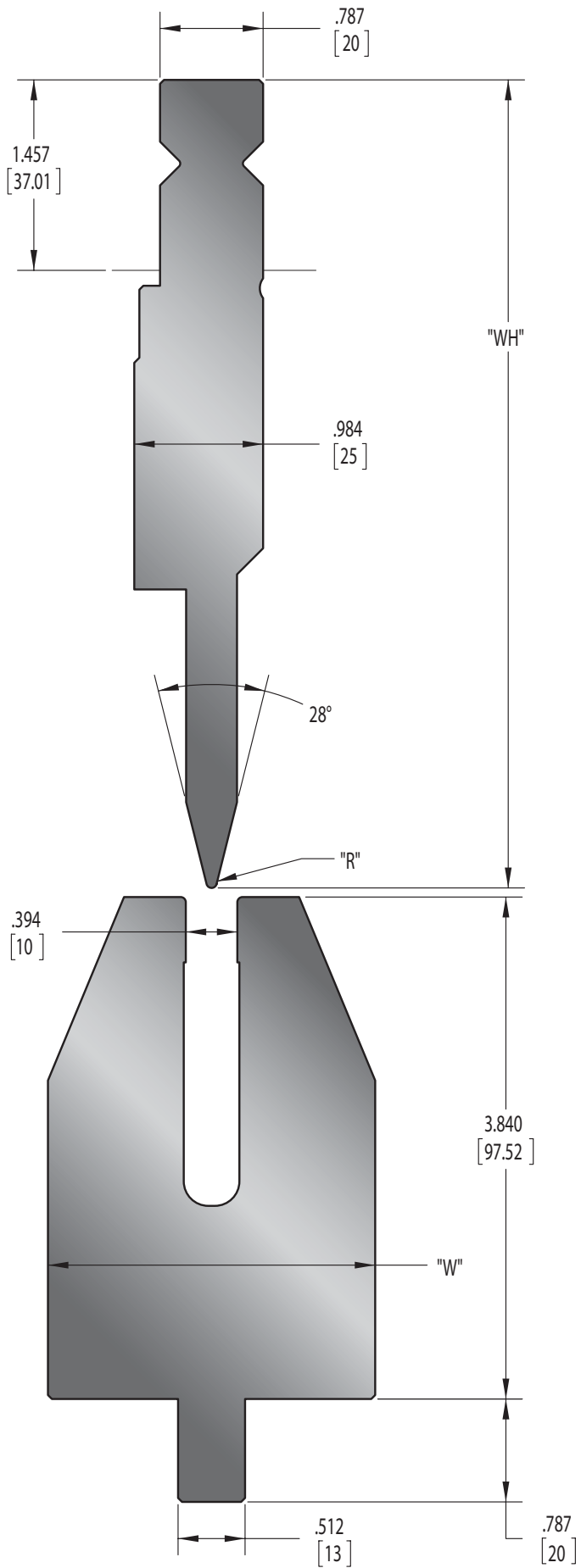
SERIES 650 86° DIES – 100mm [3.937"] TALL								
	Catalog #	A Angle	V Opening inch [mm]	W Width inch [mm]	SR Shoulder Radius	MAX TON feet [meter]	500 19.7 [500mm]	X Sectionalized 41.3 [1050mm]
STOCK	65086006	86	.236 [6]	.787 [20]	.024 [0.6]	14 [45]		
	65086008	86	.315 [8]	.787 [20]	.032 [0.8]	14 [45]		
	65086010	86	.394 [10]	.787 [20]	.039 [1.0]	17 [56]		
	65086012	86	.472 [12]	.984 [25]	.039 [1.0]	17 [56]		
	65086016	86	.630 [16]	1.181 [30]	.063 [1.6]	24 [79]		
	65086020	86	.787 [20]	1.181 [30]	.078 [3.0]	24 [79]		
	65086024	86	.945 [24]	1.378 [35]	.098 [2.5]	24 [79]		
	65086030	86	1.181 [30]	1.772 [45]	.118 [3.0]	26 [84]		
	65086040	86	1.575 [40]	2.165 [55]	.118 [3.0]	41 [135]		
	65086050	86	1.969 [50]	2.950 [75]	.118 [3.0]	41 [135]		

Tooling for special application available upon request.  
2050mm, 2550mm, 3050mm & 4050mm available, please call for pricing.



SERIES 650 80° DIES										
	Catalog #	A Angle	V Opening inch [mm]	H Height inch [mm]	W Width inch [mm]	SR Shoulder Radius	MAX TON feet [meter]	200 7.87 [200mm]	300 11.81 [300mm]	X Sectionalized 41.3 [1050mm]
STOCK	65080080	80	3.150 [80]	3.937 [100]	3.937 [100]	.197 [5.0]	41 [135]			
	65080100	80	3.937 [100]	4.724 [120]	4.724 [120]	.315 [8.0]	41 [135]			

Tooling for special application available upon request.  
2050mm, 2550mm, 3050mm & 4050mm available, please call for pricing.



28° TWO STAGE HEMMING PUNCH							
	Catalog #	R Tip Radius inch [mm]	A Angle	H Height inch [mm]	MAX TON feet [meter]	500 19.7 [500mm]	X Sectionalized 41.3 [1050mm]
STOCK	69528010	.039 [1.0]	28	5.512 [140.0]	30 [100]		
	60528010	.039 [1.0]	28	4.724 [120.0]	30 [100]		

- Tonnage is based on direct load and does not apply for thrusting applications.
- Maximum material is 16ga. Cold rolled steel

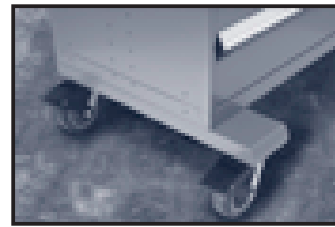
TWO STAGE HEMMING DIE						
	Catalog #	V V Opening inch [mm]	W Width inch [mm]	MAX TON feet [meter]	500 19.7 [500mm]	X Sectionalized 41.3 [1050mm]
STOCK	65530010	.394 [100]	2.362 [60]	30 [100]		N/A

- Tonnage is based on direct load and does not apply for thrusting applications.
- Maximum material is 16ga. Cold rolled steel

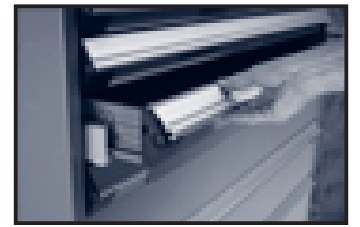


## Standard Features:

- Solid steel construction
- Mobile base with heavy duty casters with a rated capacity of 3600 pounds
- Lay-down storage allowing visibility of laser marking for easy tool identification
- Punches and dies can be stored as sets
- Safety interlock to prevent the opening of more than one drawer at a time
- Full width handles with end caps
- Protective label covers
- Retainer top with rubber mat
- Drawer dimensions listed below are useable space
- Industrial rubber mat in each drawer



Extended wheel base prevents the cabinet from tipping.



Individual latches on all drawers are easily activated with one hand.

Catalog #	Lead Time	Height inches	Width inches	Depth inches	Drawers Included			Price
					2" [50mm]	3" [76mm]	4" [101mm]	
90021	15 Days	51.5	48.0	27.0	2	6	2	

# URETHANE ROLLS

## Urethane Rolls For Mark-Free Bending

Catalog #	Dimensions	PRICE
42530	.015 [0.4] x 6" [152]	
42531	.030 [0.8] x 6" [152]	

Note: Urethane dies are also available for mark-free bending. Contact application sales desk for pricing and lead times.







## **PRESS BRAKE SPECIALS**

**Innovative  
Solutions  
for Challenging  
Applications.**



*Strength. Performance. Innovation.*



### **Nitrex™ Extends Tool Life.**

Wilson Tool's exclusive Nitrex high endurance surface enhancement increases press brake tooling life by several times that of ordinary tooling. Wilson's patented process provides a surface hardness of HRC-70, increasing long-term durability and minimizing galling in even the toughest bending applications.

Nitrex also adds lubricity to press brake tooling that lowers friction, effectively minimizing galling. Unlike ordinary press brake tooling Nitrex treated tools experience zero corrosion, resulting in faster cleanups and longer lasting tooling.

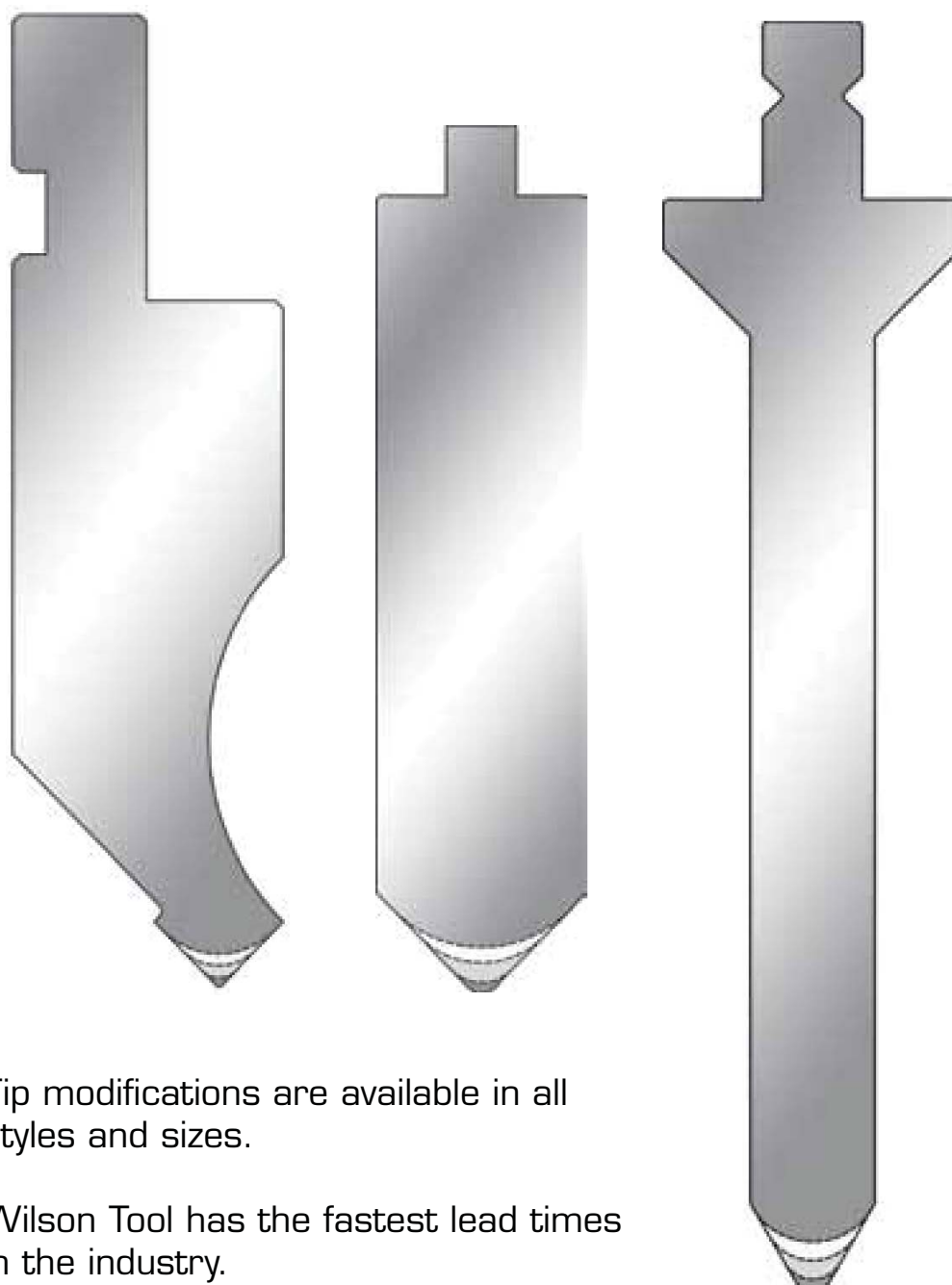
### **Laser Hardening Optional.**

Wilson Tool now offers optional laser hardening to further improve heat and wear resistance of press brake tooling. Laser hardening is ideal for high wear applications.

## **TABLE OF CONTENTS**

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Forming . . . . .	9
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## **TIP MODIFICATIONS**

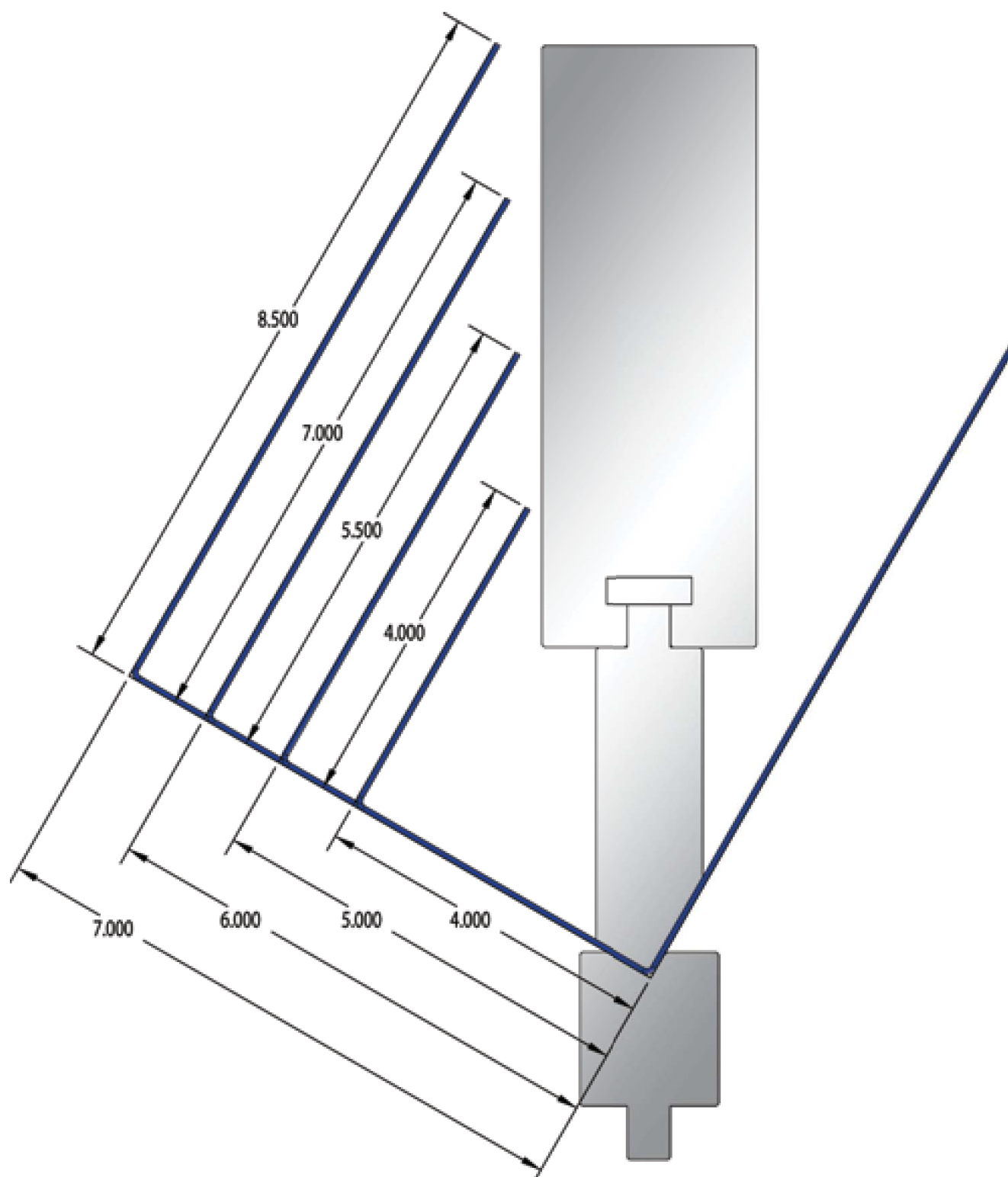


Tip modifications are available in all styles and sizes.

Wilson Tool has the fastest lead times in the industry.



## 30 - 60 – FOR DEEP BOX BENDING

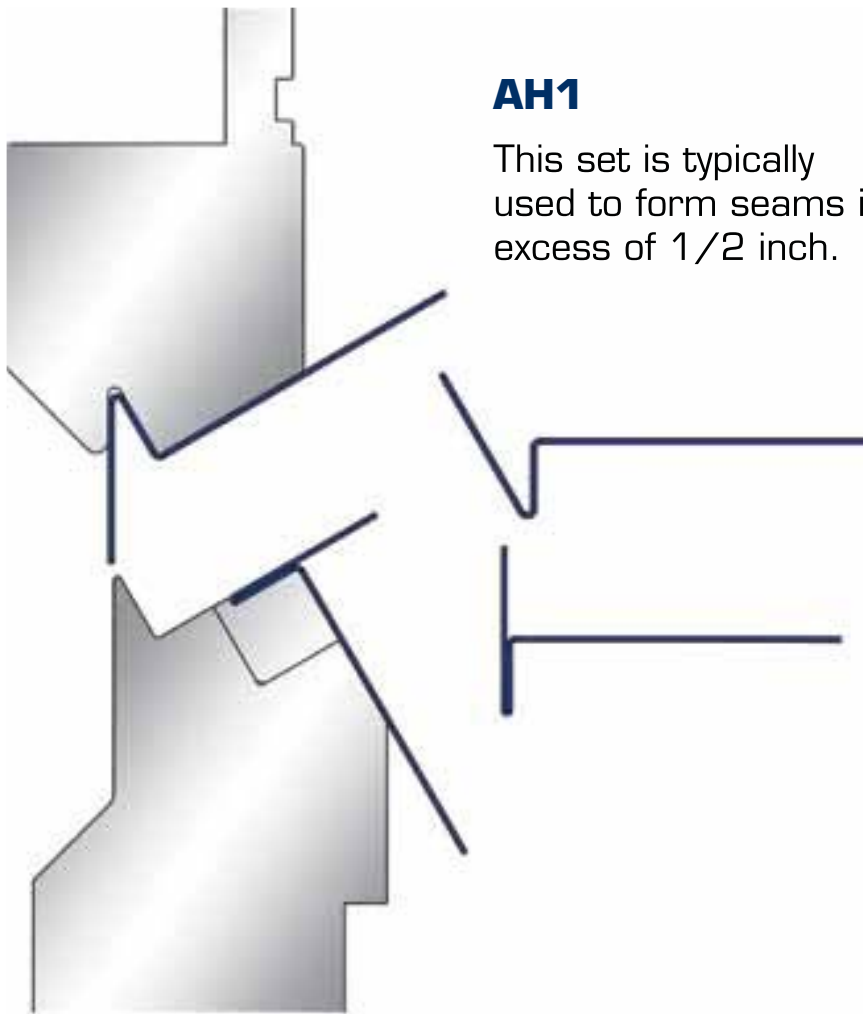


### 30/60

When forming a four-sided box, the punch must be sufficient height to prevent the pre-formed side from striking the upper beam.

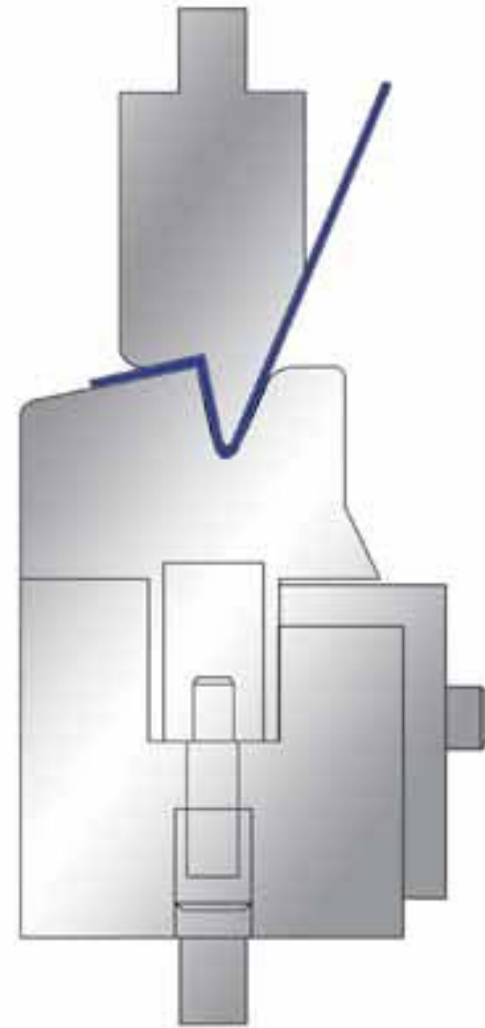


## CUSTOM HEMMING



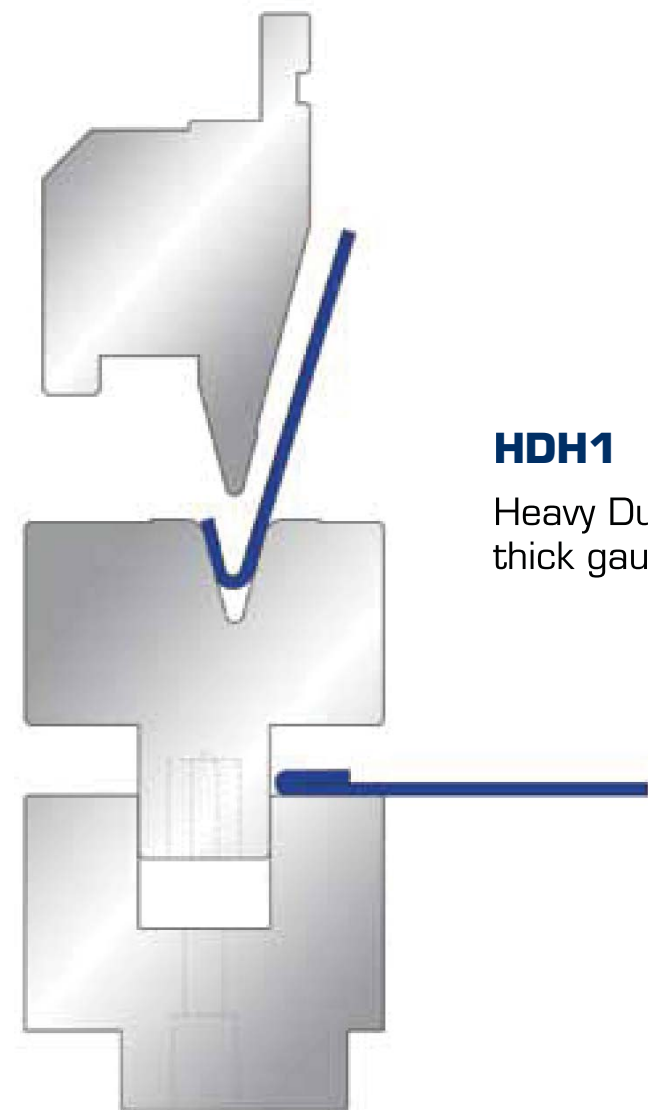
### AH1

This set is typically used to form seams in excess of 1/2 inch.



### SSH1

This set is used to form a standing seam in 2 strokes. The first stroke forms an acute angle offset, the second stroke closes the seam.

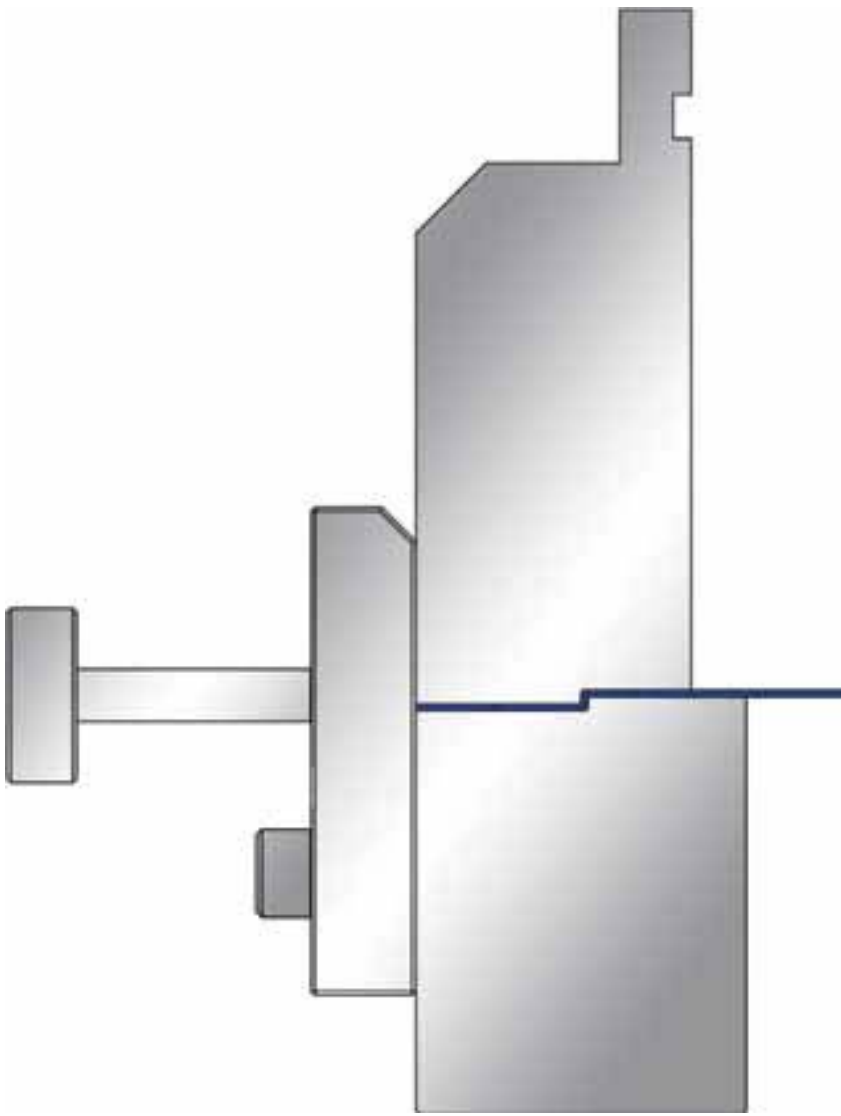


### HDH1

Heavy Duty Hemming for thick gauge applications.



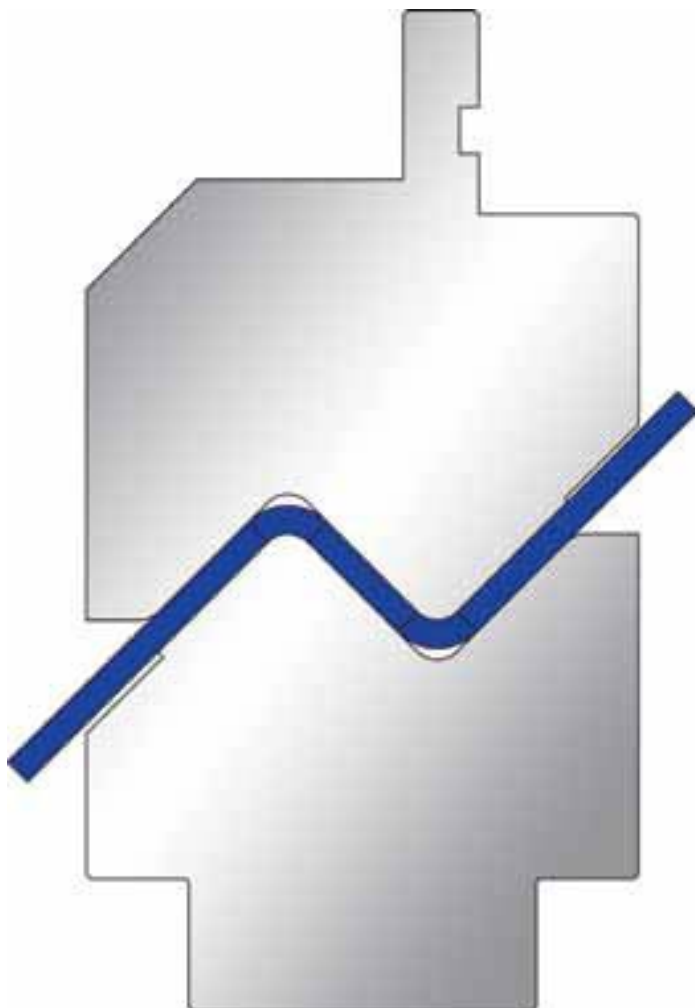
## OFFSET



### H Offset

#### H01

This set is used when forming offsets that are approximately one material thickness. Prevents material whip up. Thrust plates and adjustable back gauging are provided.



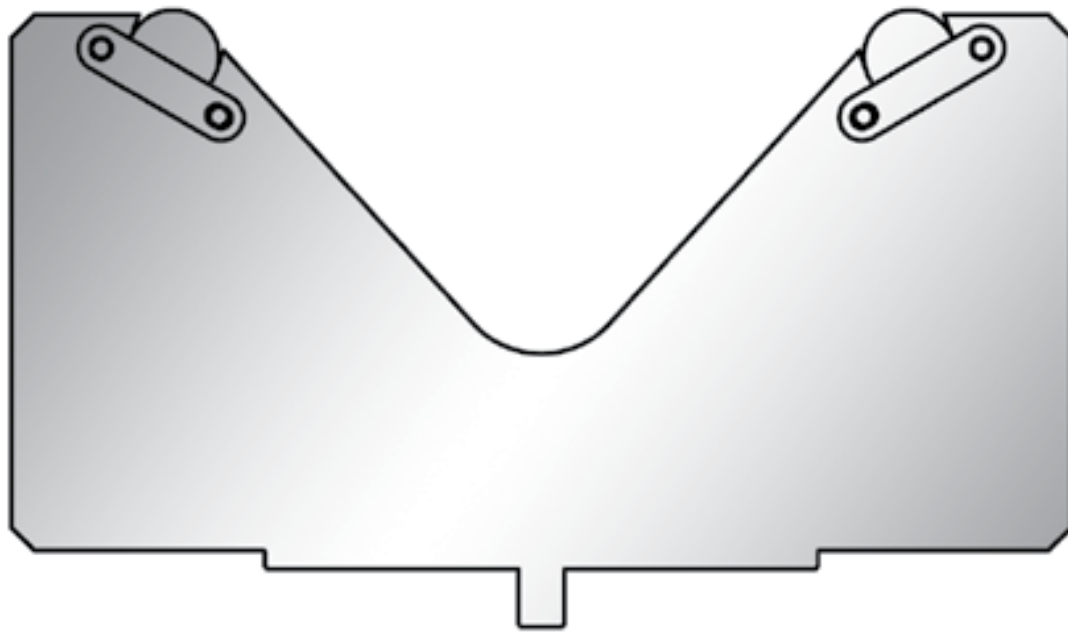
### Large Offset

#### L01

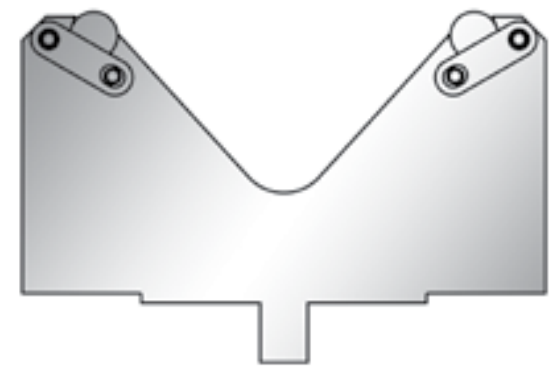
This set is used for heavy gauge, large offset bending.



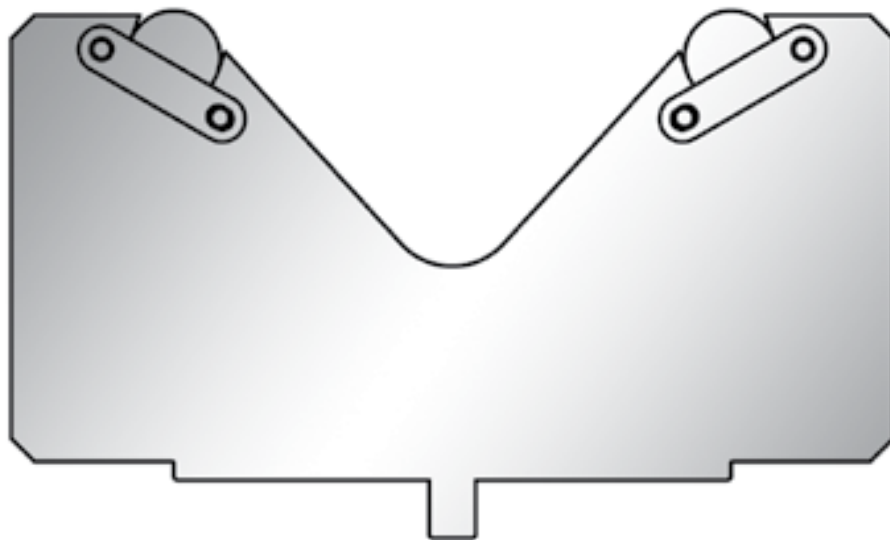
## ROLLING SHOULDER DIE



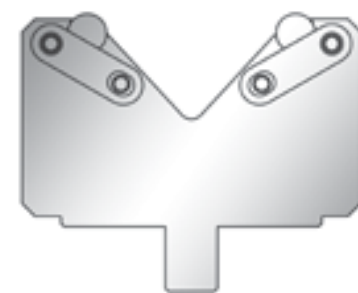
8" V



4" V



6" V



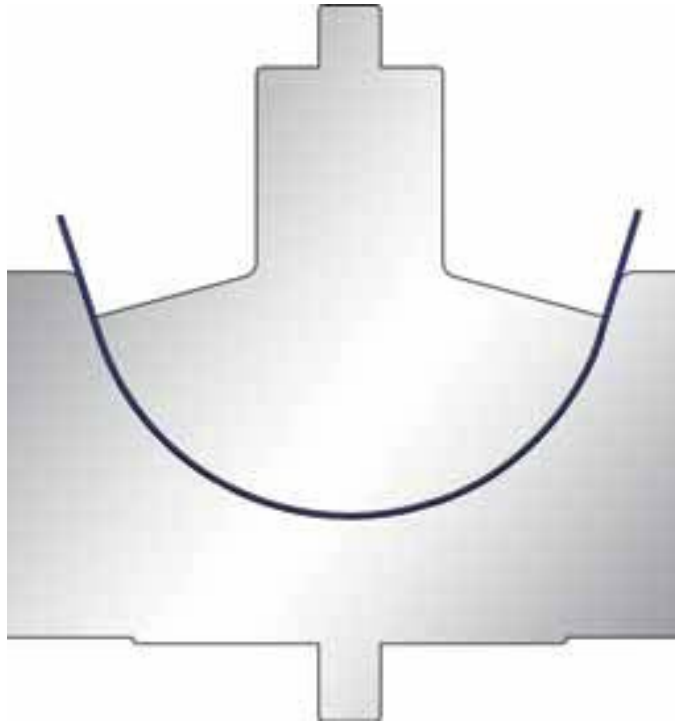
2" V

Insertable shoulder dies are ideal for extreme wear conditions created then forming heavy plate and abrasive materials.

Replaceable inserts eliminate the need for replacing the entire die when the die shoulders wear.

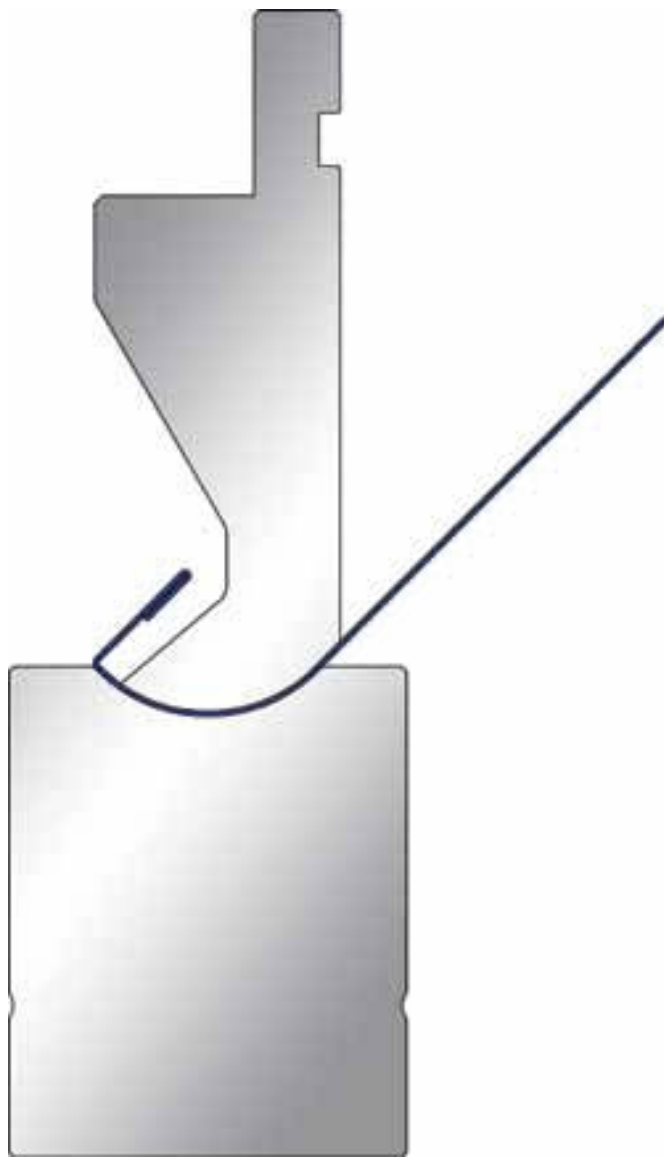
Available in multiple V sizes and 75° and 85° configurations.

## LARGE RADII



### LR1

This is a 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.



### LR2 Multi Hit Rad

This set is used when a full radius is required before the flange. May require multiple strokes.



### LR3 Multi Hit Rad

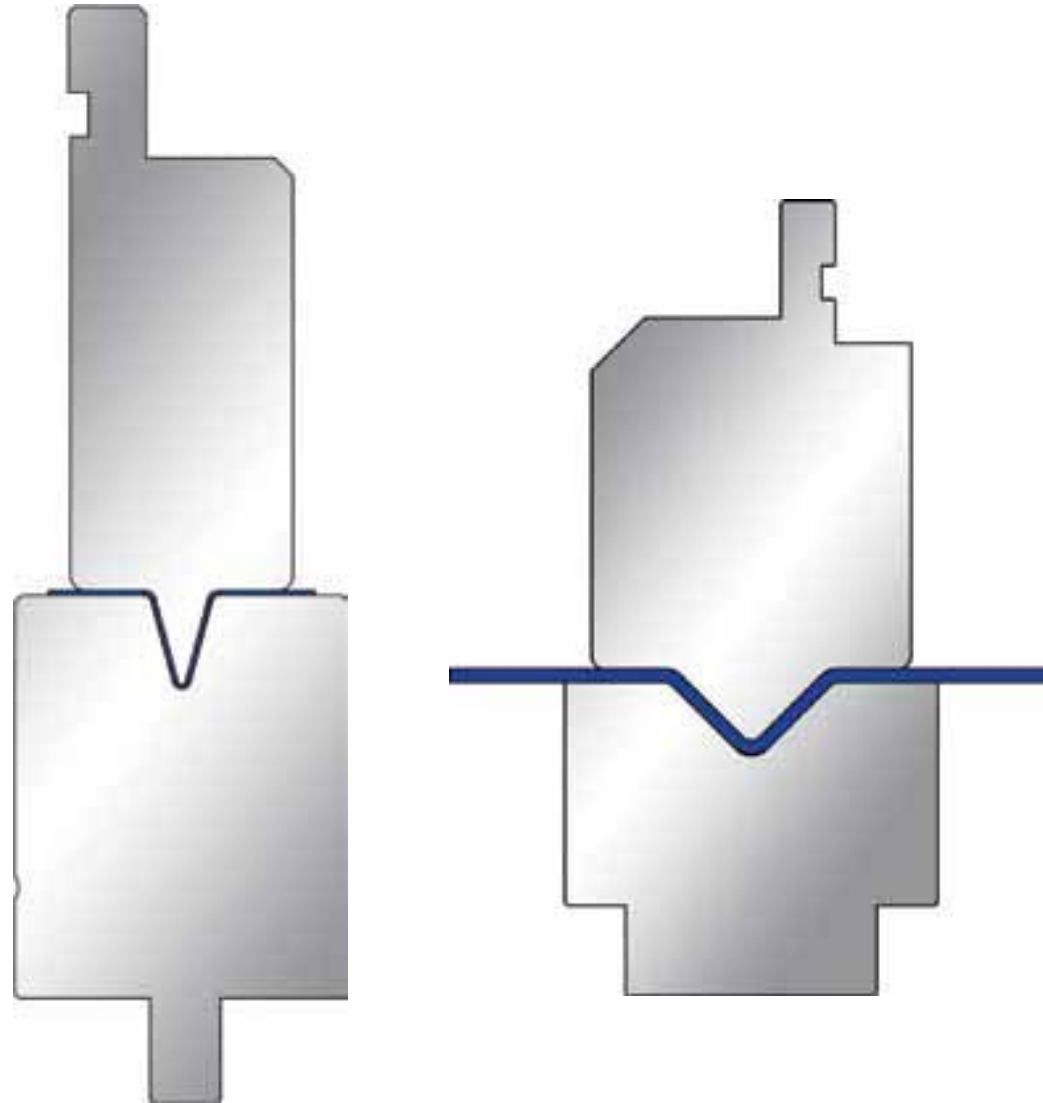
This set is used when the return flange starts at the radius end. May require multiple strokes.



## V-RIB / STRENGTHENING RIB

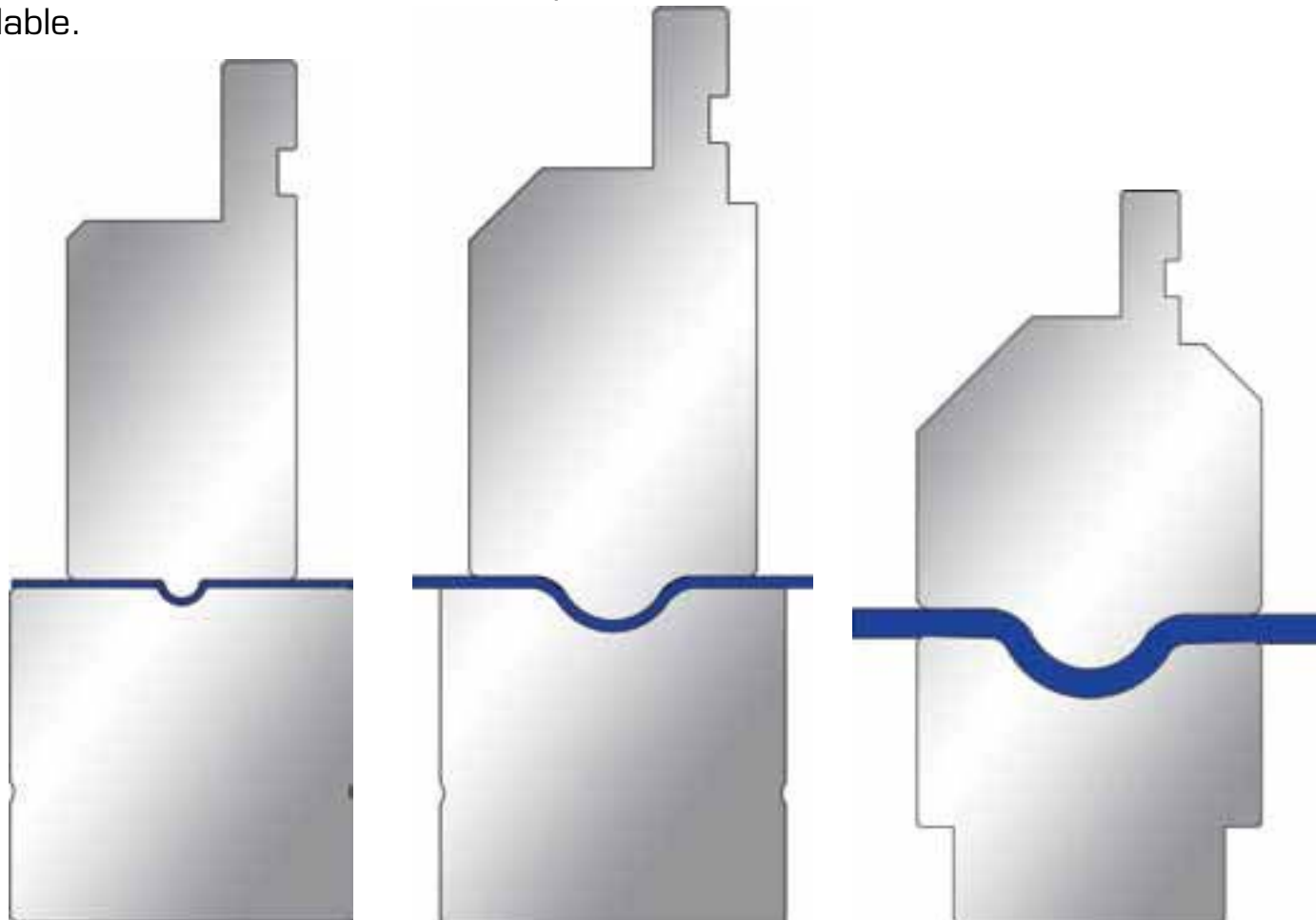
### VR1

These sets produce a v-rib in one stroke. Spring back allowance is built in.

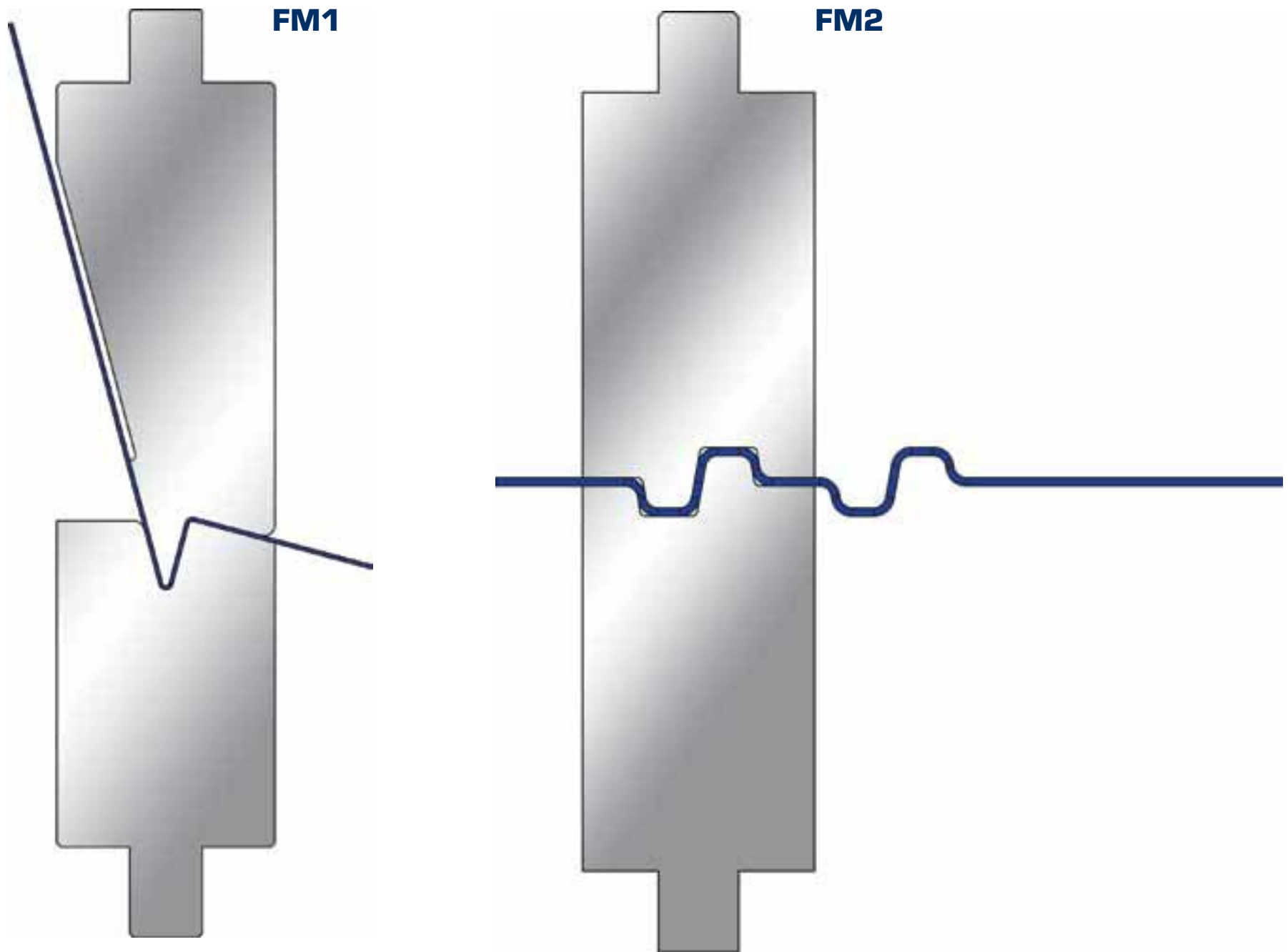


### SR1

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

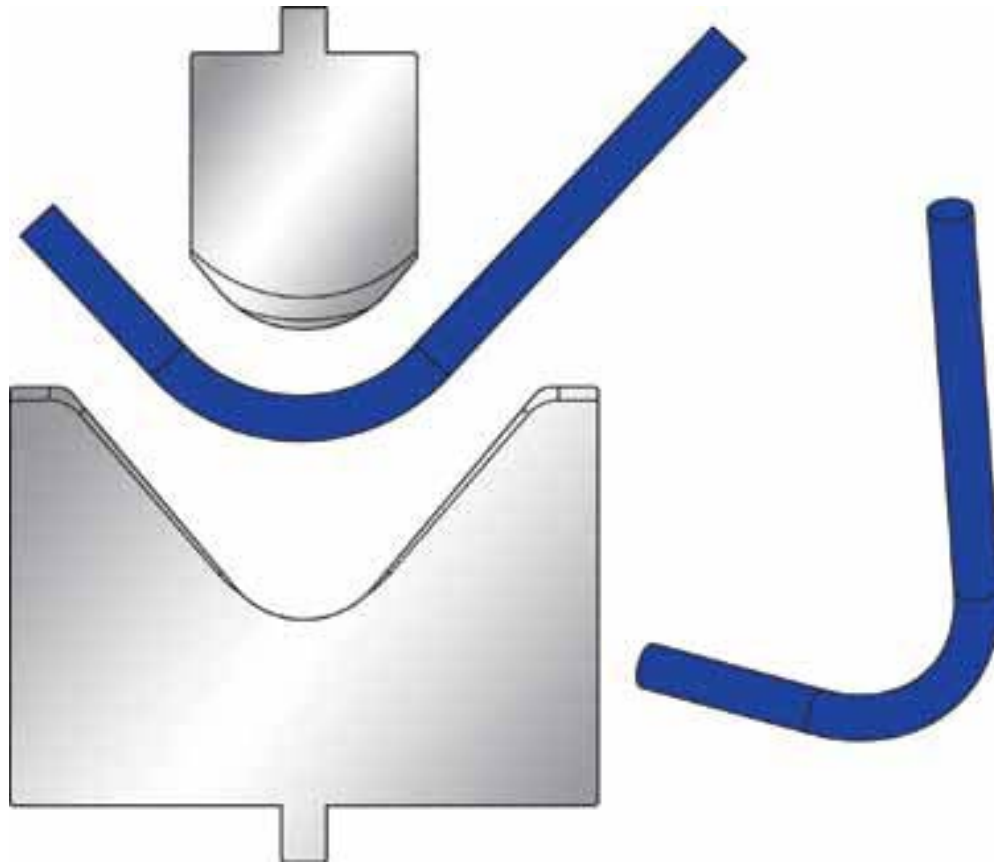




**FORMING**

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

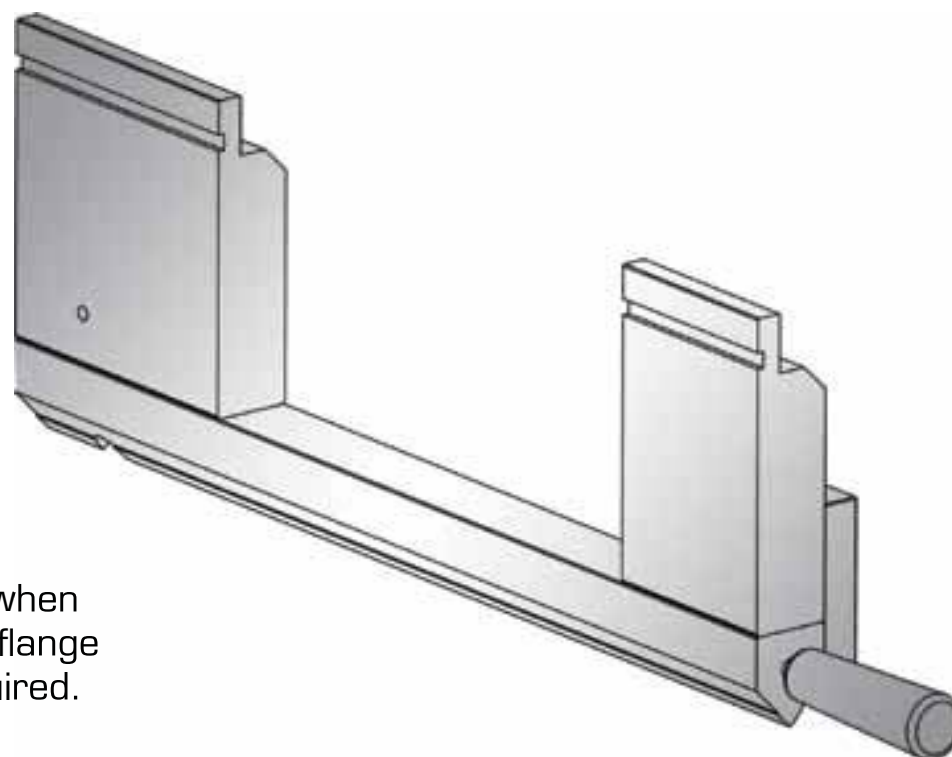
## ROD BENDING



### RB1

These sets provide nesting for the rod during the forming process.

## WINDOW



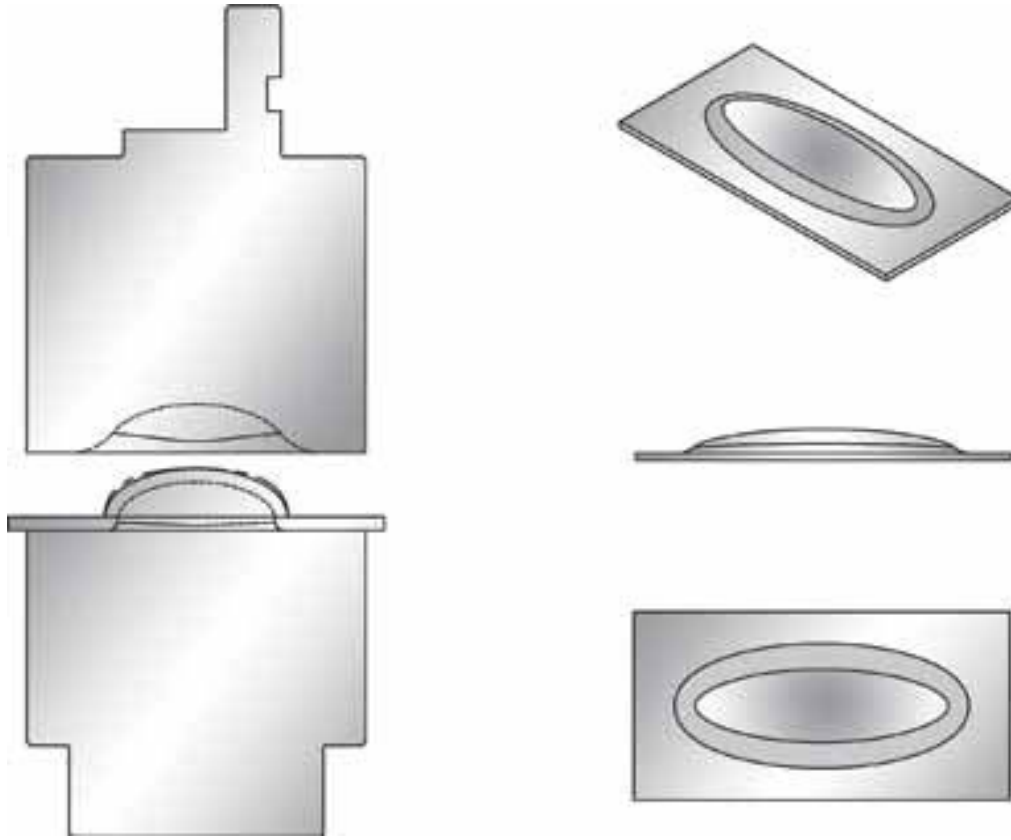
### W1

This set is used when minimum return flange clearance is required.



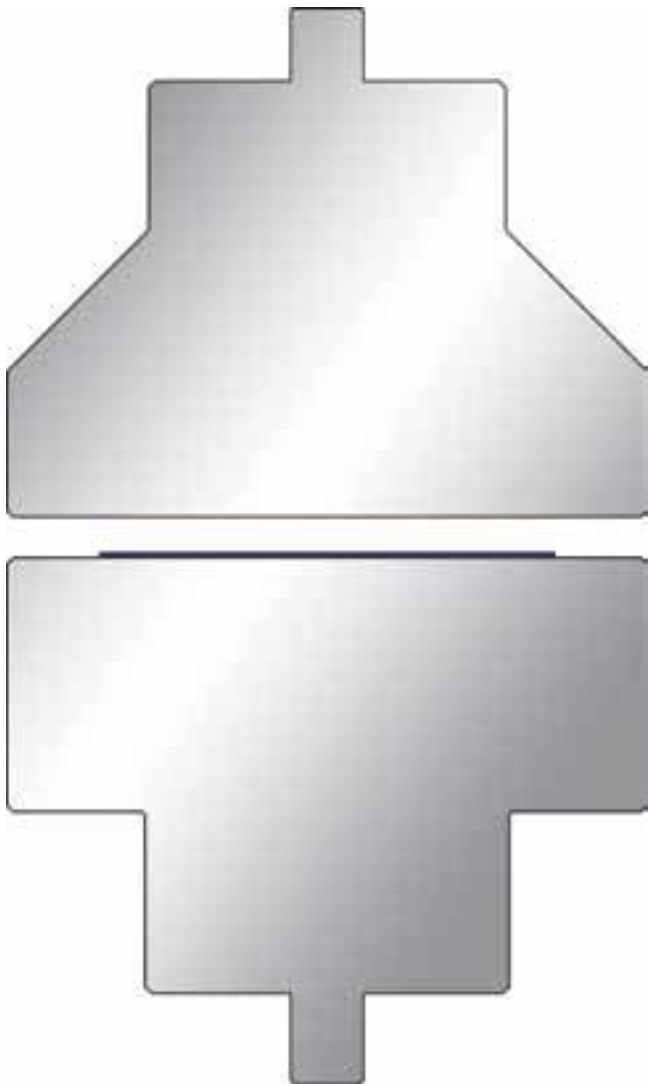
# STAMPING

## EMBOSS & LOGO



### EM1

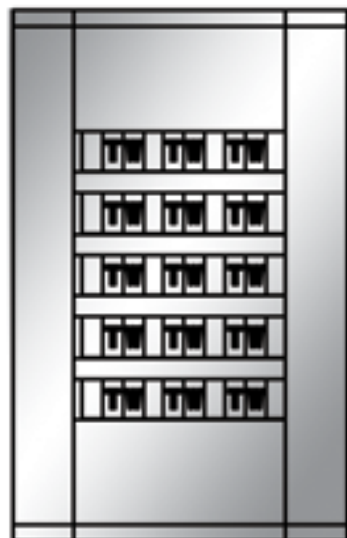
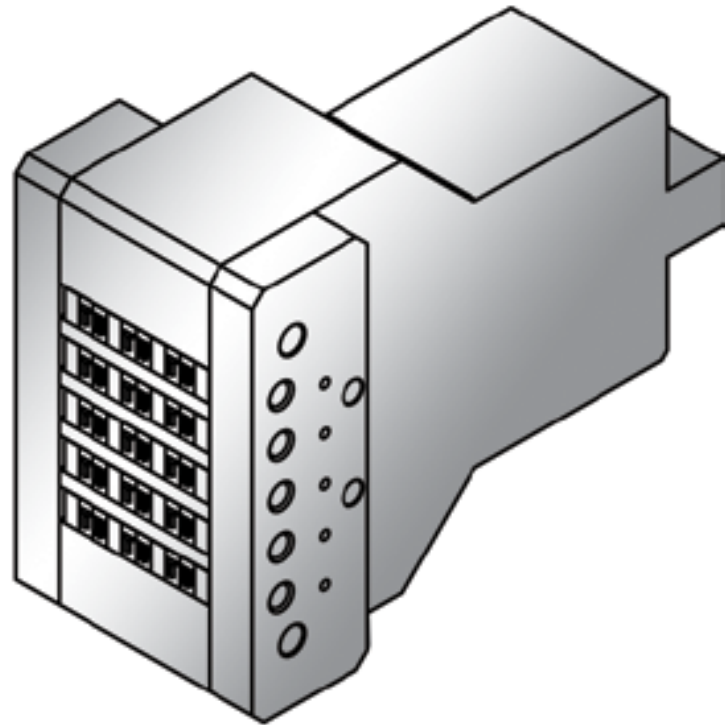
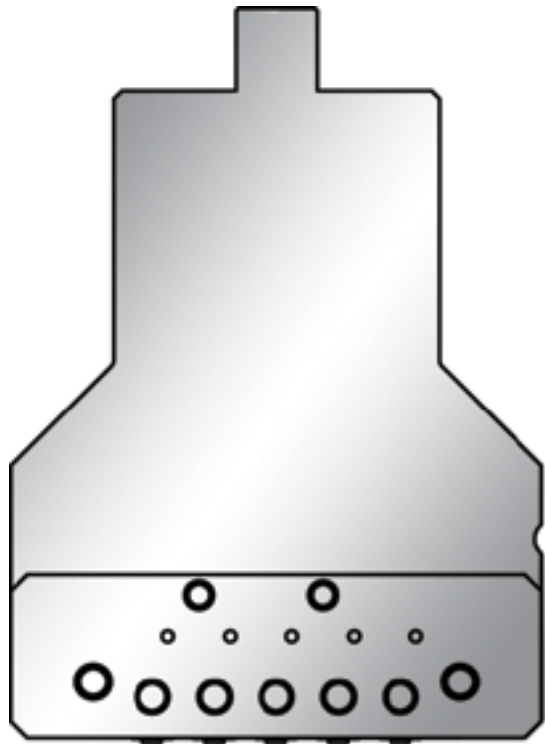
A variety of raised emboss and chisel point emboss sets are available.



### LG1

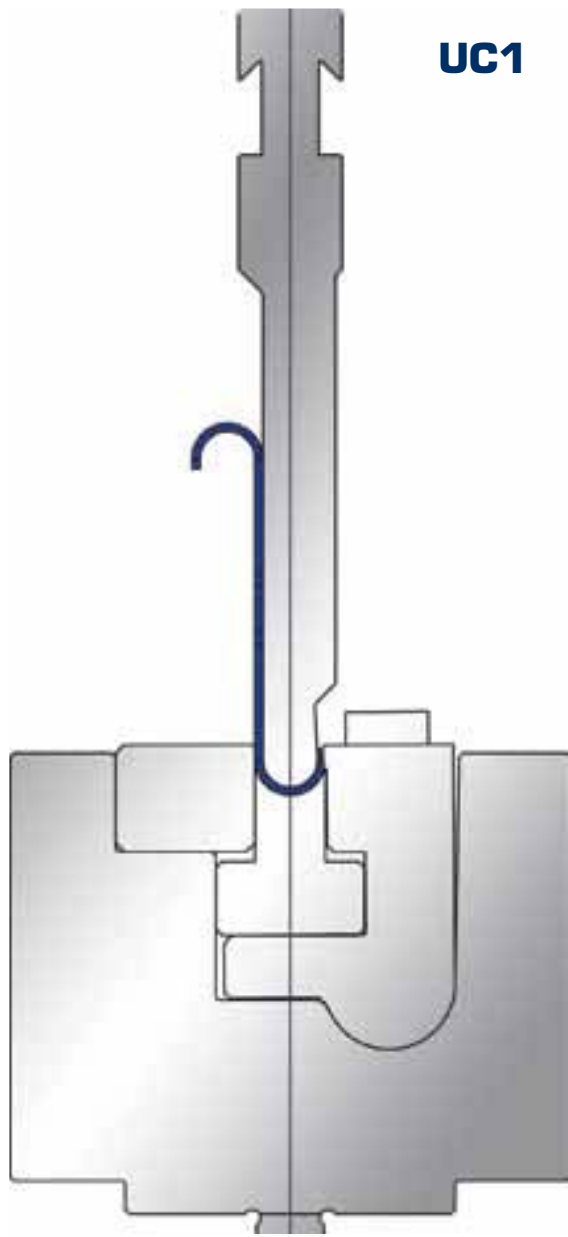


## LETTERSTAMP

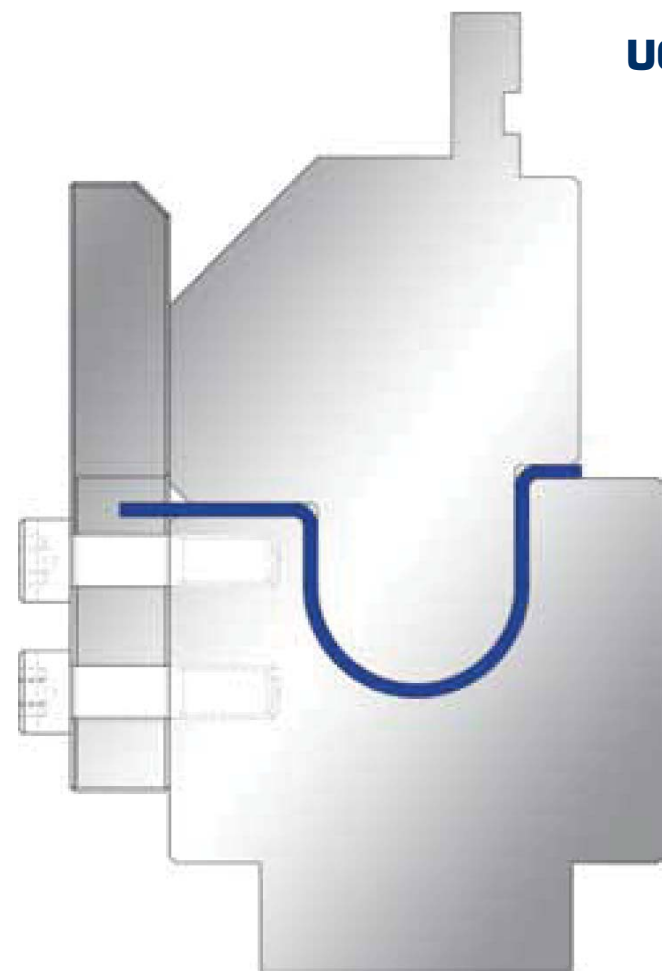
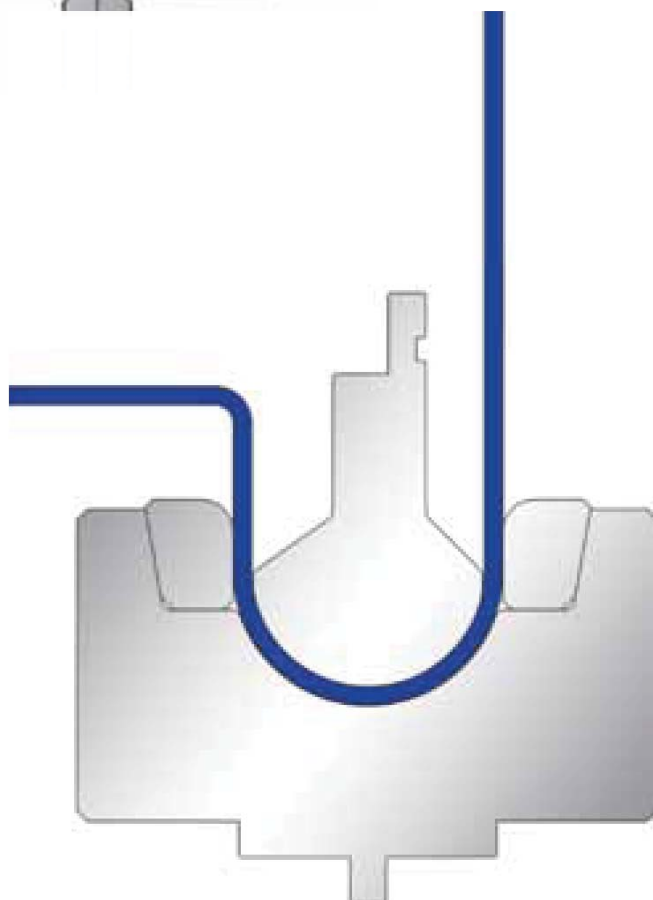


### LS1

This set provides chisel point embossing with interchangeable characters. Single row or multi row available.

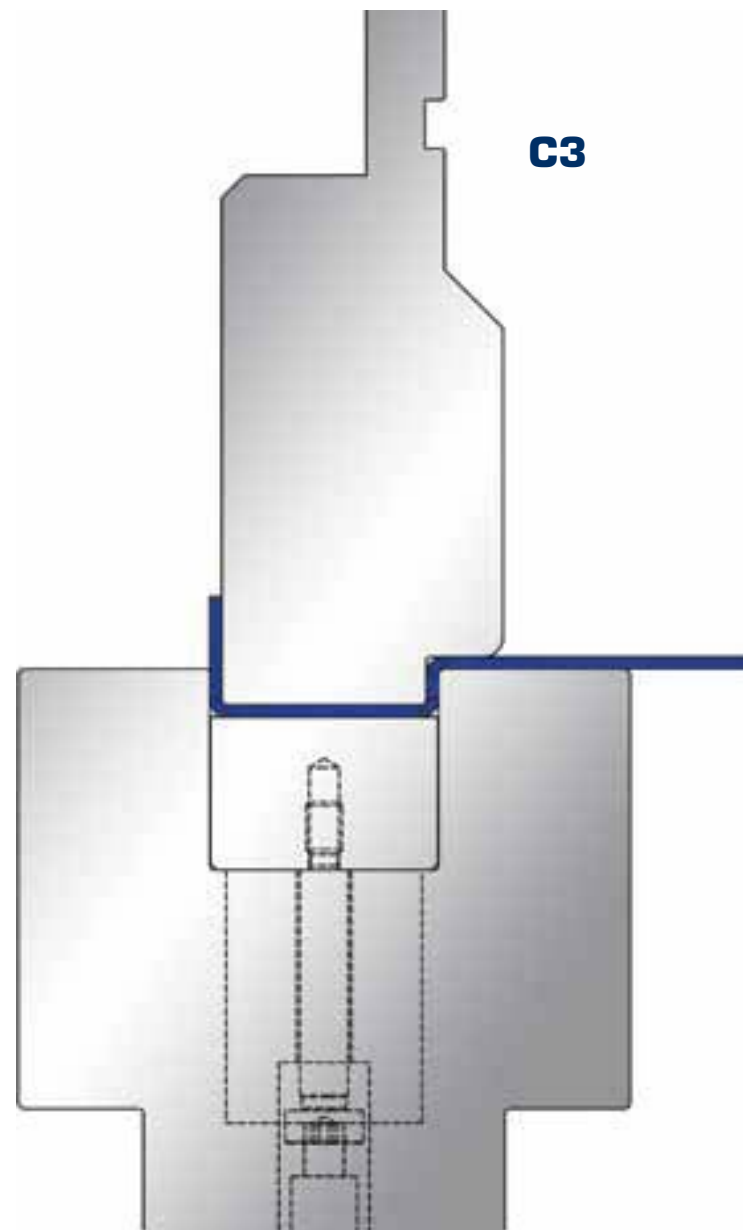
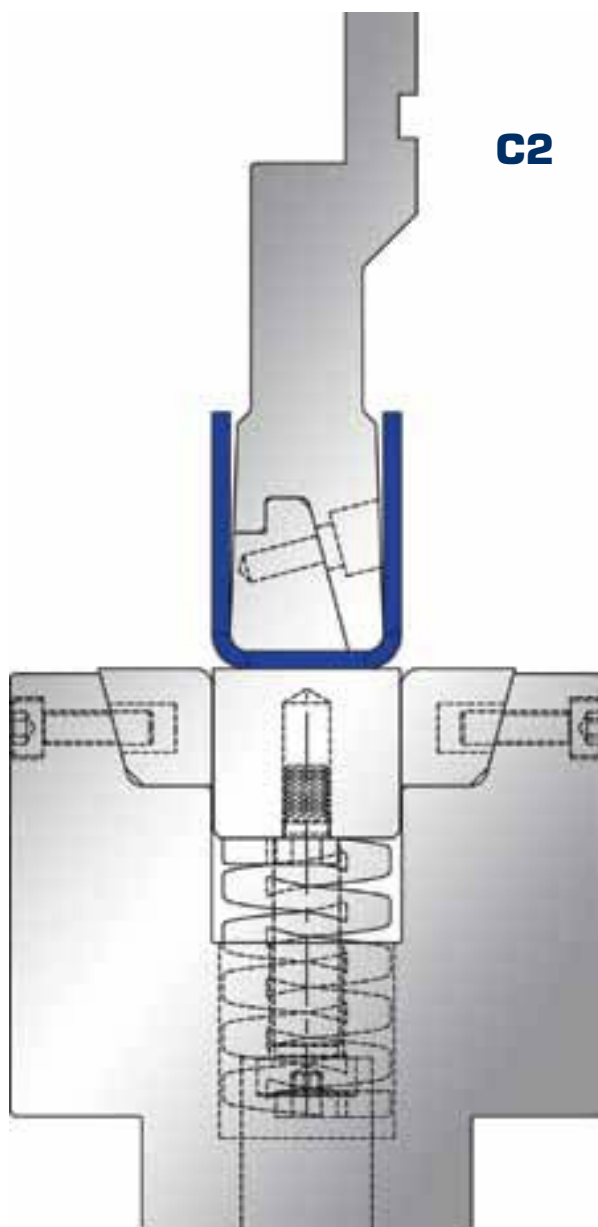
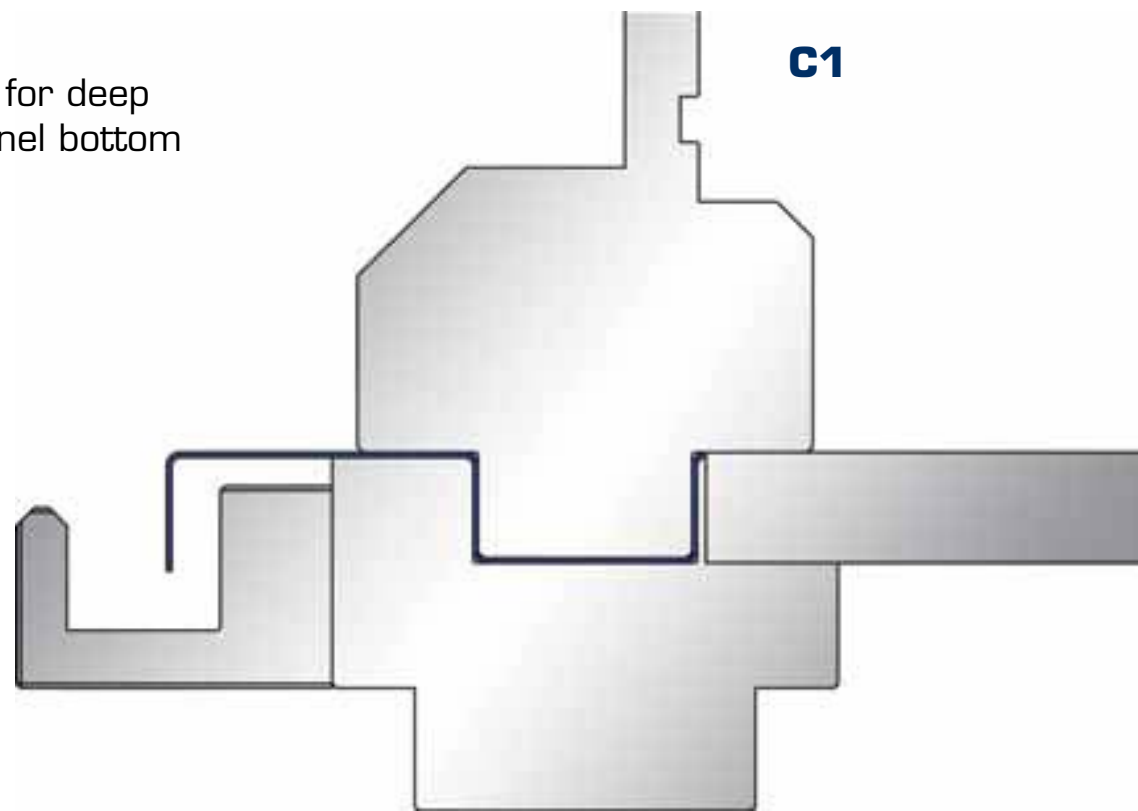
**CHANNEL****UC1**

These sets are recommended for applications where considerable spring back is encountered. Secondary flattening operations may be required.

**UC2****UC3**

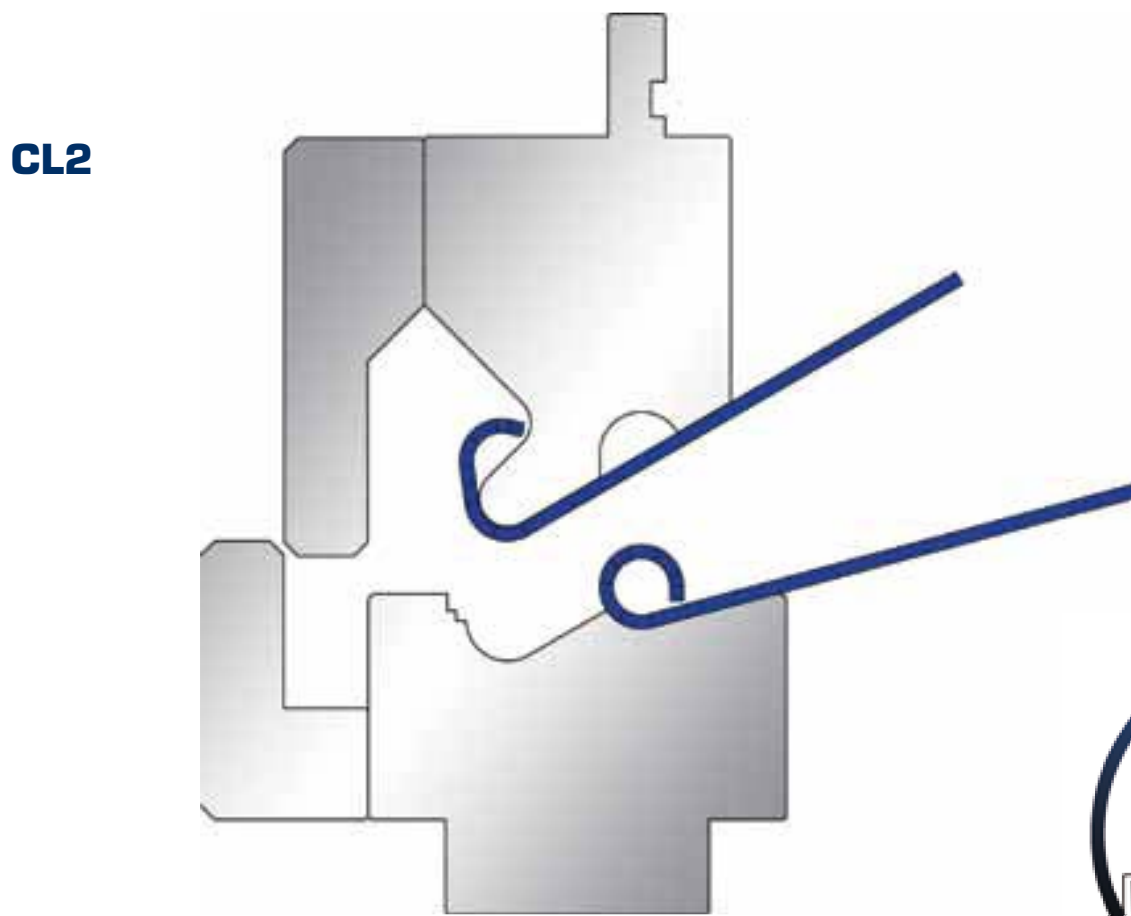
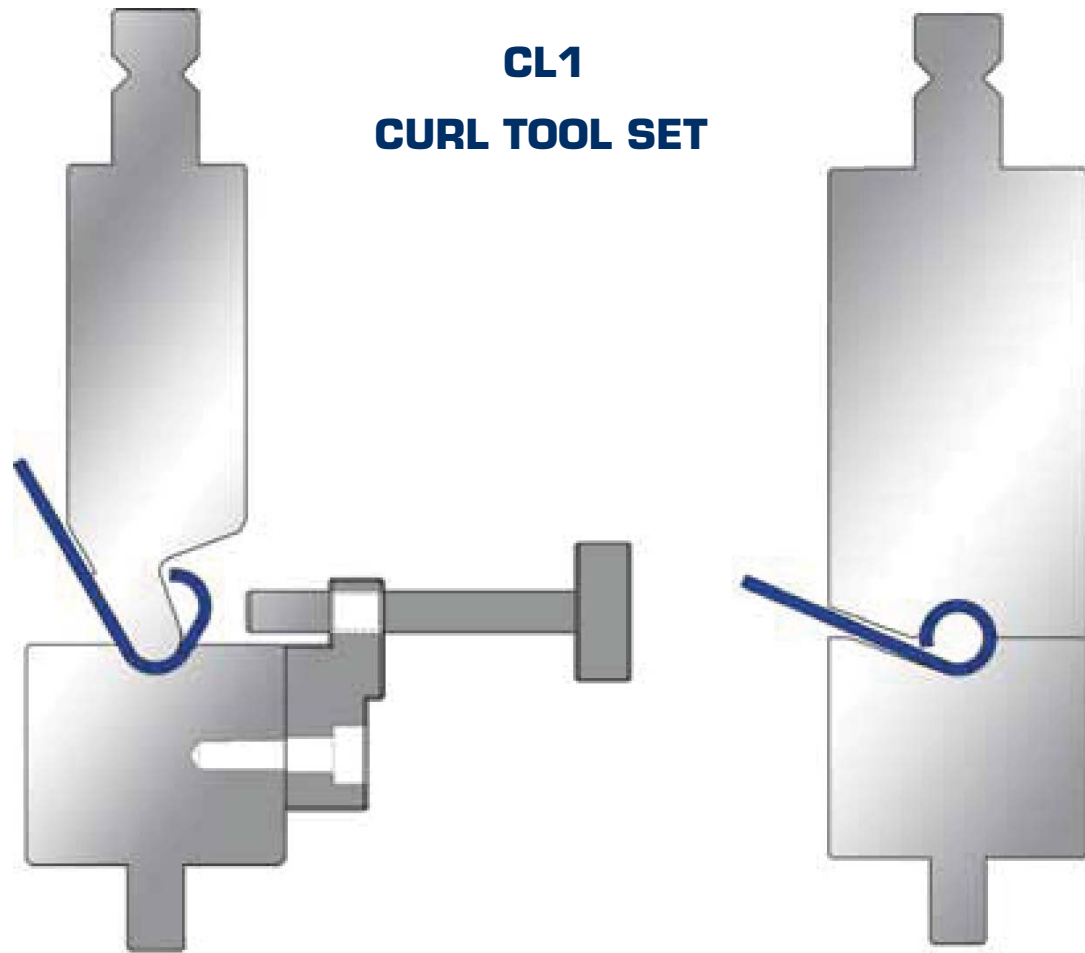
## CHANNEL

These sets are required for deep channels when the channel bottom needs to remain flat.

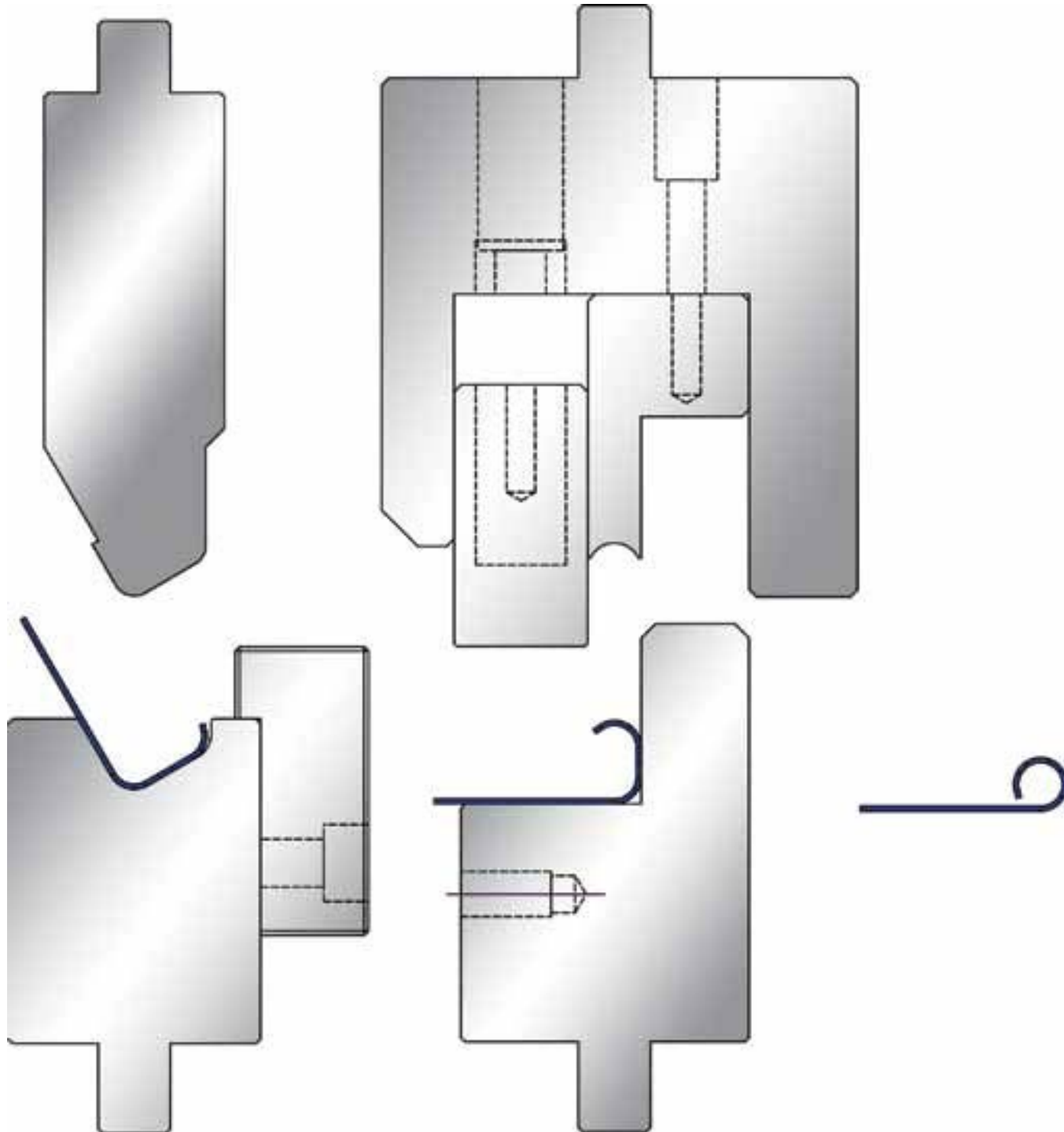


## CURL

MECHANICAL



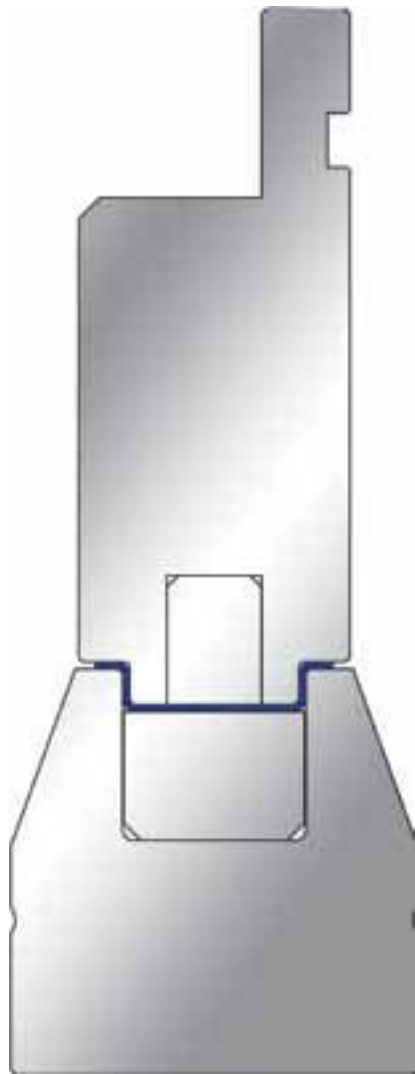
## CURL



### CL3

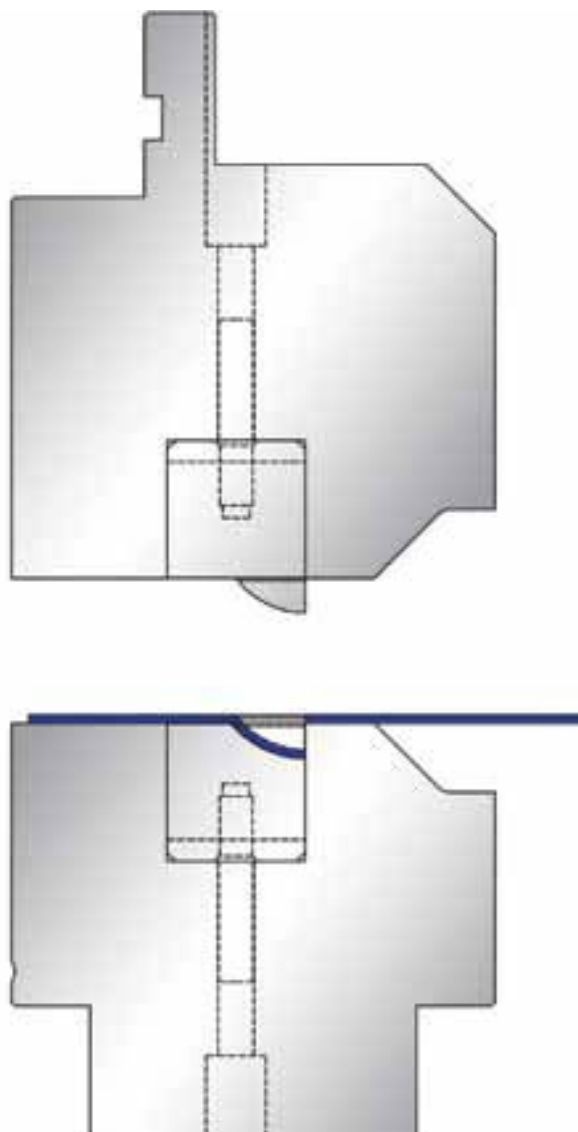
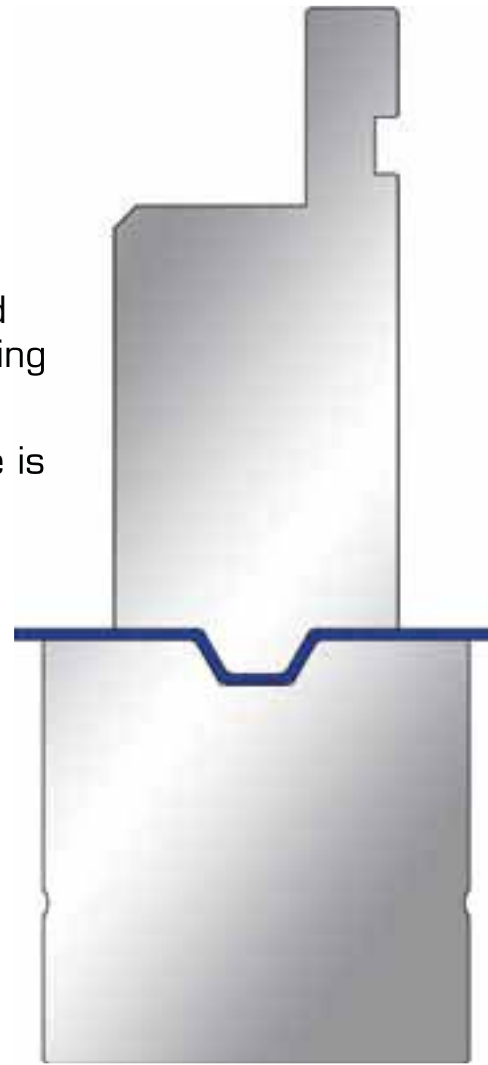
These sets are used for hinges and corner beading.  
Call for specific application recommendations.



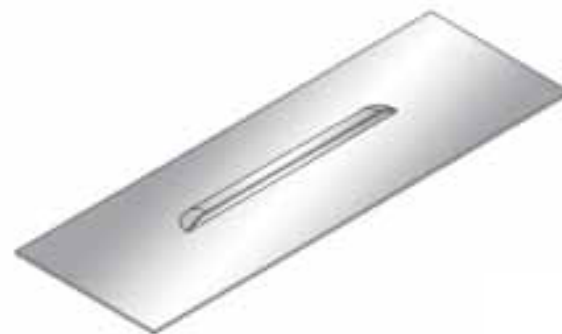
**HAT CHANNEL, LOUVER****HT1**

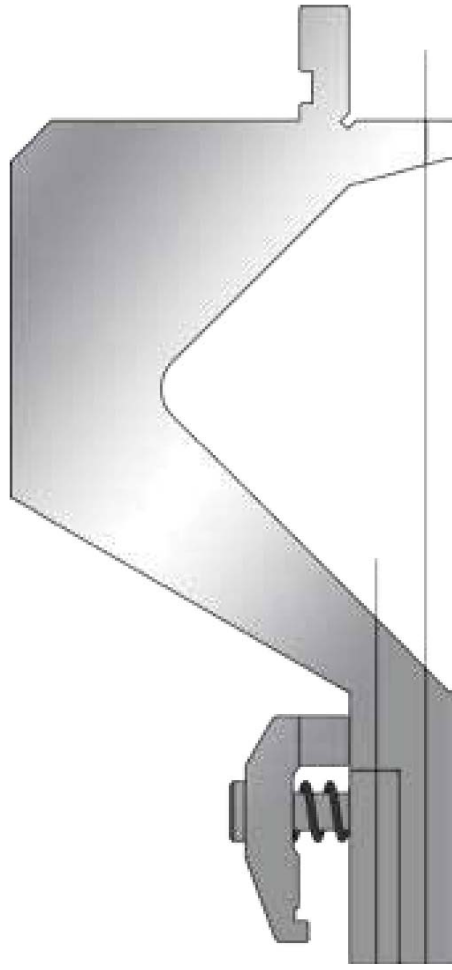
These sets provide straight wall or angled wall hat channel bending in one stroke.

Spring back allowance is built in.

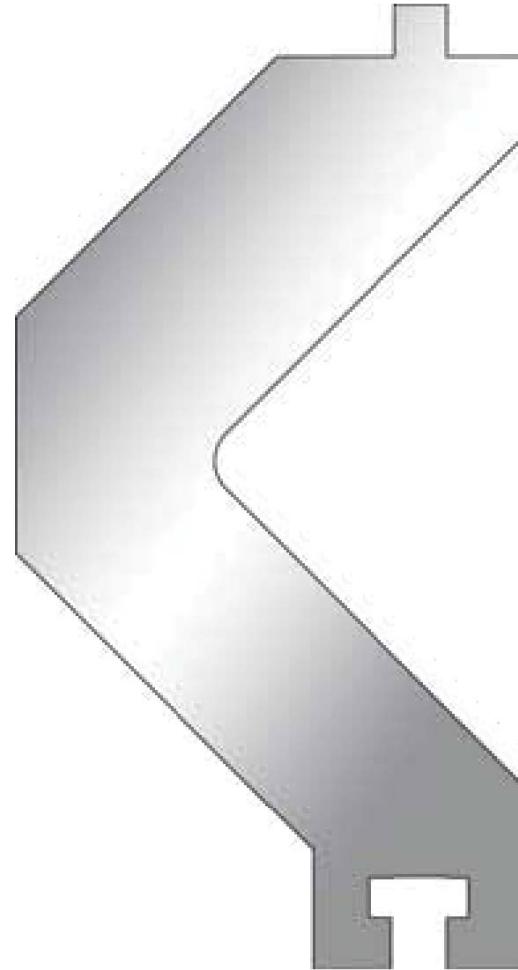
**LL1**

Multiple louver configurations are available. For louver forming, sheet perforation is required.

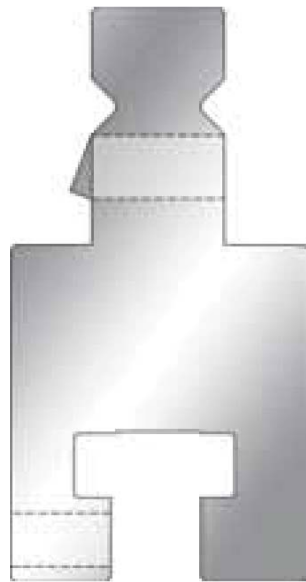




**43002**  
**Euro Z1 or Z2 Clamping**



**AM Gooseneck Holder**






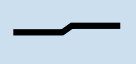





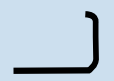

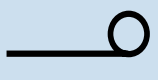

**WT - American**



**AM Self Seat**

## Press Brake Multiple Bend Allowances and Tonnage Estimates

*Formula for making multiple bends on a press brake. For shape as shown, in mild steel with radii equal 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
	MT'L THK OFFSET	300	600
	CHANNEL	225	300
	VEE RIB	200	600
	W DIE	300	600
	OPEN HAT CHANNEL	300	450
	SQ HAT CHANNEL	---	600
	PREFORM CURL	---	300
	PREFORM CURL	---	200
	CLOSE CURL	---	300
	RADIUS	---	180/300
Shape Considerations		Large Radii Angle Variation Concave or Convex Sides	Mat'l Thk. Radii Min. Angle Variation Maintain Flatness

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



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