

Wilson Tooling System for Pullmax machines

July 2006





The New Standard In Tooling Performance!!!

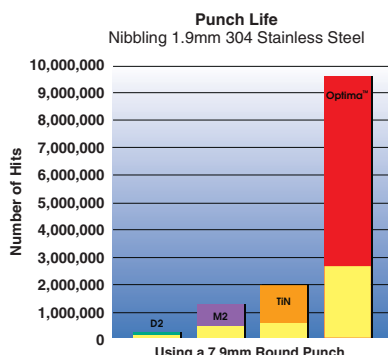
Optima™ is a proprietary TiCN (titanium carbo-nitride) coating that was custom engineered for Wilson Tool. It features unique properties that significantly enhance tooling performance. This coating, which is available only to Wilson Tool customers, provides a level of surface hardness, wear resistance and lubricity never before associated with coated or uncoated punch tooling.



Some of the many benefits that you will enjoy with our Optima™ coating include:

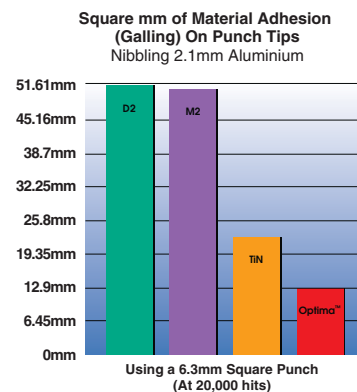
- Longer tool life
- Increased wear resistance
- More hits between sharpenings
- Reduced adhesion (galling)
- Reduced slug pulling
- Reduced corner breakdown
- Improved special tooling performance
- Lower overall tooling costs
- In-house coating facilities allow us to deliver faster and maintain total quality control

Punch Life

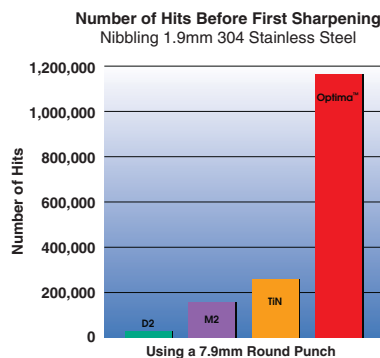


The yellow area indicates actual results achieved through three tool sharpenings of 0.25mm each. The complete graph indicates projected results with a total of 6mm removed for sharpening.

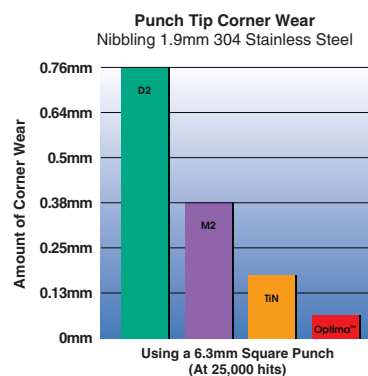
Material Adhesion

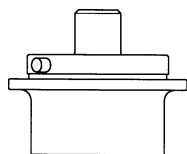
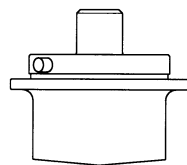
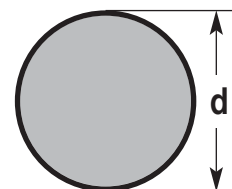


Number of Hits



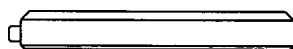
Tip Wear



**PUNCH HSS****SHEAR****STANDARD****TOOLS****ROUND**

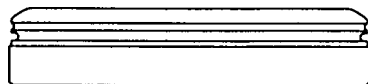
"d" Dimension	Cat. No.	Price	Cat. No.	Price	Add-on for Optima™
1.50 - 30.00	25768		25769		
30.01 - 40.00	25774		25775		
40.01 - 56.00	25780		25781		
56.01 - 66.00	25786		25787		
66.01 - 76.20	25792		25793		
*76.21 - 90.00	62140		62141		

* Requires a keyed collar # 25573

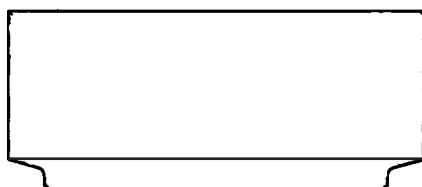
**241 DIE BLADE**

"d" Dimension	Cat. No.	Price
1.50 - 40.00	25980	
40.01 - 56.00	25982	

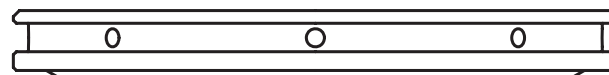
NOTE: Long Tooling can be used, but only with Urethane strippers. This requires a special holder. When long tools have been ground by 0.5mm they can be used with a metal stripper. For further information, please contact our Sales Desk.

**DIE**

"d" Dimension	Cat. No.	Price
1.50 - 30.00	25005	
30.01 - 76.20	25024	
76.21 - 90.00	62139	

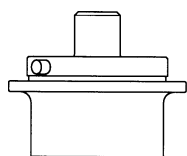
**URETHANE STRIPPER**

"d" Dimension	Cat. No.	Price
1.50 - 30.00	62133	
30.01 - 76.20	62132	

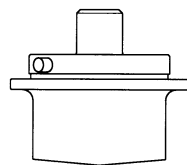
**METAL STRIPPER**

"d" Dimension	Cat. No.	Price
1.50 - 76.20	62144	
76.21 - 90.00	62126	

2



PUNCH HSS



FLAT



STANDARD

TOOLS

SQUARE

"a" Dimension	Cat. No.	Price	Cat. No.	Price	Add-on for Optima™
1.50 - 21.22	25814		25816		
21.23 - 28.29	25820		25822		
28.30 - 39.60	25826		25828		
39.61 - 46.68	25832		25834		
46.69 - 53.90	25838		25840		
*53.91 - 63.65	62142		62143		

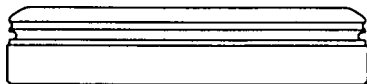
* Requires a keyed collar # 25573



241 DIE BLADE

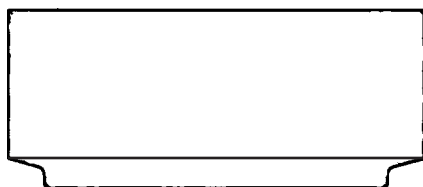
"a" Dimension	Cat. No.	Price
1.50 - 28.29	25979	
28.30 - 39.60	25981	

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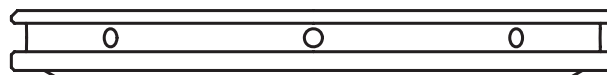
DIE

"a" Dimension	Cat. No.	Price
1.50 - 21.22	25483	
21.23 - 53.90	25519	
53.91 - 63.65	62127	



URETHANE STRIPPER

"a" Dimension	Cat. No.	Price
1.50 - 21.22	62133	
21.23 - 53.90	62132	



METAL STRIPPER

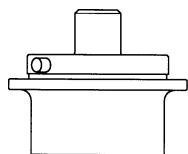
"a" Dimension	Cat. No.	Price
1.50 - 53.90	62145	
53.91 - 63.65	62126	

520

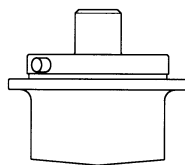
530

720

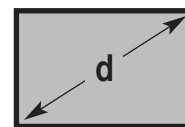
730



PUNCH HSS

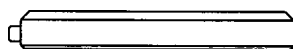


SHEAR


**STANDARD
TOOLS
RECTANGLE**

"d" Dimension	Cat. No.	Price	Cat. No.	Price	Add-on for Optima™
1.50 - 30.00	25815		25817		
30.01 - 40.00	25821		25823		
40.01 - 56.00	25827		25829		
56.01 - 66.00	25833		25835		
66.01 - 76.20	25839		25841		
*76.21 - 90.00	62142		62143		

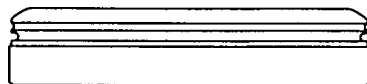
* Requires a keyed collar # 25573



241 DIE BLADE

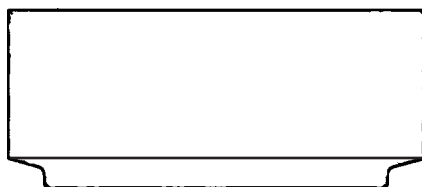
"d" Dimension	Cat. No.	Price
1.50 - 40.00	25979	
40.01 - 56.00	25981	

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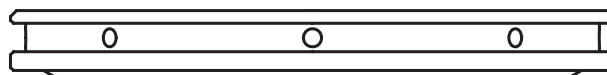
DIE

"d" Dimension	Cat. No.	Price
1.50 - 30.00	25484	
30.01 - 76.20	25520	
76.21 - 90.00	62127	



URETHANE STRIPPER

"d" Dimension	Cat. No.	Price
1.50 - 30.00	62133	
30.01 - 76.20	62132	



METAL STRIPPER

"d" Dimension	Cat. No.	Price
1.50 - 76.20	62145	
76.21 - 90.00	62126	

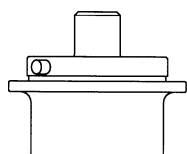
4

520

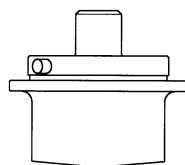
530

720

730



PUNCH HSS



SHEAR

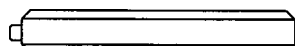
**STANDARD
TOOLS
ALL OTHER
STANDARD
SHAPES**

"d" Dimension	Cat. No.	Price	Cat. No.	Price	Add-on for Optima™
1.50 - 30.00	25771		25772		
30.01 - 40.00	25777		25778		
40.01 - 56.00	25783		25784		
56.01 - 66.00	25789		25790		
66.01 - 76.20	25795		25796		
*76.21 - 90.00	62142		62143		

* Requires a keyed collar # 25573

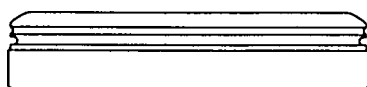
Standard Shapes

241 DIE BLADE

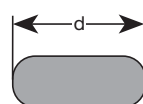


"d" Dimension	Cat. No.	Price
1.50 - 40.00	25979	
40.01 - 56.00	25981	

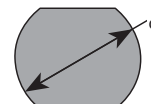
DIE



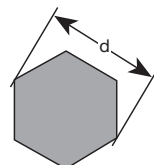
"d" Dimension	Cat. No.	Price
1.50 - 30.00	25027	
30.01 - 76.20	25000	
76.21 - 90.00	62127	



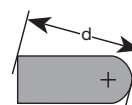
OBROUND



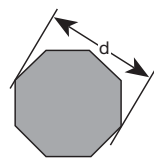
DOUBLE "D"



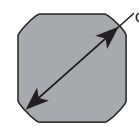
HEXAGON



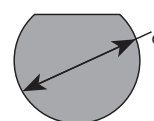
LONG "D"



OCTAGON



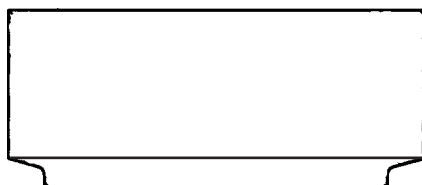
QUADRA "D"



SINGLE "D"

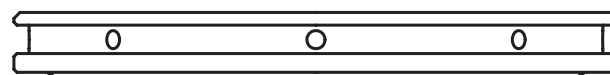
EQUILATERAL
TRIANGLE

NOTE: Long Tooling can be used, but only with Urethane strippers. This requires a special holder. When long tools have been ground by 0.5mm they can be used with a metal stripper. For further information, please contact our Sales Desk.



URETHANE STRIPPER

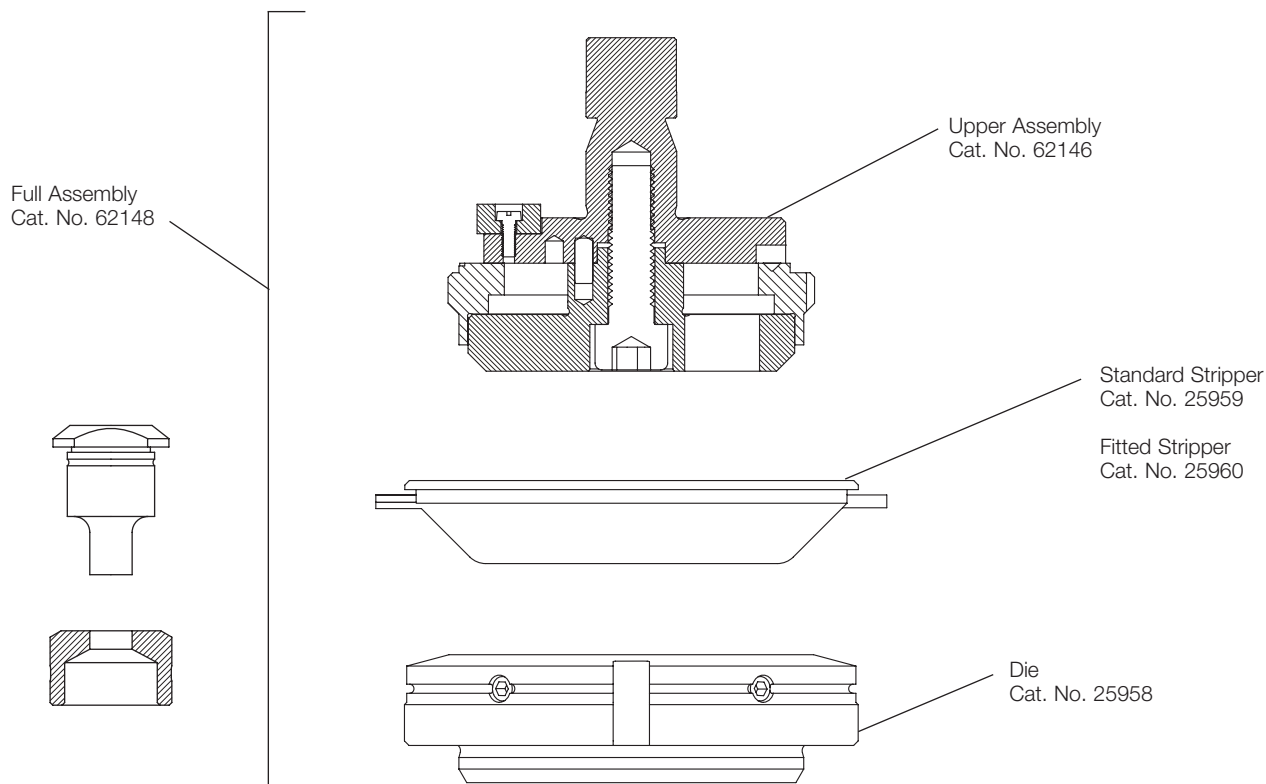
"d" Dimension	Cat. No.	Price
1.50 - 30.00	62133	
30.01 - 76.20	62132	



METAL STRIPPER

"d" Dimension	Cat. No.	Price
1.50 - 76.20	62145	
76.21 - 90.00	62126	

OrbitTool 5



5

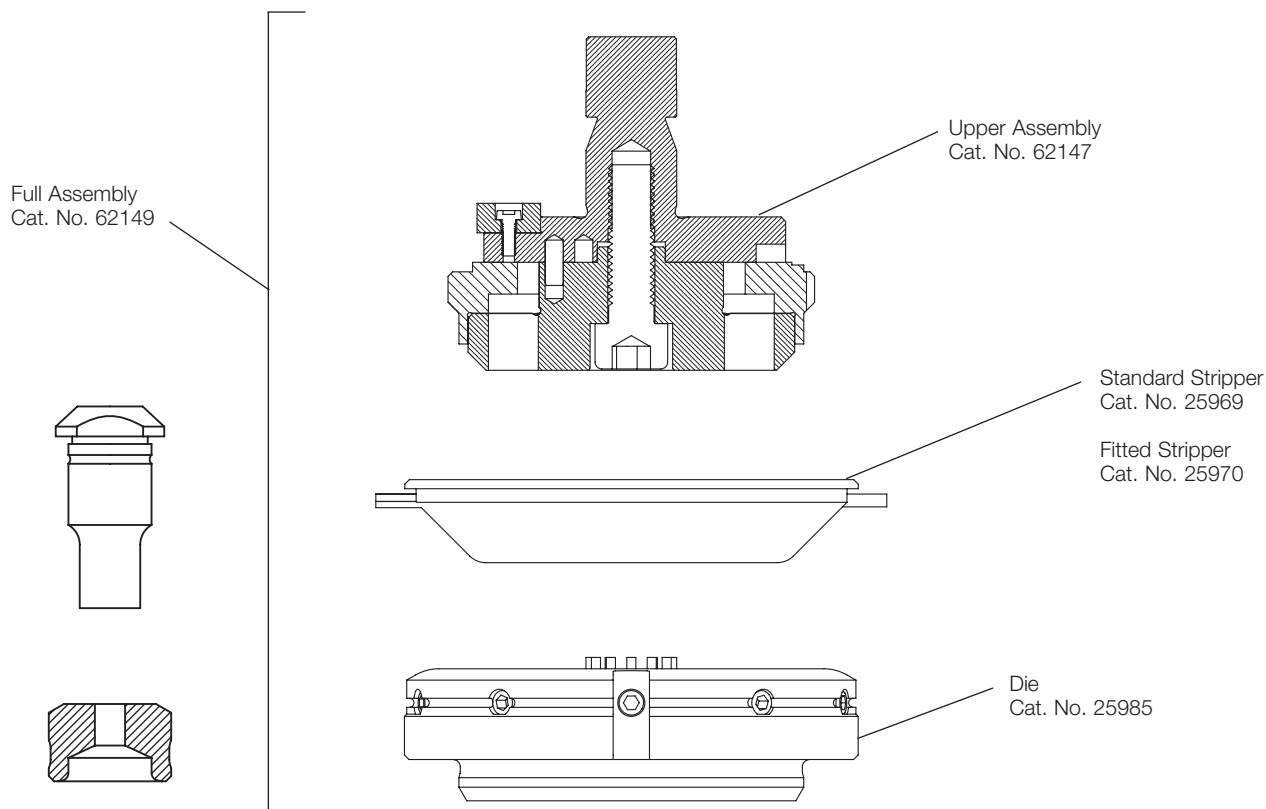
520

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720

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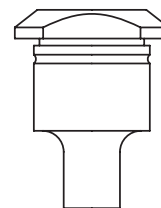
OrbitTool 10



OrbitTool 1.5 mm – 16.0 mm

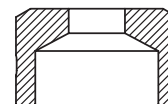
MULTI-TOOL 5-STATION PUNCH

Description	Cat. No.	Price	Add-on for Optima™
Round Punch	25735		
Shape Punch	25736		
Square Punch	25869		
Rectangle Punch	25870		



MULTI-TOOL 5-STATION DIE

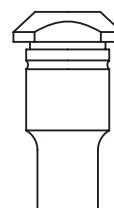
Description	Cat. No.	Price
Round Die	25737	
Shape Die	25738	
Square Die	25871	
Rectangle Die	25872	
MT5 Die Shim Pack	26003	



OrbitTool 1.5 mm – 10.5 mm

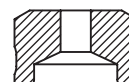
MULTI-TOOL 10-STATION PUNCH

Description	Cat. No.	Price	Add-on for Optima™
Round Punch	25809		
Shape Punch	25810		
Square Punch	25873		
Rectangle Punch	25874		

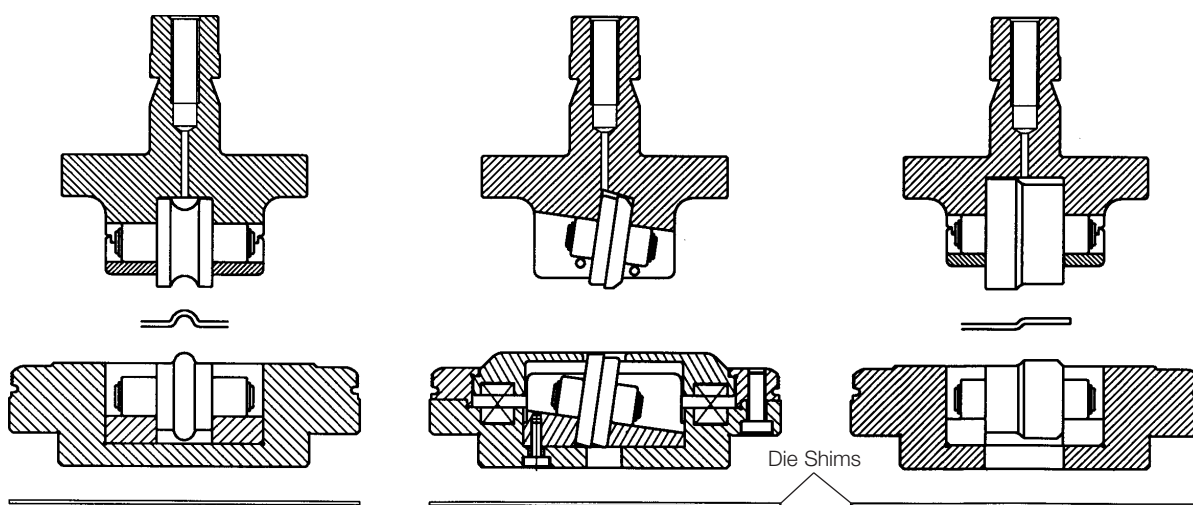
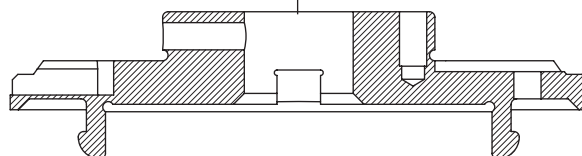


MULTI-TOOL 10-STATION DIE

Description	Cat. No.	Price
Round Die	25996	
Shape Die	25997	
MT10 Die Shim Pack	25995	



Not available from Wilson Tool, machine part.
(Not to scale)



For further information please contact our Sales Desk

Rolling Rib Tool

- High speed - equal to programmed table travel speed.
- Creates ribs in any contour using rotation.
- Virtually no nibble marks.
- Rib can be started or ended anywhere on the sheet.
- Material 0.8 - 2.5 mm.
- Stock sizes 2.5 and 3.0 mm radii.
- Min. rad. = 16 mm.

Rolling Shear Tool

- High speed - equal to programmed table travel speed.
- Virtually no burrs.
- Creates slits in any contour using rotation.
- Slit can be started or ended anywhere on the sheet.
- Material
 - 0.8 - 1.5 mm Stainless Steel
 - 0.8 - 2.0 mm Mild Steel
 - 0.8 - 2.5 mm Aluminium
- Min. rad. = 45 mm.

Rolling Offset Tool

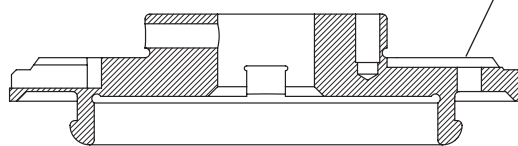
- High speed - equal to programmed table travel speed.
- Creates offsets in any contour using rotation.
- Virtually no nibble marks.
- Offsets can be started or ended anywhere on the sheet.
- Material
 - 0.8 - 1.5 mm Stainless Steel
 - 0.8 - 2.0 mm Mild Steel
 - 0.8 - 2.5 mm Aluminium
- Stock sizes 1.5 and 3.0 mm.
- Min. rad. = 25 mm.

241 Punch Holder Assembly

8

520530720730

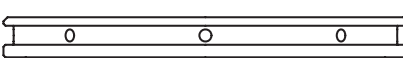
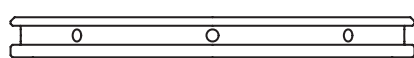
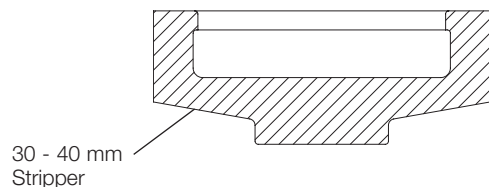
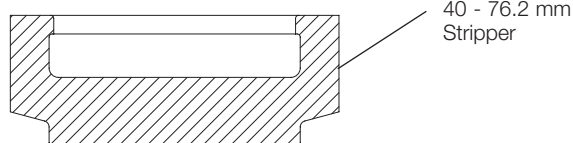
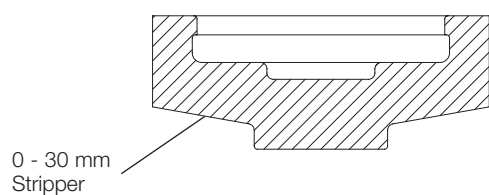
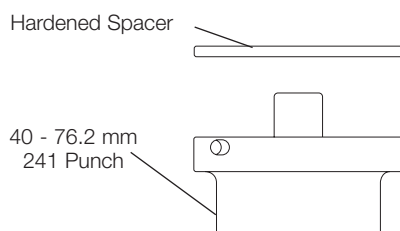
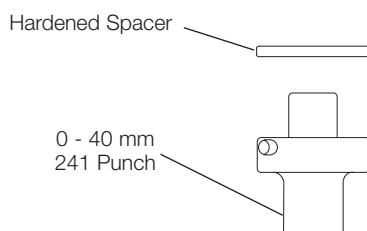
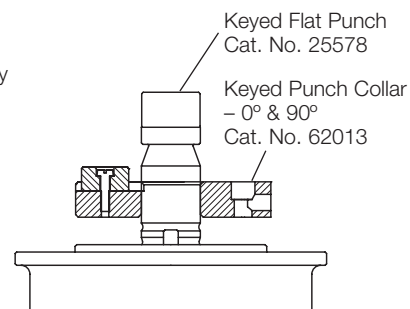
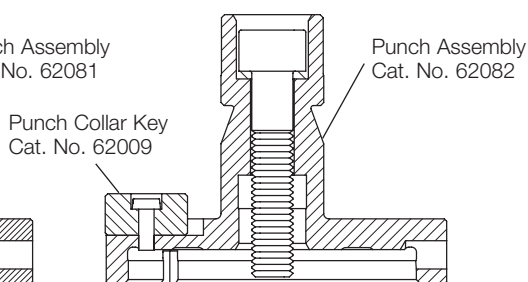
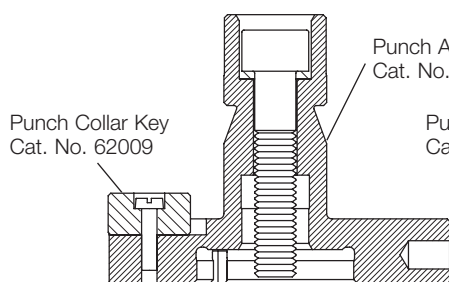
Not available from Wilson Tool, machine part.



0 - 40 mm

40 - 76.2 mm

76.2 - 90 mm



Metal Stripper

Metal Stripper

Metal Stripper

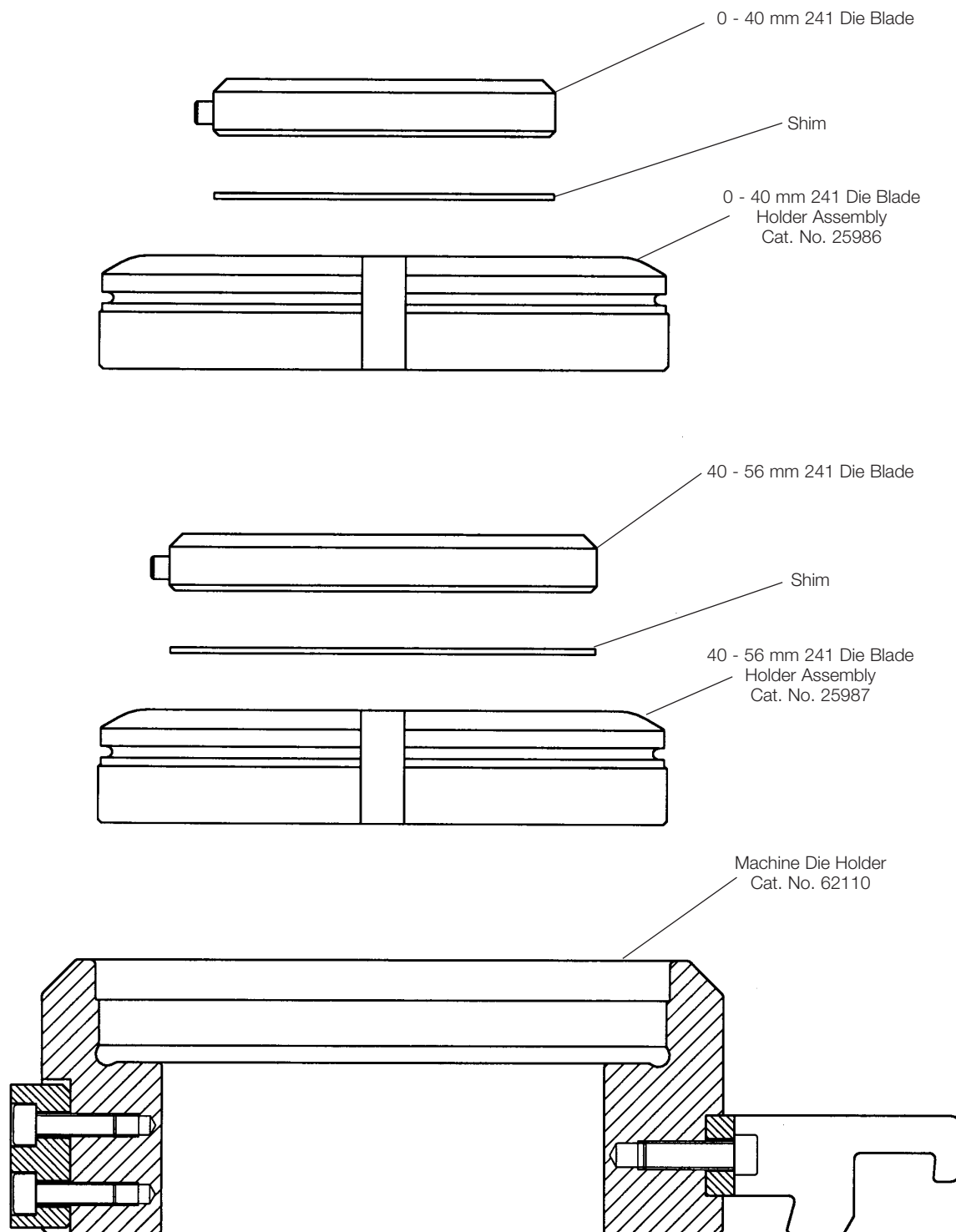


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Swindon
Wiltshire SN3 4TQ

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Fax (Free): (0800) 373758
Ireland
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Fax (Free): (1-800) 535538

Office:
Tel: +44 (0) 1793 831818
Fax: +44 (0) 1793 831945
Email: sales@wilsontool.eu.com
<http://www.wilsontool.com>

07/06 TEK

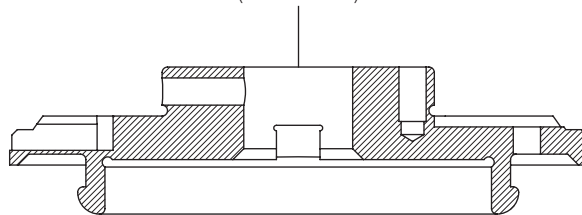


System for using Trumpf Style Tooling

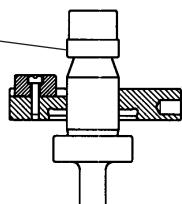
10

5
2
0
5
3
0
7
2
0
7
3
0

Not available from Wilson Tool, machine part.
(Not to scale)



Size 1 Trumpf Tooling

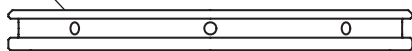


Punch Collar
Cat. No. 62008

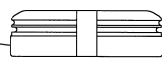
0 - 30 mm Stripper
Cat. No. 62134



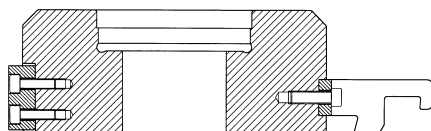
Metal Stripper



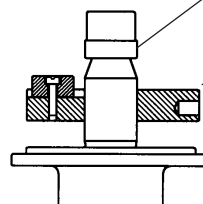
Size 1 Die



Machine Die Holder
Cat. No. 62109

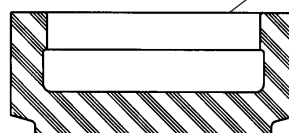


Size 2 Trumpf Tooling

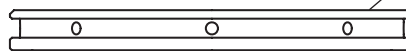


Punch Collar
Cat. No. 62010

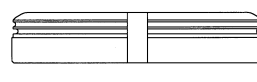
30 - 76.2 mm Stripper
Cat. No. 62132



Metal Stripper

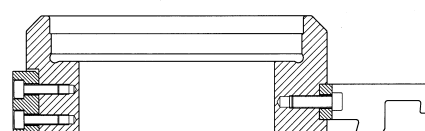


Size 2 Die



Shim

Machine Die Holder
Cat. No. 62110

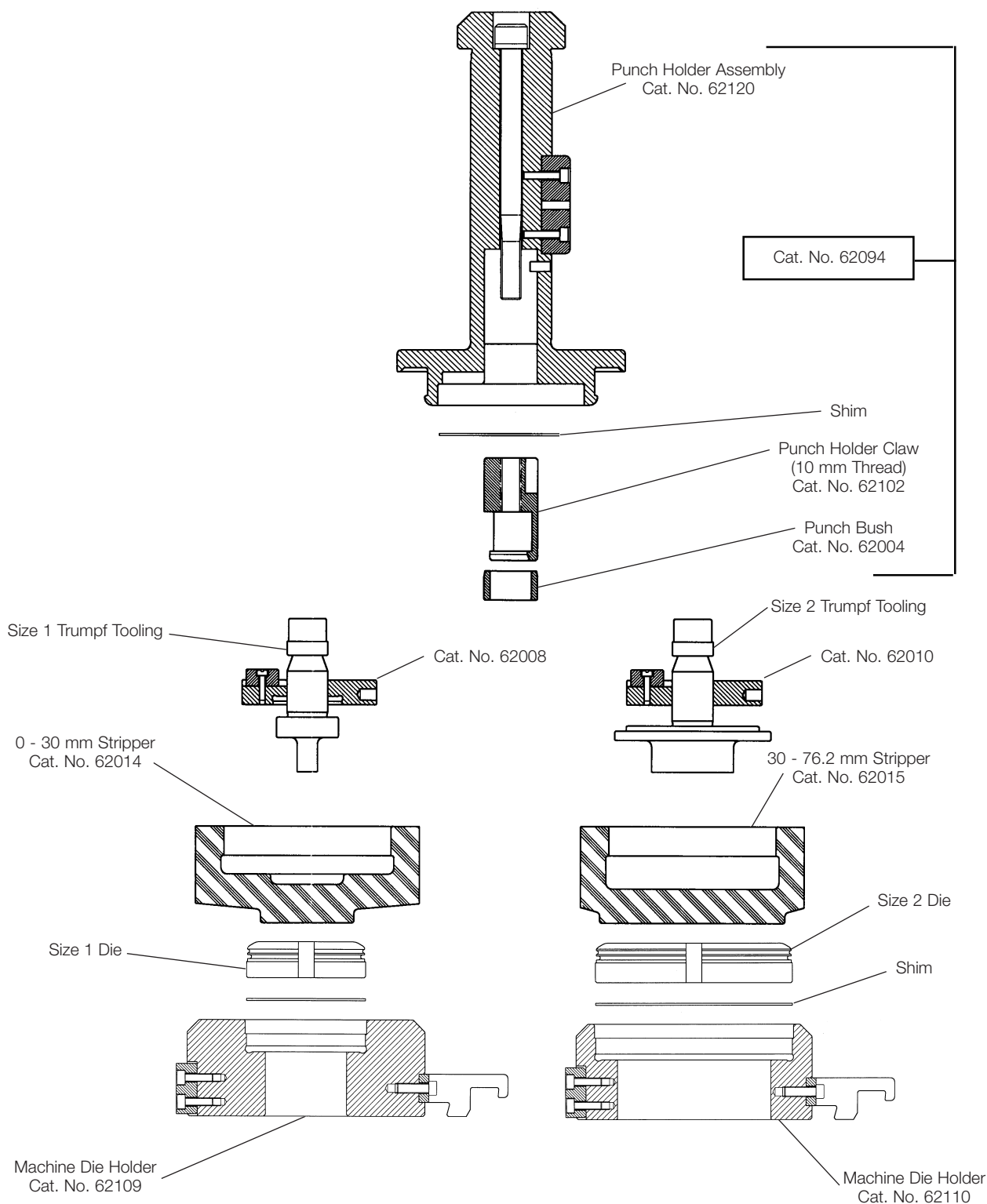


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Tel: +44 (0) 1793 831818
Fax: +44 (0) 1793 831945
Email: sales@wilsontool.eu.com
<http://www.wilsontool.com>

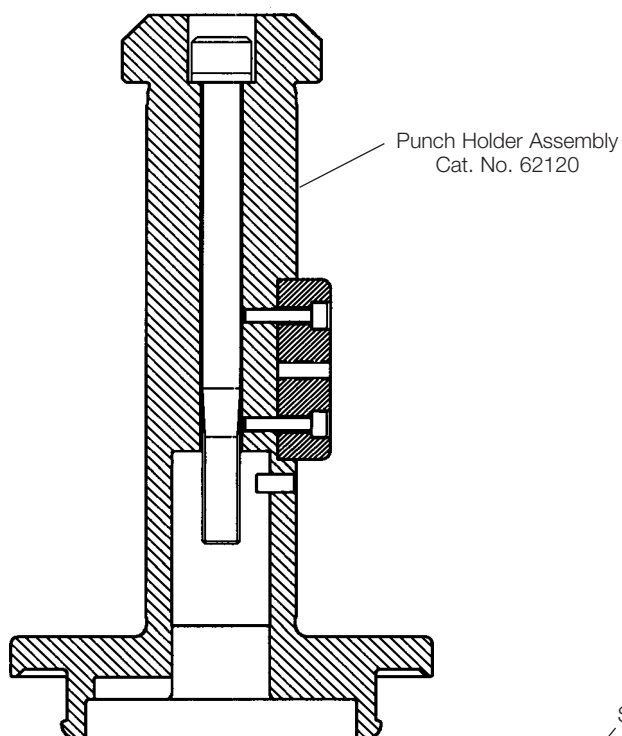
07/06 TEK



241 Punch Holder Assembly

12

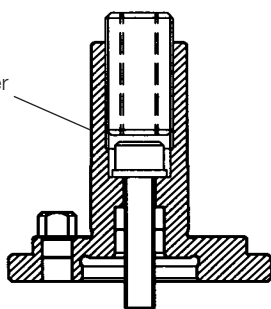
400050006000



Shim

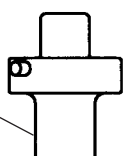
Shim

0 - 40 mm
241 Punch Holder
Assembly
Cat. No. 62098

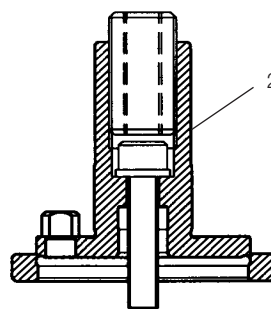


Hardened Spacer

0 - 40 mm
241 Punch

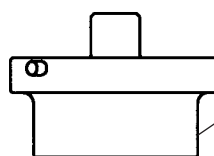


40 - 76.2 mm
241 Punch Holder
Assembly
Cat. No. 62099

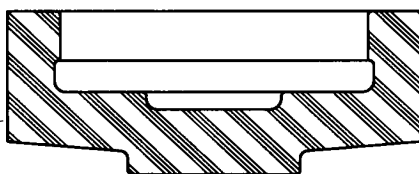


Hardened Spacer

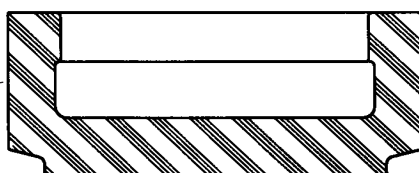
40 - 76.2 mm
241 Punch



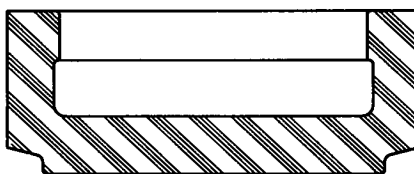
0 - 30 mm
Stripper
Cat. No. 62080



30 - 40 mm
Stripper
Cat. No. 62015



40 - 76.2 mm
Stripper
Cat. No. 62015



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07/06 TEK

241 SHIM PACKS

Shim	Cat. No.	Price
Punch Shim Pack	62005	
0 – 40 mm 241 Hardened Punch Spacer	25806	
40 – 76 mm 241 Hardened Punch Spacer	25807	
0 – 40 mm Die Blade Shim Pack	25983	
40 – 56 mm Die Blade Shim Pack	25984	

OrbitTool 8, 5 & 10 SHIM PACKS

OrbitTool	Shim	Cat. No.	Price
8	0 – 10 mm Insert Punch Shim Pack	62066	
8	0 – 10 mm Die Shim Pack	62055	
8	0 – 20 mm Die Shim Pack	62056	
5	0 – 16 mm Die Shim Pack	26003	
10	0 – 10.5 mm Die Shim Pack	25995	

HEAVY DUTY SHIM PACKS

Shim	Cat. No.	Price
Punch Shim Pack*	62005	
Die Shim Pack	62024	

TRUMPF SHIM PACKS

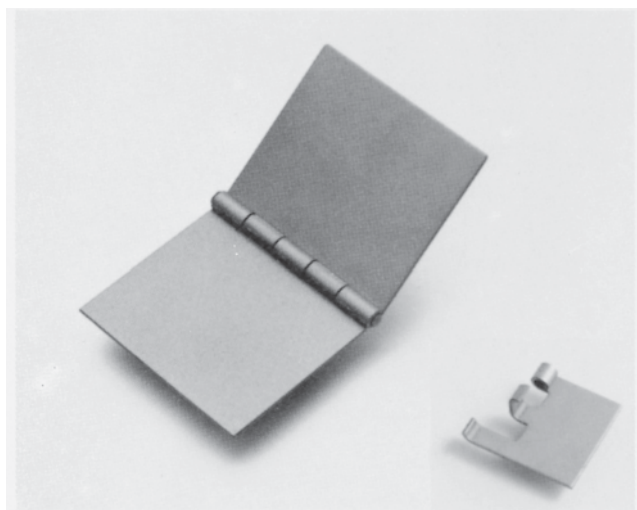
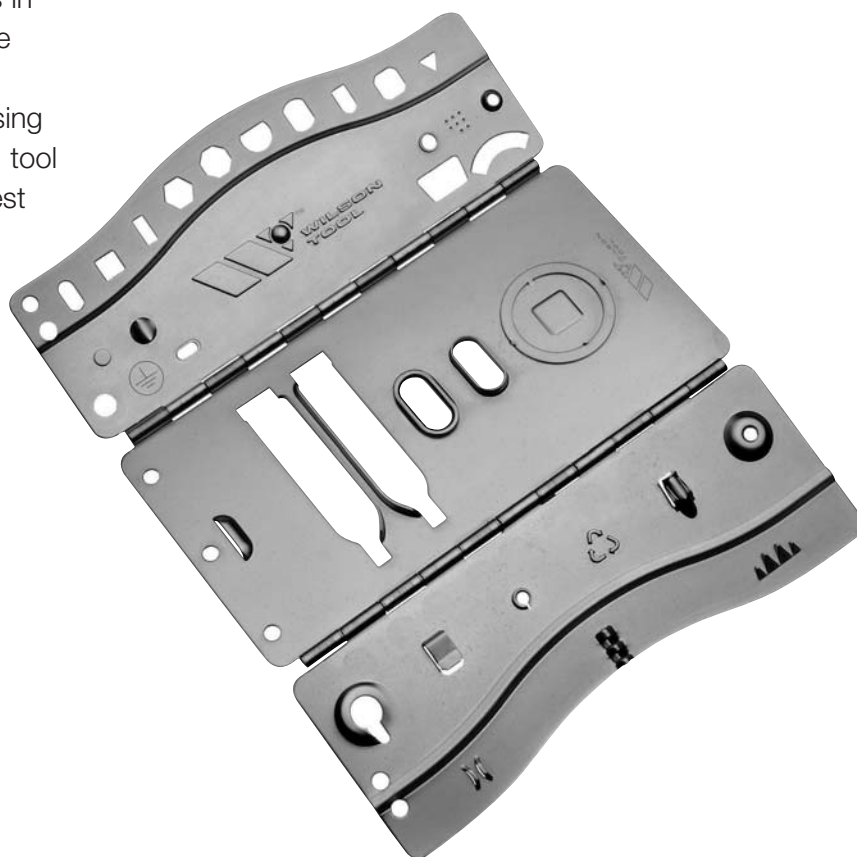
Shim	Cat. No.	Price
Punch Shim Pack*	62005	
Size 1 Die Shim Pack	62023	
Size 2 Die Shim Pack	62024	
76.2 – 90.0 mm Die Shim Pack	62136	

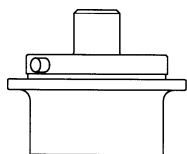
WHEEL TOOL SHIM PACKS

Shim	Cat. No.	Price
Punch Shim Pack	62005	
Die Shim Pack	62024	

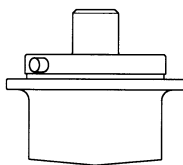
* For 4000, 5000 and 6000 machines only

Wilson Tool are the specialists in form tools, and there is a large variation in types available. Whether it is a simple embossing tool or a complex progression tool contact Wilson Tool for the best advice on your requirements.

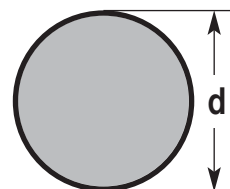




PUNCH HSS



SHEAR

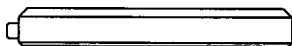


STANDARD

TOOLS

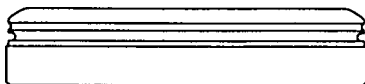
ROUND

"d" Dimension	Cat. No.	Price	Cat. No.	Price	Add-on for Optima™
1.50 - 30.00	25768		25769		
30.01 - 40.00	25774		25775		
40.01 - 56.00	25780		25781		
56.01 - 66.00	25786		25787		
66.01 - 76.20	25792		25793		



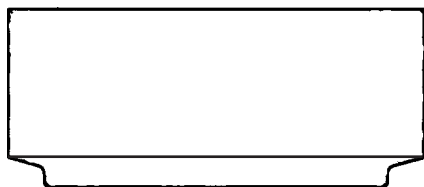
241 DIE BLADE

"d" Dimension	Cat. No.	Price
1.50 - 40.00	25980	
40.01 - 56.00	25982	



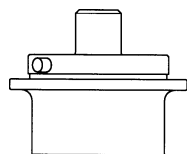
DIE

"d" Dimension	Cat. No.	Price
1.50 - 30.00	25005	
30.01 - 76.20	25024	



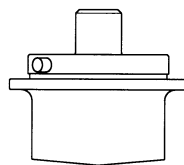
STRIPPER

"d" Dimension	Cat. No.	Price
1.50 - 30.00	62014	
30.01 - 76.20	62015	



PUNCH HSS

FLAT



SHEAR

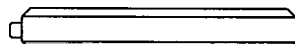


STANDARD

TOOLS

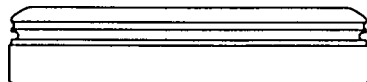
SQUARE

"a" Dimension	Cat. No.	Price	Cat. No.	Price	Add-on for Optima™
1.50 - 21.22	25814		25816		
21.23 - 28.29	25820		25822		
28.30 - 39.60	25826		25828		
39.61 - 46.68	25832		25834		
46.69 - 53.90	25838		25840		



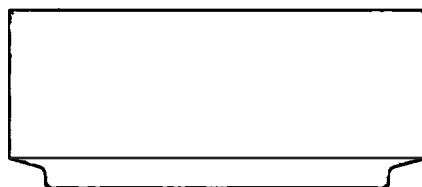
241 DIE BLADE

"a" Dimension	Cat. No.	Price
1.50 - 28.29	25979	
28.30 - 39.60	25981	



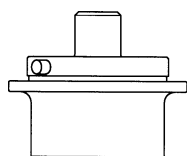
DIE

"a" Dimension	Cat. No.	Price
1.50 - 21.22	25483	
21.23 - 53.90	25519	



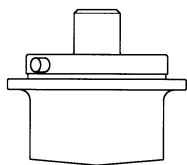
STRIPPER

"a" Dimension	Cat. No.	Price
1.50 - 21.22	62014	
21.23 - 53.90	62015	

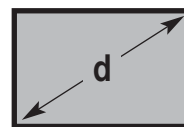


PUNCH HSS

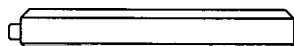
FLAT



SHEAR

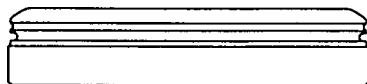
STANDARD
TOOLS
RECTANGLE

"d" Dimension	Cat. No.	Price	Cat. No.	Price	Add-on for Optima™
1.50 - 30.00	25815		25817		
30.01 - 40.00	25821		25823		
40.01 - 56.00	25827		25829		
56.01 - 66.00	25833		25835		
66.01 - 76.20	25839		25841		



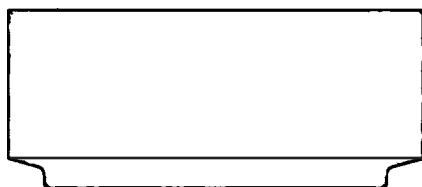
241 DIE BLADE

"d" Dimension	Cat. No.	Price
1.50 - 40.00	25979	
40.01 - 56.00	25981	



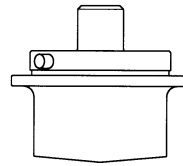
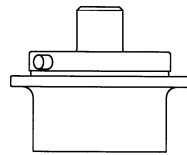
DIE

"d" Dimension	Cat. No.	Price
1.50 - 30.00	25484	
30.01 - 76.20	25520	



STRIPPER

"d" Dimension	Cat. No.	Price
1.50 - 30.00	62014	
30.01 - 76.20	62015	



**STANDARD
TOOLS
ALL OTHER
STANDARD
SHAPES**

PUNCH HSS

FLAT

SHEAR

"d" Dimension	Cat. No.	Price	Cat. No.	Price	Add-on for Optima™
1.50 - 30.00	25771		25772		
30.01 - 40.00	25777		25778		
40.01 - 56.00	25783		25784		
56.01 - 66.00	25789		25790		
66.01 - 76.20	25795		25796		

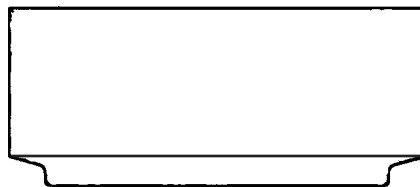
Standard Shapes

241 DIE BLADE

"d" Dimension	Cat. No.	Price
1.50 - 40.00	25979	
40.01 - 56.00	25981	

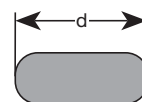
DIE

"d" Dimension	Cat. No.	Price
1.50 - 30.00	25027	
30.01 - 76.20	25000	



STRIPPER

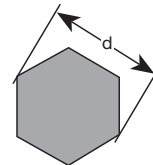
"d" Dimension	Cat. No.	Price
1.50 - 30.00	62014	
30.01 - 76.20	62015	



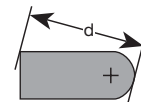
OBROUND



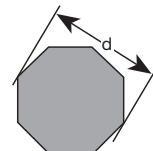
DOUBLE "D"



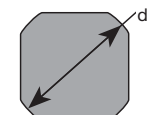
HEXAGON



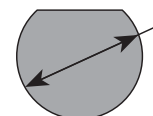
LONG "D"



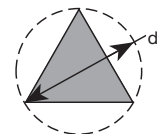
OCTAGON



QUADRA "D"

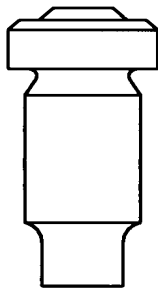


SINGLE "D"

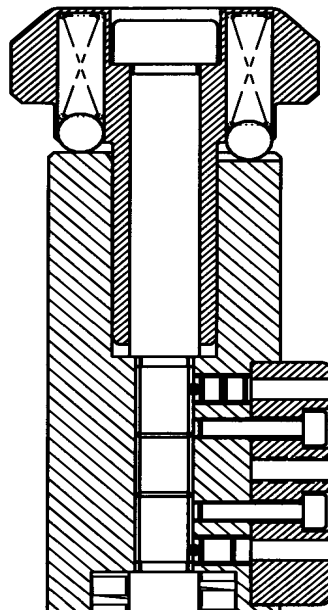
EQUILATERAL
TRIANGLE

Notes:

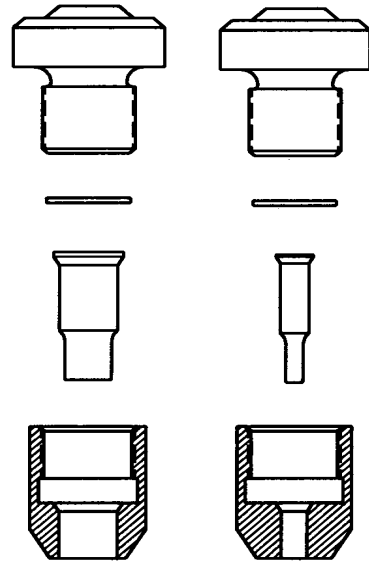
- Maximum force for the OrbitTool is 60KN.
- Maximum material thickness is 4 mm.
- Maximum hit rate 500 /Min.
- It is not recommended to nibble with the OrbitTool.



0 - 20 mm Punch



0 - 10 mm Insert Punches.
Round Only.



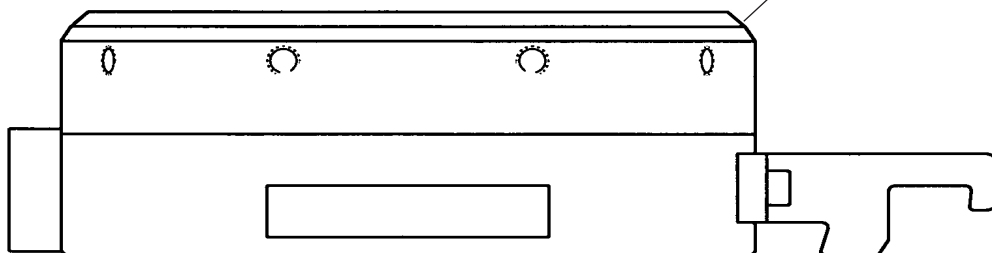
OrbitTool Upper
Assembly
Cat. No. 62104

0 - 10 mm Die. Round Only

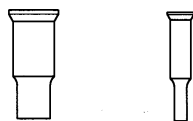
0 - 20 mm Die

Shim

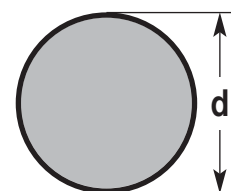
OrbitTool Lower
Assembly
Cat. No. 62044



20


INSERT PUNCH
 0 – 10 mm

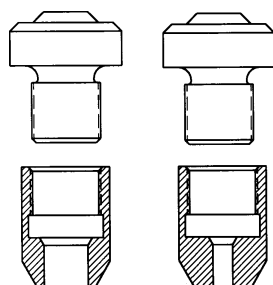
"d" Dimension	Cat. No.	Price	Add-on for Optima™
1.50 - 5.00	62069		
5.01 - 10.00	62070		



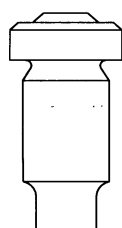
STANDARD

TOOLS

ROUND


INSERT HOLDER ASSEMBLY

"d" Dimension	Cat. No.	Price
0 - 5.00	62061	
5.00 - 10.00	62067	


PUNCH
 0 – 20 mm

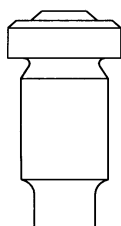
"d" Dimension	Cat. No.	Price	Add-on for Optima™
1.50 - 20.00	62071		

DIE
 0 – 20 mm


"d" Dimension	Cat. No.	Price
1.50 - 12.00	62074	
12.01 - 20.00	62075	

DIE
 0 – 10 mm


"d" Dimension	Cat. No.	Price
1.50 - 10.00	62073	



PUNCH
0 – 20 mm

**STANDARD
SHAPED
TOOLS**

"d" Dimension	Cat. No.	Price	Add-on for Optima™
1.50 - 20.00	62072		



DIE
0 – 20 mm

"d" Dimension	Cat. No.	Price
1.50 - 12.00	62076	
12.01 - 20.00	62077	

21

400050006000

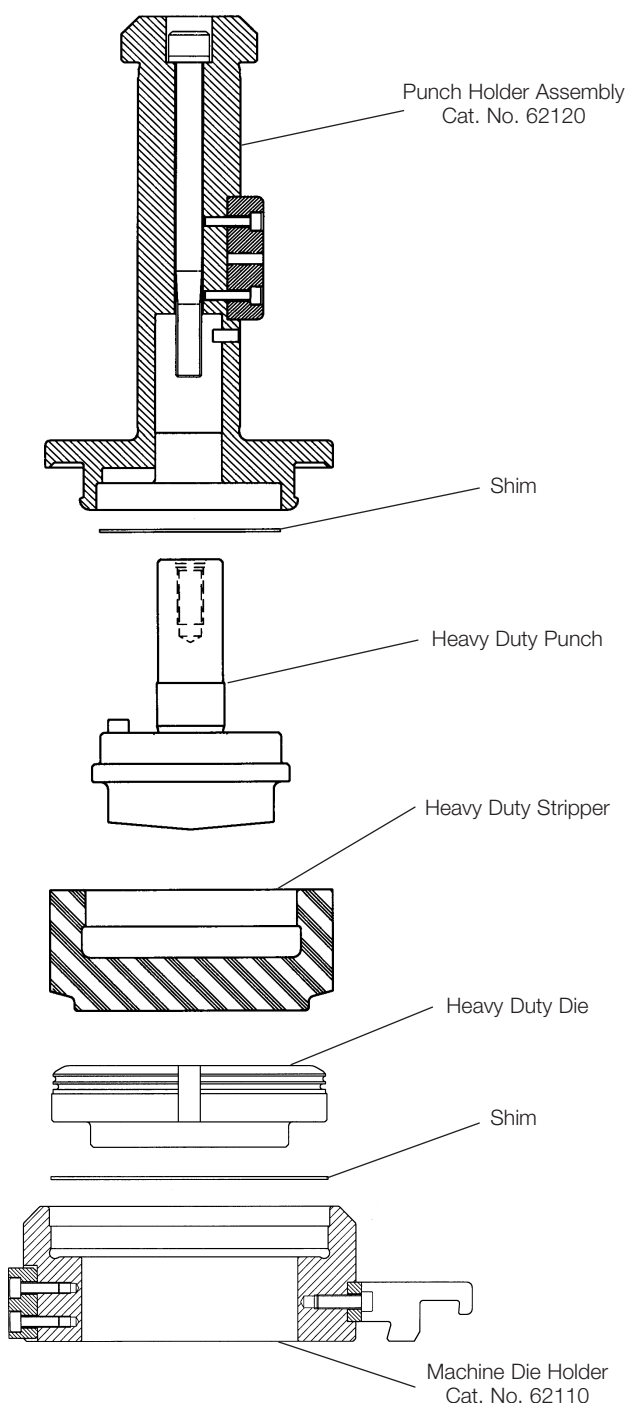
Heavy Duty Punch System

PUNCH HSS

FLAT

SHEAR

Up to 76.20 mm	Cat. No.	Price	Cat. No.	Price	Add-on for Optima™
Round	62090		62092		
Shaped	62121		62122		



DIE

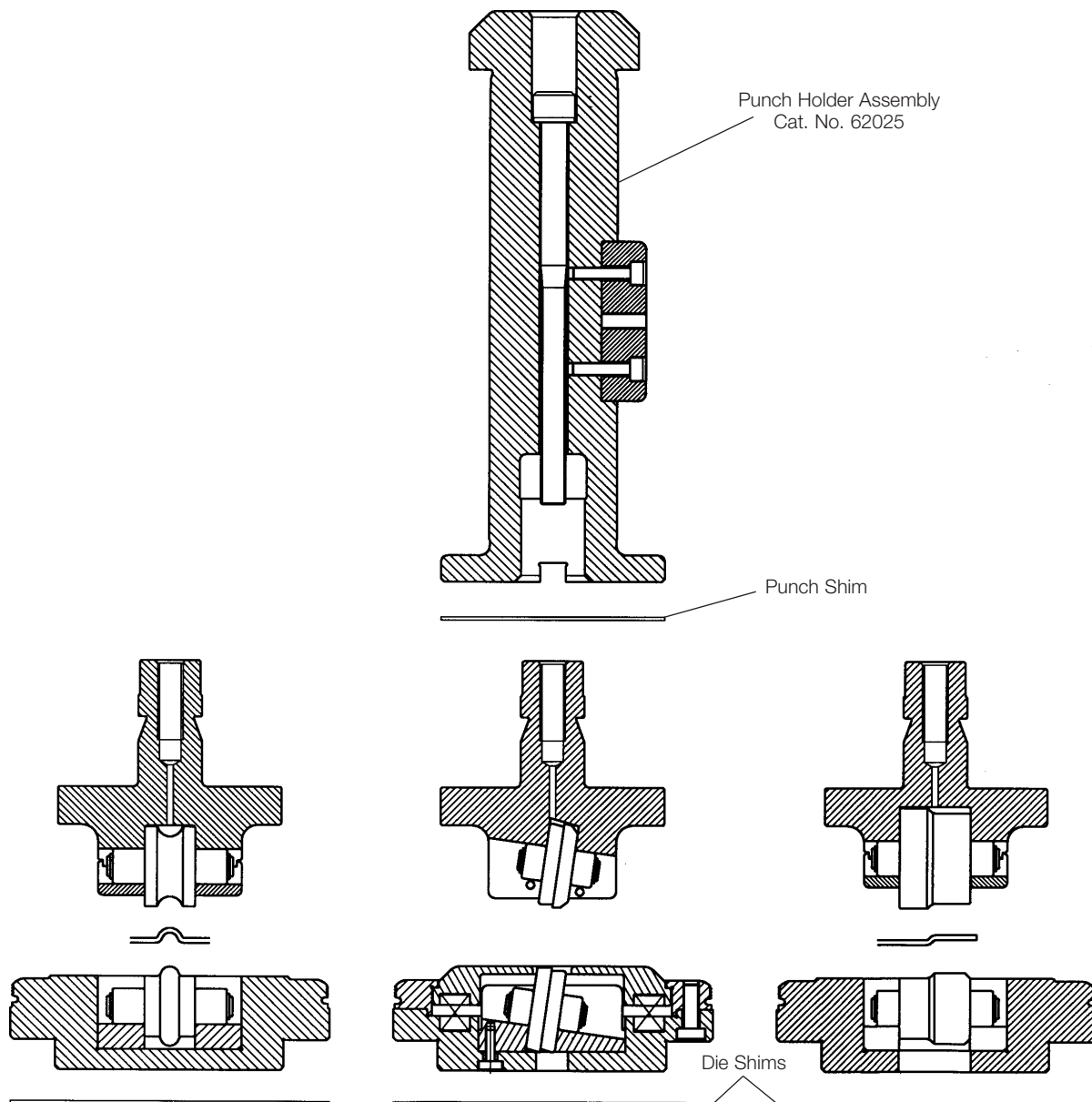
Up to 56.00 mm	Cat. No.	Price
Round	25180	
Shaped	25162	

STRIPPER

"d" Dimension	Cat. No.	Price
Up to 76.20 mm	62093	

Notes:

- Minimum punch $\varnothing 10.0$ mm.
- Maximum die $\varnothing$ is 56.0 mm. For sizes over this, the solution is based on the application.
- Punches have extra back taper as standard.
- 1.0 mm rads. on corners will increase the life of the punch and die.
- Roof top shear recommended as long as shear depth is a minimum 50% of material thickness.
- Heavy duty punch to be used on 6 mm material and above and when the punching force is over 200KN.
- Heavy duty die to be used when the punching force is over 180KN.
- Check the size required does not exceed the machine punching force.
- Optima is strongly recommended for heavy duty punches.



For further information please contact our Sales Desk

Rolling Rib Tool

- High speed - equal to programmed table travel speed.
- Creates ribs in any contour using rotation.
- Virtually no nibble marks.
- Rib can be started or ended anywhere on the sheet.
- Material 0.8 - 2.5 mm.
- Stock sizes 2.5 and 3.0 mm radii.
- Min. rad. = 16 mm.

Rolling Shear Tool

- High speed - equal to programmed table travel speed.
- Virtually no burrs.
- Creates slits in any contour using rotation.
- Slit can be started or ended anywhere on the sheet.
- Material
 - 0.8 - 1.5 mm Stainless Steel
 - 0.8 - 2.0 mm Mild Steel
 - 0.8 - 2.5 mm Aluminium
- Min. rad. = 45 mm.

Rolling Offset Tool

- High speed - equal to programmed table travel speed.
- Creates offsets in any contour using rotation.
- Virtually no nibble marks.
- Offsets can be started or ended anywhere on the sheet.
- Material
 - 0.8 - 1.5 mm Stainless Steel
 - 0.8 - 2.0 mm Mild Steel
 - 0.8 - 2.5 mm Aluminium
- Stock sizes 1.5 and 3.0 mm.
- Min. rad. = 25 mm.

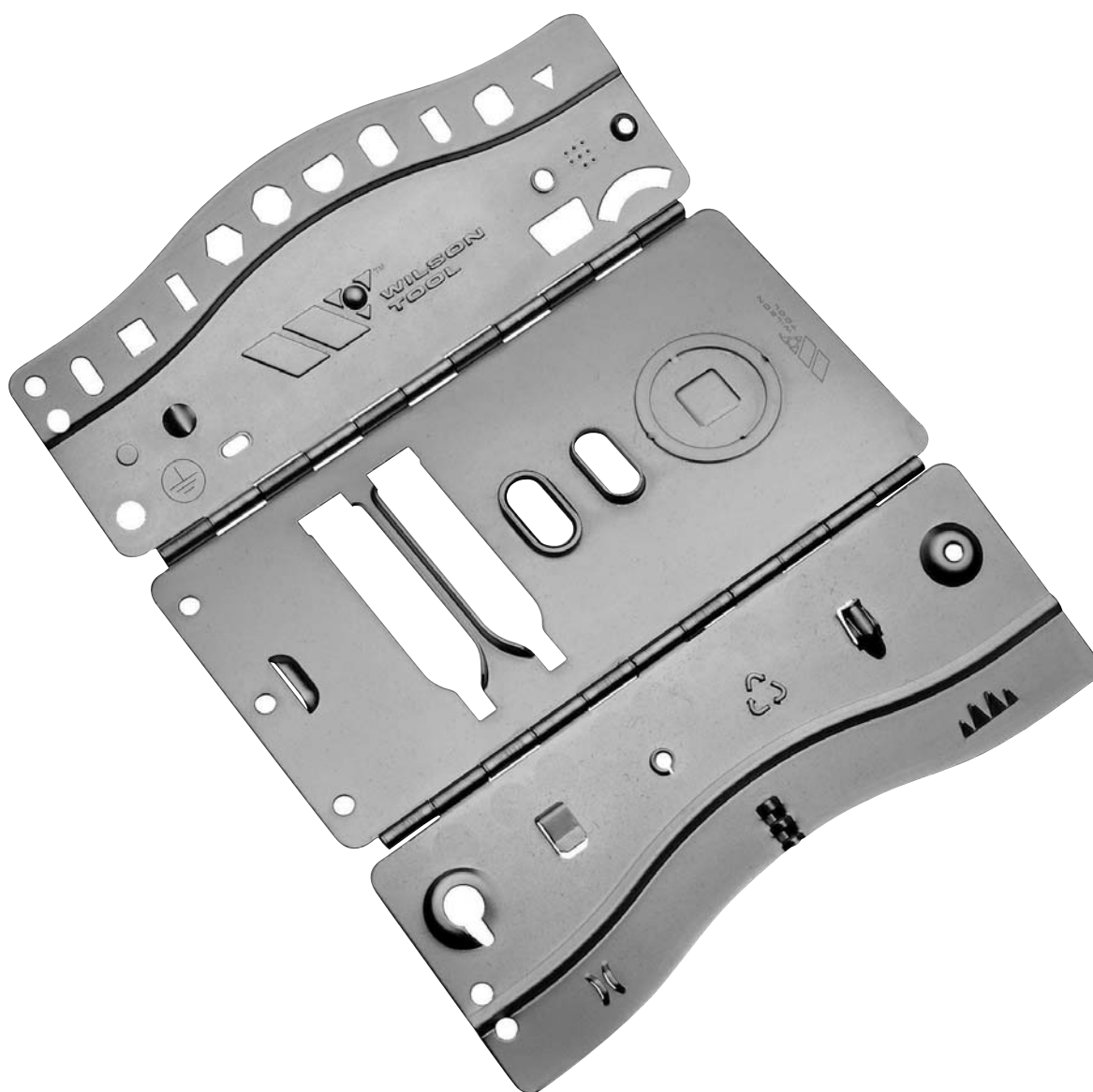


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