

WILSON METRIC TOOL SYSTEMS



SOLUTIONS FOR METAL STAMPING

Terms and Conditions

Credit	All orders are subject to the approval of our credit department. If you are a new account, please furnish us with a bank reference and three supplier references. A credit limit will be imposed on new accounts until credit has been established.
Payment	Terms are net 30 days.
Cancellation	In the event an order is cancelled, a charge will be made to cover labour, materials and over-heads.
Returned Material	A handling charge of 25% is made on all standard parts returned for credit. Written permission and shipping instructions must be obtained before the return of any material. Special tooling cannot be returned.
Claims	All claims for shortages must be made within 3 days of the invoice date.
Prices	Prices and specifications subject to change without prior notice. E & OE. All prices are exclusive of VAT.

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Technology for Increased Tool Life

Optima® Coating

The New Standard in Tooling Performance!

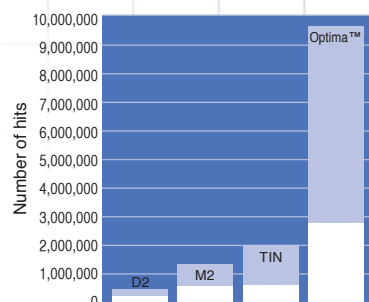
Optima® is a proprietary TiCN (titanium carbo-nitride) coating that was custom engineered at our in-house coating facilities. It features unique properties that significantly enhance tooling performance. This coating, which is available only to Wilson Tool customers, provides a level of surface hardness,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

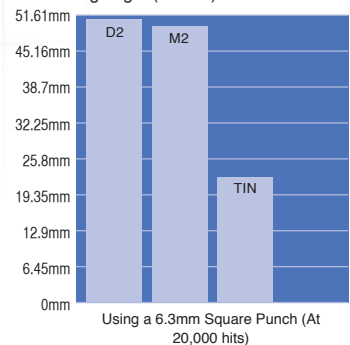
Punch Life
Nibbling 14ga. (1.9mm) 304 Stainless Steel



Using a 7.9mm Round Punch
The white 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

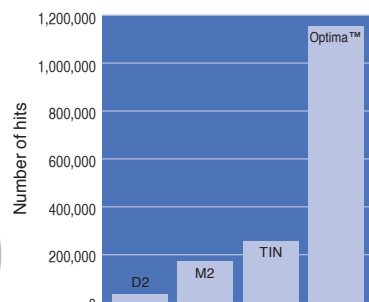
Square mm of Material Adhesion (Galling) on Punch Tips
Nibbling 12ga. (2.1mm) Aluminium



Using a 6.3mm Square Punch (At 20,000 hits)

Number of Hits

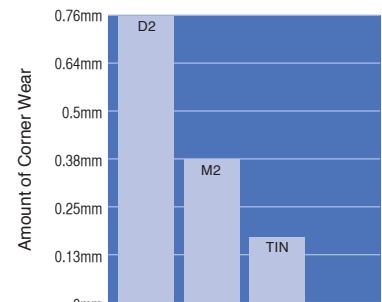
Number of Hits Before First Sharpening
Nibbling 14ga. (1.9mm) 304 Stainless Steel



Using a 7.9mm Round Punch

Tip Wear

Punch Tip Corner Wear
Nibbling 14ga. (1.9mm) 304 Stainless Steel



Using a 6.3mm Square Punch (At 25,000 hits)

Optima

TECHNOLOGY AT THE CUTTING EDGE

Ultima® Tool Steel

Boost Punching Productivity!

Tool Steel for Longer Life

When faced with demanding applications that require long-term wear resistance and toughness, turn to Wilson's new Ultima® Premium Tool Steel for HP thick turret tooling. Ultima® punches and dies are engineered to increase wear resistance by up to 100% over conventional tool steels.

A New Level of Performance

Ultima® premium tool steel sets a new benchmark for durability and performance. Ultima® punches and dies are designed to dramatically improve tool life when punching abrasive materials and materials with high tensile strength.

Ultima® excels in applications in which punches and dies wear quickly and is ideal for long running tasks. The premium steel from which Ultima® punches and dies are made significantly reduces micro chipping on the cutting edge. This micro chipping is most often where cutting edge failure begins.



Remarkable Downtime Reductions

With up to twice as long between re-grinds, Ultima® premium steel significantly reduces downtime and tool replacement costs. Breaking, chipping, cracking, tool fatigue and other downtime problems are minimised, providing long term gains in productivity and profitability.

Ultima® tools are especially useful for the toughest punch press applications, but are effective in any job. Viability can be determined by conducting a cost benefit analysis.

Maintenance and sharpening may differ from traditional tooling. Please check with your local Sales Engineer or the Salesdesk.

Ultima®
PREMIUM TOOL STEELS

Features and Benefits - A and B Stations

Wilson Metric Thick Turret Tool Systems for A & B Stations

Wilson Tool offers three ranges of A & B station standard tools with feature sets to suit different applications and budgets.

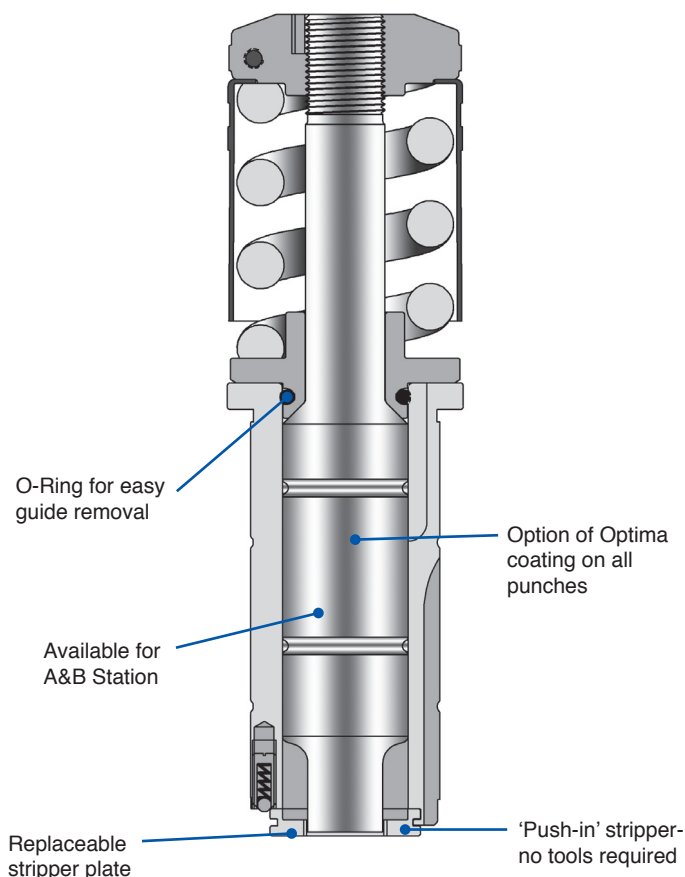
HPX is Wilson Tool's premium tool holder system for A & B stations. With quick-change EXP punches and push in stripper plates, it is possible to use the same holder for multiple punches rather than purchasing full assemblies for each job. EXP punches are manufactured from Ultima powdered tool steel for long life, and punch lengths can be adjusted with a twist of the punch head. This new punch technology increases productivity, reduces manufacturing waste, saves storage space and delivers the same performance, grind life and durability as our ground-breaking HP punch press tooling at a lower cost.

Quick Adjust is Wilson Tool's standard tool system. Compatible with Metric-style punches, Quick Adjust assemblies eliminate the need for shims; tool length is easily adjusted using the spring pack.

Basix is Wilson Tool's economy tool system; compatible with Metric-style punches, and using shims for tool length adjustment.

Three ranges of tools to suit your application, all manufactured to Wilson Tool's superior quality standards and tolerances and with the same short lead times.

Economy

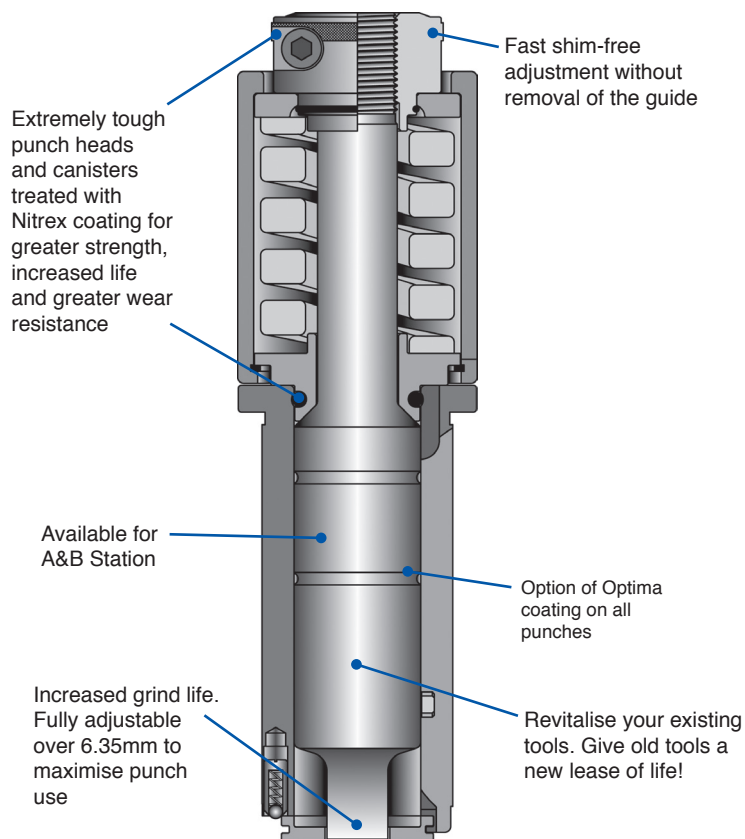


basix

Non ABS
See Pages 8-9

ABS
See Pages 18-19

Standard

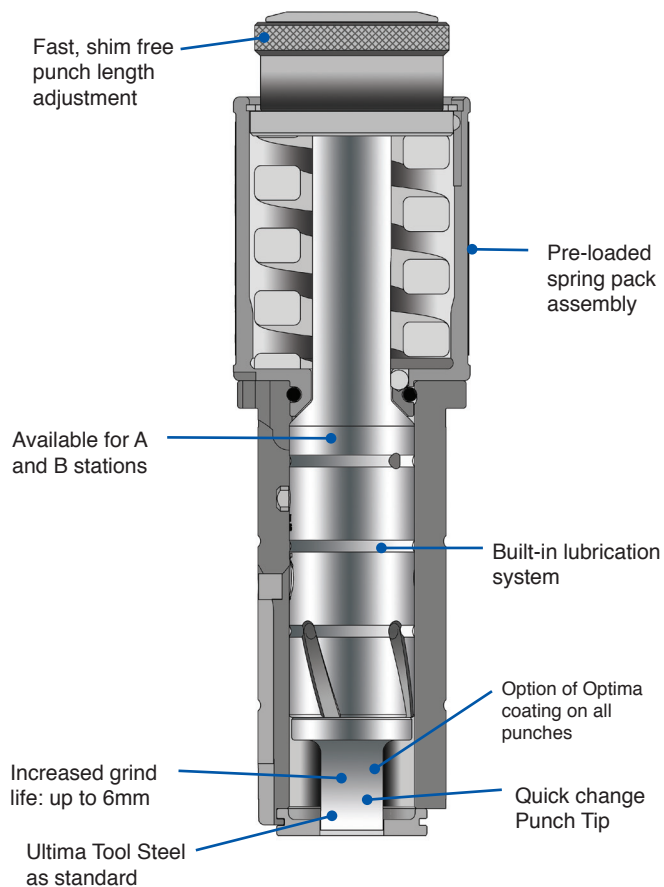


WILSON
Quick Adjust™

Non ABS
See Pages 10-11

ABS
See Pages 20-21

Premium



See Pages 12-13

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	Economy		Standard		Premium	
	basix ABS	basix Non ABS	Quick Adjust ABS	Quick Adjust Non ABS	HPX	
Overall Value: Considering features, benefits and costs, will this tooling system reduce your costs and improve your profitability?	
Innovation: Does this tool system contain innovative features and benefits?	
Overall Tool Life: Does this tooling system have standard design features which prolong the life of the entire tool and machine turret, such as specialist materials, coatings, surface enhancements, and built-in lubrication systems?	
Punch Grind Life: How long the tool can remain in the machine before being sharpened, and how much material that can be removed from the punch before it needs to be replaced?	
Ease of Use: Does this tooling system lend itself to simple, fast set-ups and loading into the turret, without the use of tools and fixtures?	
Fast tool set-up: Does the design of this tool allow for fast, accurate set-ups, keeping machine down time to a minimum?	
LEAN Friendly: To what extent will working with this tooling system further your LEAN production aims?	
Delivery time: Are these tooling styles available with next day shipping for standard shapes?	
	Go To Pages 18-19	Go To Pages 8-9	Go To Pages 20-21	Go To Pages 10-11	Go To Pages 12-13	

Features and Benefits - C, D and E Stations

Wilson Metric Thick Turret Tool Systems for C, D & E Stations

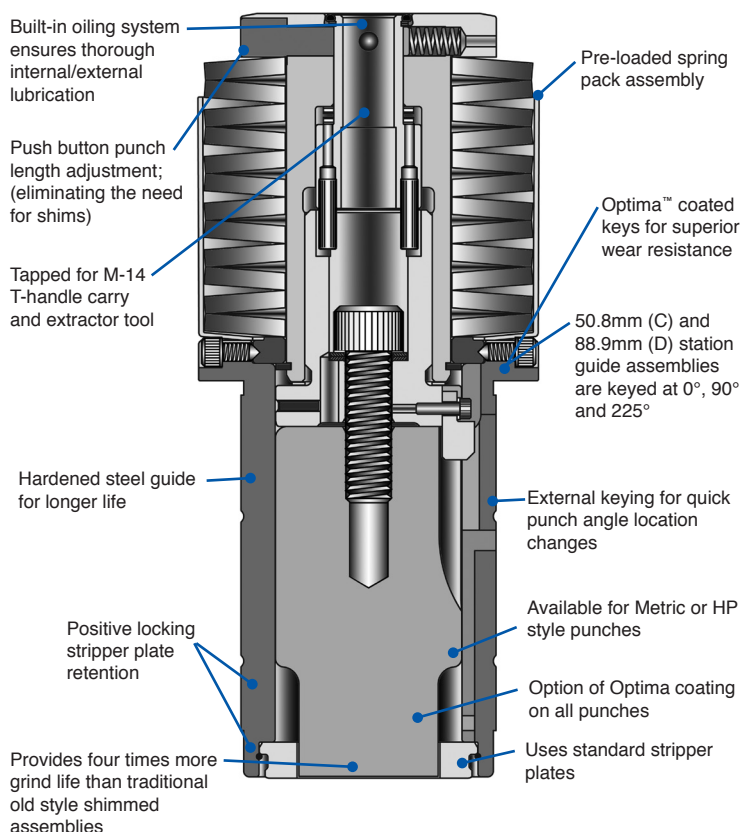
Wilson Tool offers two ranges of C, D & E station standard tools with feature sets to suit different applications and budgets.

Wilson Metric Style with Quick-Release Stripper Plate is Wilson Tool's premium tool system for C, D & E stations. Unique features including patented push button length adjustment, quick release stripper plate and hardened steel construction make this the most advanced thick turret tool system for Metric-style punches in the industry. Assemblies are compatible with all Metric-style punches and stripper plates, the Metric PDC system, and are available in ABS and gravity-fed lubrication configurations.

Wilson Replacement Metric is Wilson Tool's standard tool system for C, D & E stations. Designed with patented push button length adjustment and hardened steel construction, but with manual stripper retention using stripper clips or a wire lock ring. Wilson Replacement Metric assemblies are compatible with all Metric-style punches and stripper plates, the Metric PDC system, and are available in ABS and gravity-fed lubrication configurations.

Two ranges of tools to suit your application, both manufactured to Wilson Tool's superior quality standards and tolerances and with the same short lead times.

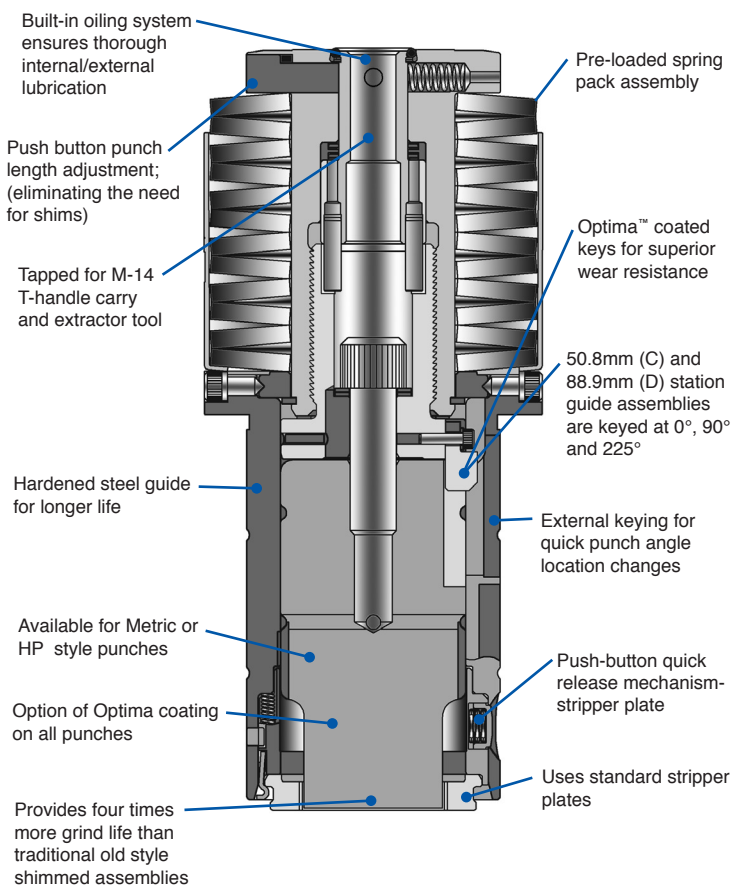
Standard



Wilson Metric-Style

See Pages 14-16

Premium



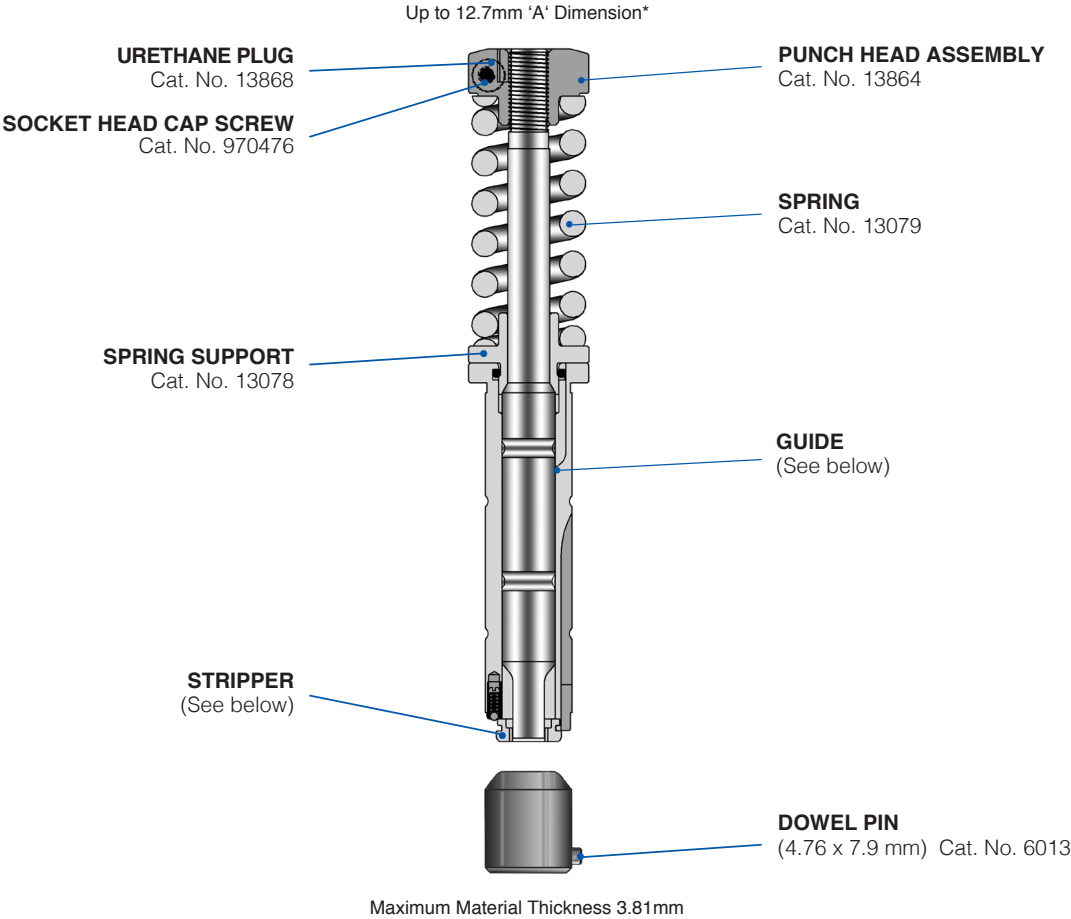
Wilson Metric-Style with Quick-Release Stripper Plate

See Pages 25-27

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	Standard	Premium
	Wilson Metric	Wilson Metric with Quick Release Stripper
Overall Value: Considering features, benefits and costs, will this tooling system reduce your costs and improve your profitability?
Innovation: Does this tool system contain innovative features and benefits?
Overall Tool Life: Does this tooling system have standard design features which prolong the life of the entire tool and machine turret, such as specialist materials, coatings, surface enhancements, and built-in lubrication systems?
Punch Grind Life: How long the tool can remain in the machine before being sharpened, and how much material that can be removed from the punch before it needs to be replaced?
Ease of Use: Does this tooling system lend itself to simple, fast set-ups and loading into the turret, without the use of tools and fixtures?
Fast tool set-up: Does the design of this tool allow for fast, accurate set-ups, keeping machine down time to a minimum?
LEAN Friendly: To what extent will working with this tooling system further your LEAN production aims?
Delivery time: Are these tooling styles available with next day shipping for standard shapes?
	Go To Pages 14-16	Go To Pages 25-27

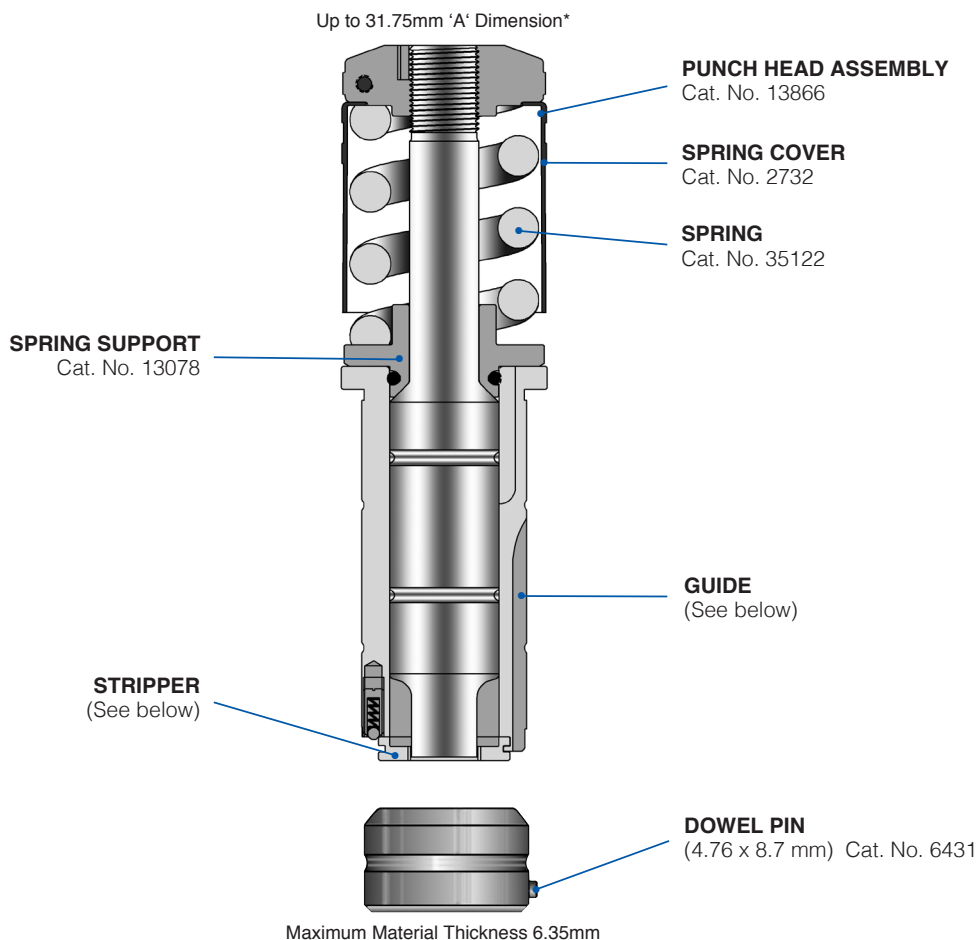
Basix Metric Style A Station



Description		Cat. No.	Price
Punch & Guide Assembly	• Round	13057	
	• Shape Fitted	13059	
	• Optima® Add On	-	
Punches	• Round	2183	
	• Shape	2182	
	• Optima® Add On	-	
Guides	• Round	13065	
	• Shape (0°)	13066	
	• Shape (0° & 45°)	13067	
	• Shape (0° & 90°)	13068	
Stripper	• Round	13044	
	• Shape Fitted	13143	
Dies	• Round Slug Hugger®†	2192	
	• Round Standard	1808	
	• Shape Slug Hugger®†	2193	
	• Shape Standard	13801	
	• Ultima™ Add On (Round)	-	
	• Ultima™ Add On (Shape)	-	

Notes
† Slug Hugger® dies must be ordered punch size plus clearance. Size restrictions apply. Slug Hugger 2 available on request. Contact Sales Desk for further information.
* 'A' Dimension = longest distance across shape.
• For add ons go to page 38.

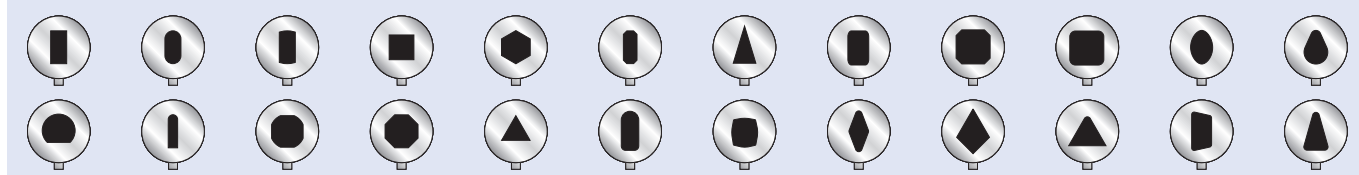
Standard Shapes & Key Locations (Die View)											



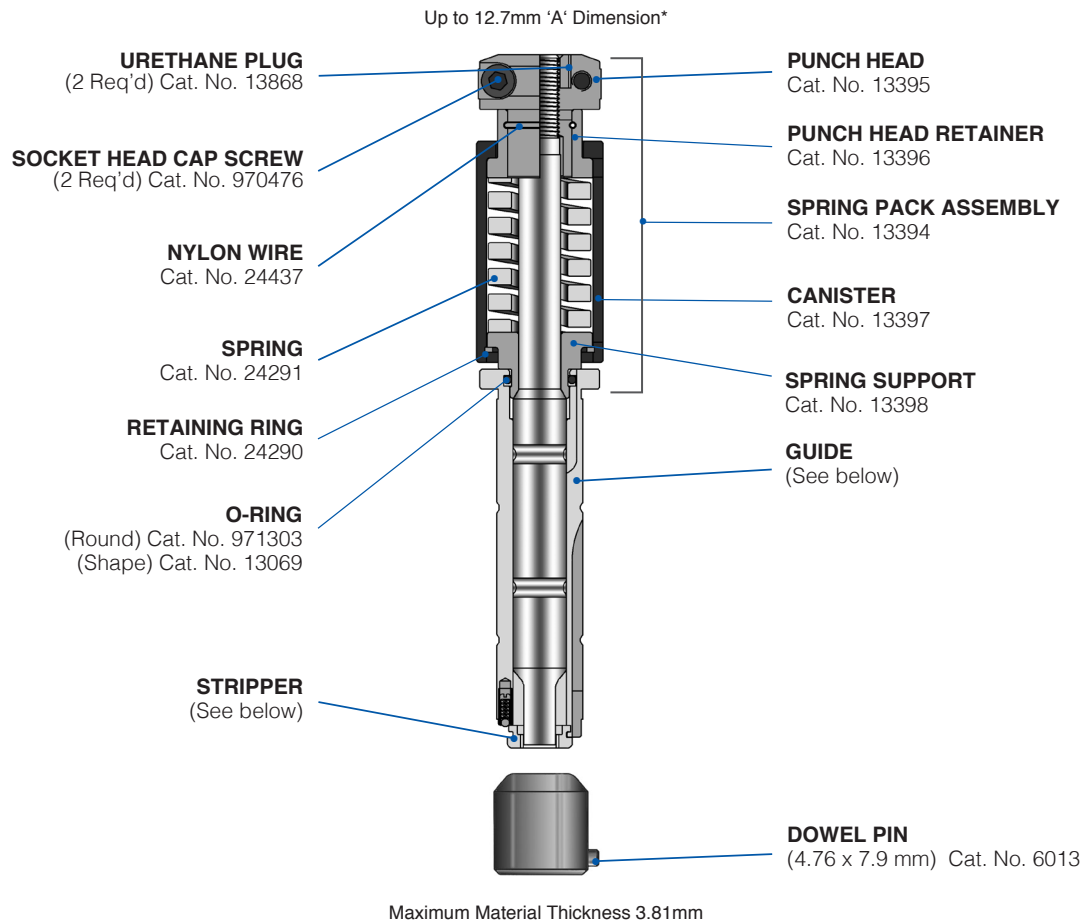
Description		Cat. No.	Price
Punch & Guide Assembly	• Round	13090	
	• Shape Fitted	13092	
	• Optima® Add On	-	
Punches	• Round	2185	
	• Shape	2184	
	• Optima® Add On	-	
Guides	• Round	13413	
	• Shape (0°)	13414	
	• Shape (0° & 45°)	13415	
	• Shape (0° & 90°)	13416	
Stripper	• Round	1890	
	• Shape Fitted	1917	
Dies	• Round Slug Hugger®†	2194	
	• Round Standard®†	2021	
	• Shape Slug Hugger	2195	
	• Shape Standard	13804	
	• Shape (0° & 45°) Positive	2263	
	• Shape (0° & 45°) Negative	2264	
	• Ultima™ Add On (Round)	-	
	• Ultima™ Add On (Shape)	-	

Notes
† Slug Hugger® dies must be ordered punch size plus clearance. Size restrictions apply. Slug Hugger 2 available on request. Contact Sales Desk for further information.
* 'A' Dimension = longest distance across shape.
• For add ons go to page 38.

Standard Shapes & Key Locations (Die View)



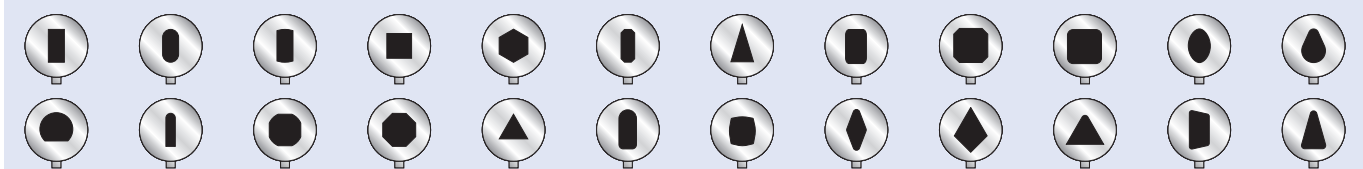
Quick Adjust A Station

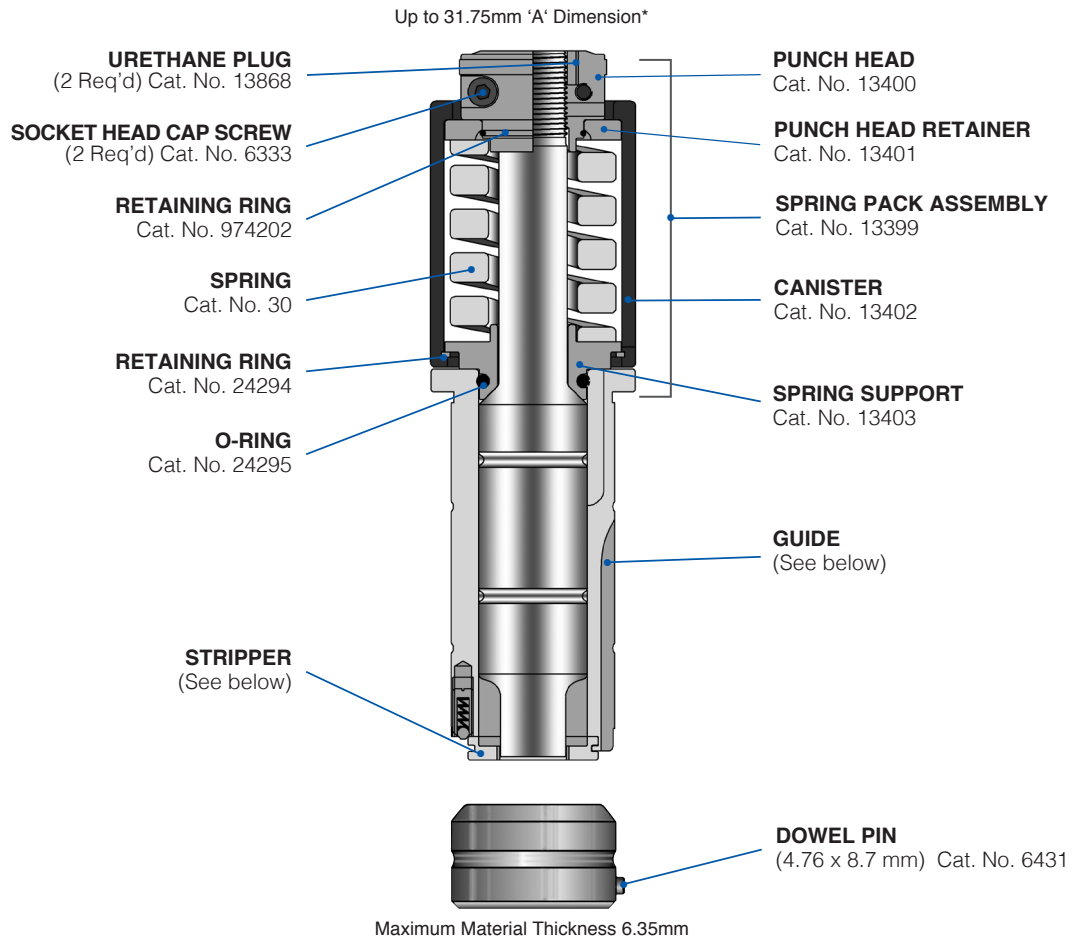


Description		Cat. No.	Price
Punch & Guide Assembly	• Round	13425	
	• Shape Fitted	13427	
	• Optima® Add On	-	
Punches	• Round	2183	
	• Shape	2182	
	• Optima® Add On	-	
Guides	• Round	13065	
	• Shape (0°)	13066	
	• Shape (0° & 45°)	13067	
	• Shape (0° & 90°)	13068	
Stripper	• Round	13044	
	• Shape Fitted	13143	
Dies	• Round Slug Hugger®†	2192	
	• Round Standard	1808	
	• Shape Slug Hugger®†	2193	
	• Shape Standard	13801	
	• Ultima™ Add On (Round)	-	
	• Ultima™ Add On (Shape)	-	

Notes
† Slug Hugger® dies must be ordered punch size plus clearance. Size restrictions apply. Slug Hugger 2 available on request. Contact Sales Desk for further information.
* 'A' Dimension = longest distance across shape.
• For add ons go to page 38.

Standard Shapes & Key Locations (Die View)

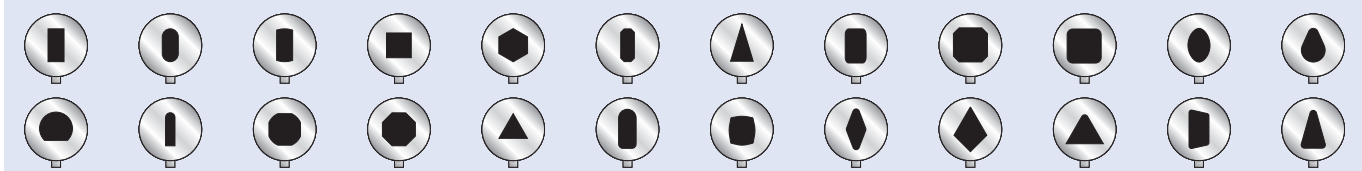


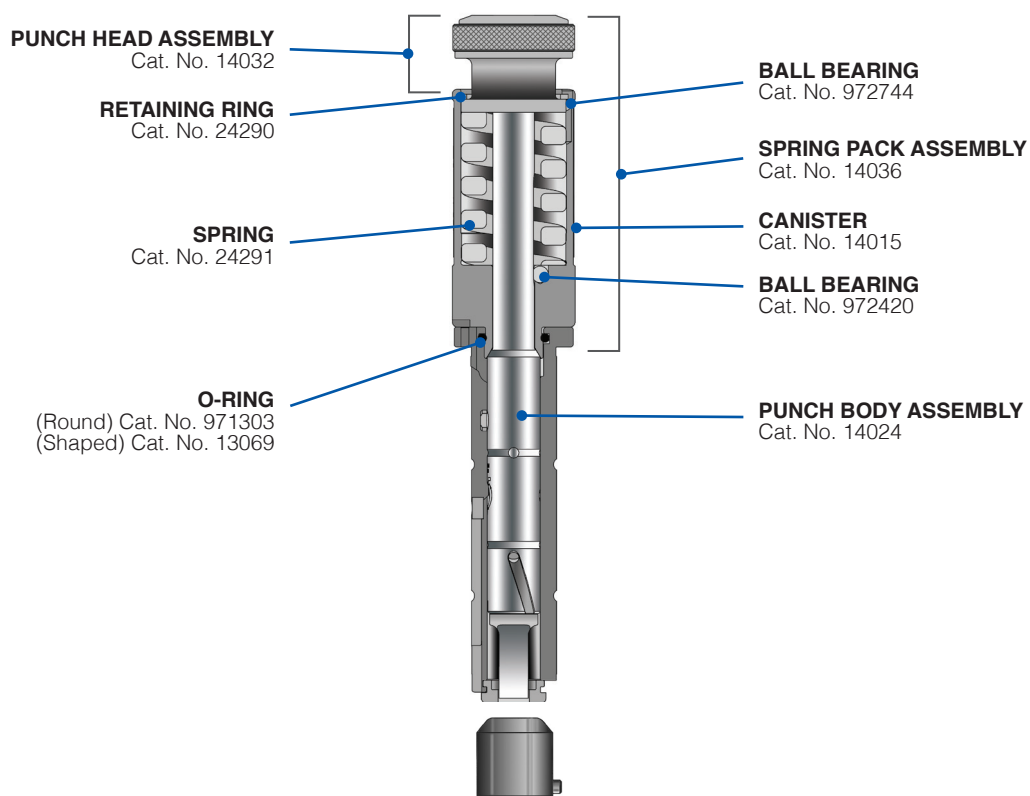


Description		Cat. No.	Price
Punch & Guide Assembly	• Round	13431	
	• Shape Fitted	13433	
	• Optima® Add On	-	
Punches	• Round	2185	
	• Shape	2184	
	• Optima® Add On	-	
Guides	• Round	13413	
	• Shape (0°)	13414	
	• Shape (0° & 45°)	13415	
	• Shape (0° & 90°)	13416	
Stripper	• Round	1890	
	• Shape Fitted	1917	
Dies	• Round Slug Hugger®†	2194	
	• Round Standard	2021	
	• Shape Slug Hugger®†	2195	
	• Shape Standard	13804	
	• Shape (0° & 45°) Positive	2263	
	• Shape (0° & 45°) Negative	2264	
	• Ultima™ Add On (Round)	-	
	• Ultima™ Add On (Shape)	-	

Notes
† Slug Hugger® dies must be ordered punch size plus clearance. Size restrictions apply. Slug Hugger 2 available on request. Contact Sales Desk for further information.
* 'A' Dimension = longest distance across shape.
• For add ons go to page 38.

Standard Shapes & Key Locations (Die View)

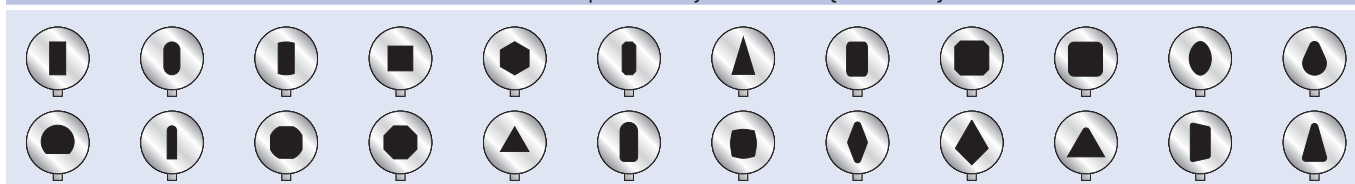


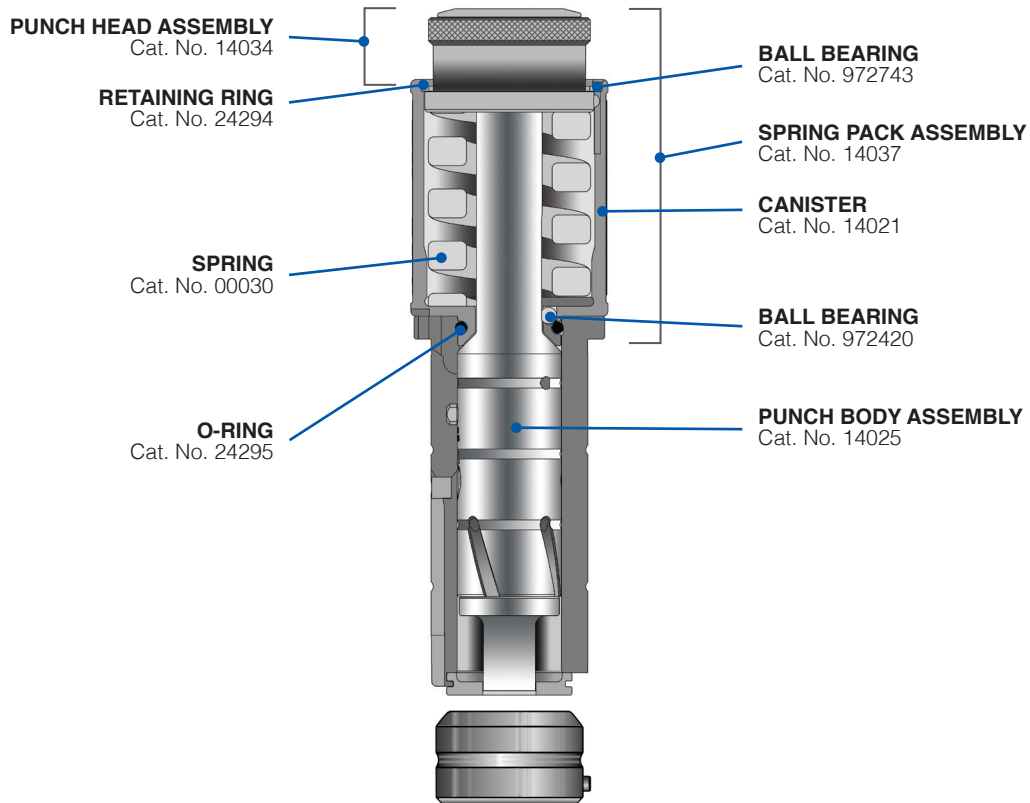


Description		Cat. No.	Price
Punch & Guide Assembly ¹	• Round	14026	
	• Shape Fitted	14012	
	• Optima® Add On	-	
Guide Assembly ²		14027	
Punches	• Round	13904	
	• Shape	13905	
	• Optima® Add On	-	
Guides	• Round	13073	
	• Shape (0°)	13074	
	• Shape (0° & 45°)	13075	
	• Shape (0° & 90°)	13076	
Stripper	• Round	13044	
	• Shape Fitted	13143	
Dies	• Round Slug Hugger®†	2192	
	• Round Standard	1808	
	• Shape Slug Hugger®†	2193	
	• Shape Standard	13801	
	• Ultima™ Add On (Round)	-	
	• Ultima™ Add On (Shape)	-	

Notes
<ul style="list-style-type: none"> • Fully compatible with ABS and non-ABS machines • For add ons go to page 38. <p>† Slug Hugger® dies must be ordered punch size plus clearance. Size restrictions apply. Slug Hugger 2 available on request. Contact Sales Desk for further information.</p> <p>* 'A' Dimension = longest distance across shape.</p> <p>1. Includes guide assembly, punch and stripper</p> <p>2. Guide assembly only. Punch and stripper to be bought separately.</p>

Standard Shapes & Key Locations [Die View]

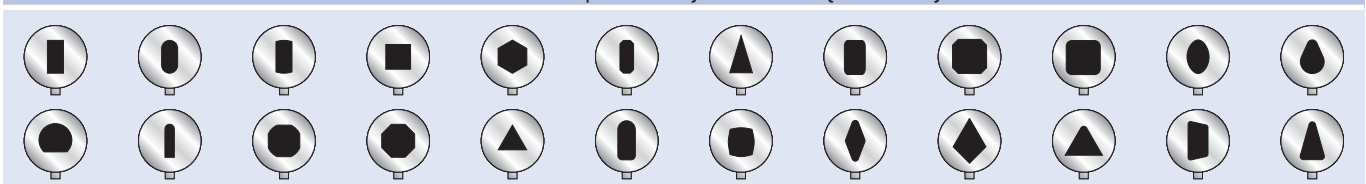




Description		Cat. No.	Price
Punch & Guide Assembly ¹	<ul style="list-style-type: none"> • Round • Shape Fitted • Optima® Add On 	14029 14018 -	
Guide Assembly ²		14030	
Punches	<ul style="list-style-type: none"> • Round • Shape • Optima® Add On 	13916 13917 -	
Guides	<ul style="list-style-type: none"> • Round • Shape (0°) • Shape (0° & 45°) • Shape (0° & 90°) 	13097 13098 13099 13100	
Stripper	<ul style="list-style-type: none"> • Round • Shape Fitted 	1890 1917	
Dies	<ul style="list-style-type: none"> • Round Slug Hugger®† • Round Standard • Shape Slug Hugger®† • Shape Standard • Ultima™ Add On (Round) • Ultima™ Add On (Shape) 	2194 2021 2195 13804 - -	

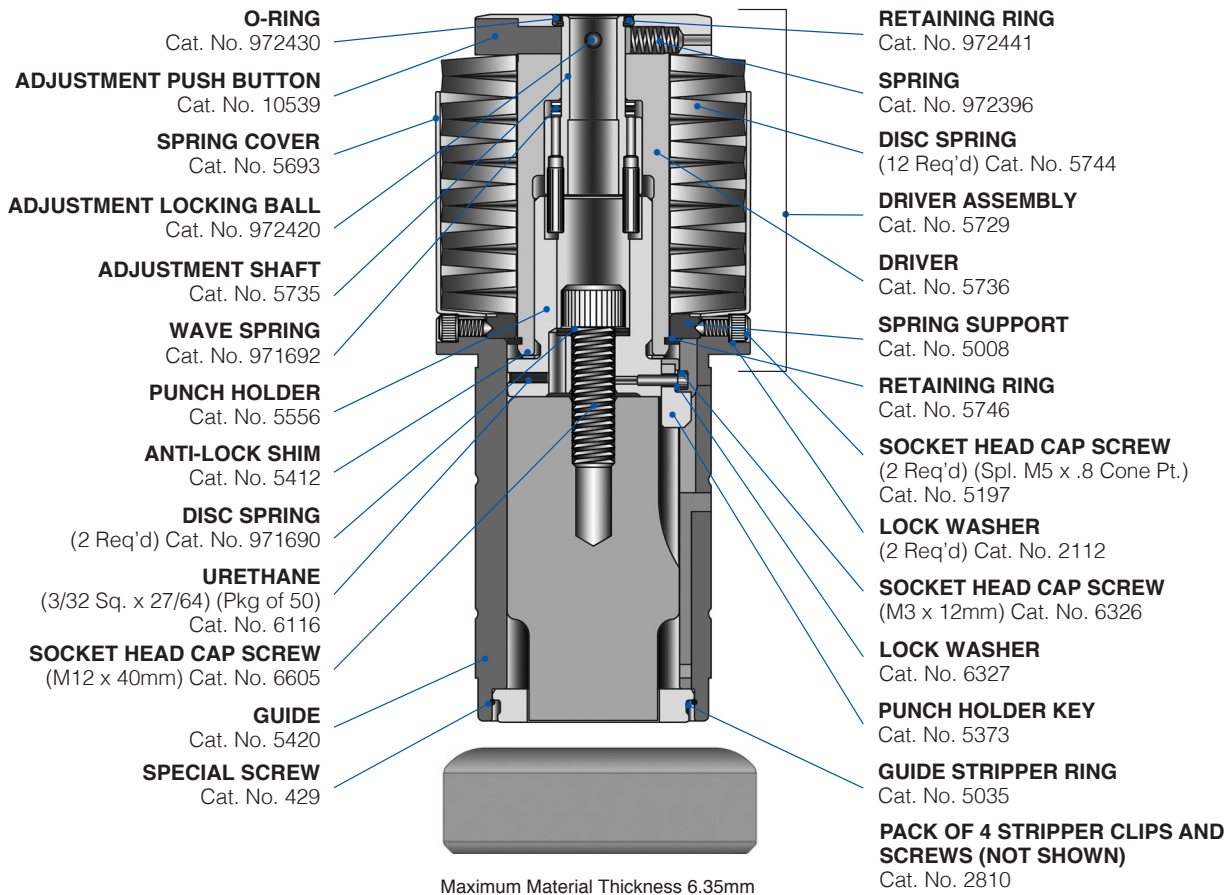
Notes
<ul style="list-style-type: none"> • Fully compatible with ABS and non-ABS machines • For add ons go to page 38. <p>† Slug Hugger® dies must be ordered punch size plus clearance. Size restrictions apply. Slug Hugger 2 available on request. Contact Sales Desk for further information.</p> <p>* 'A' Dimension = longest distance across shape.</p> <p>1. Includes guide assembly, punch and stripper</p> <p>2. Guide assembly only. Punch and stripper to be bought separately.</p>

Standard Shapes & Key Locations [Die View]



Wilson Metric Style C Station

STRIPPER RETAINED WITH WIRE LOCK RING OR STRIPPER CLIPS
Up to 50.8mm 'A' Dimension*



Description		Cat. No.	Price
Guide Assembly	• Standard	5583	
	• Standard (LVD)	35191	
	• Standard WLS®	5592	
	• Standard WLS® (LVD)	35193	
Punches	• Round	1933	
	• Shape	1934	
	• Optima® Add On	-	
Strippers	• Round	1848	
	• Shape	1854	
Dies	• Round Slug Hugger®†	2196	
	• Round Standard	1850	
	• Shape Slug Hugger®†	2197	
	• Shape Standard	13807	
	• Ultima™ Add On (Round)	-	
	• Ultima™ Add On (Shape)	-	

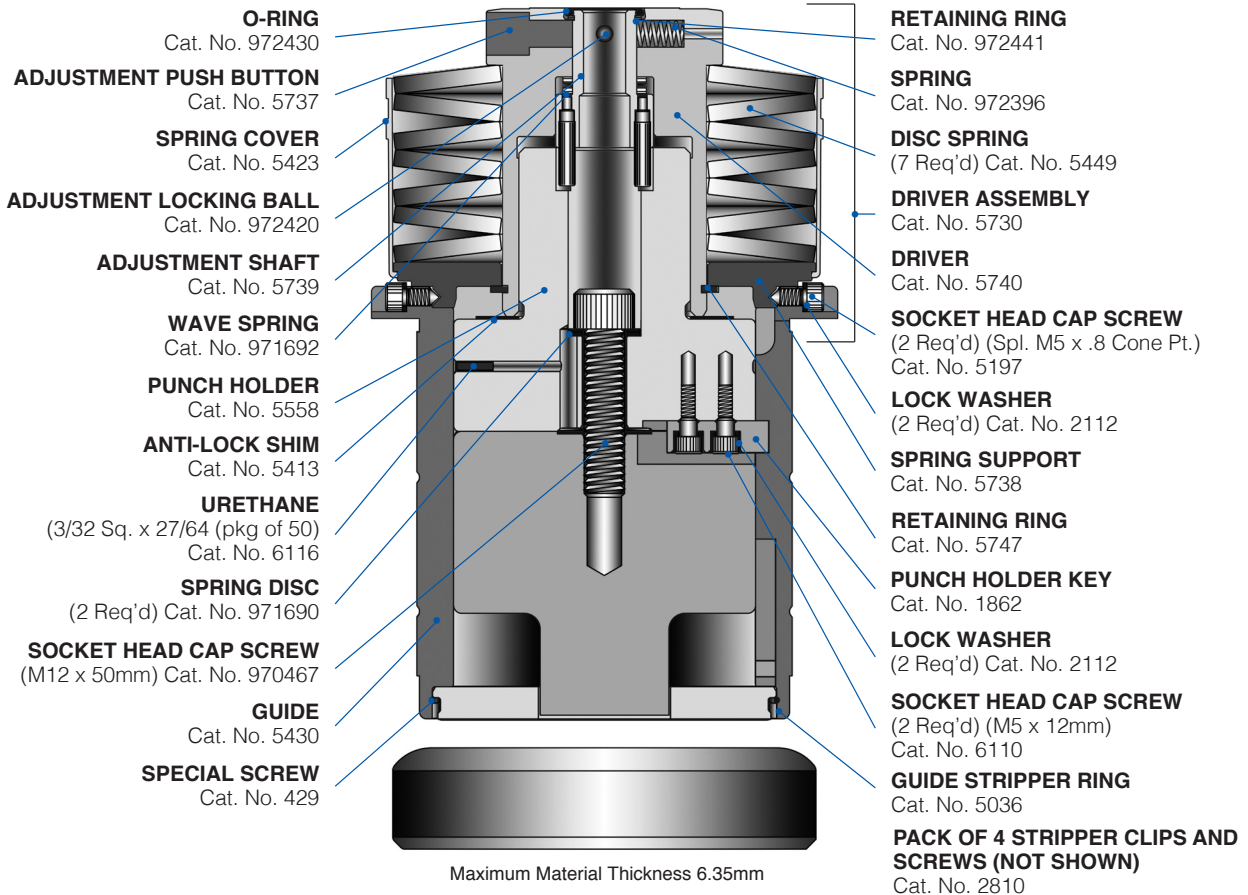
Notes
Standard guide assys. are keyed for shapes at 0°, 90° and 225°. All punches will be shipped with no shear unless specified. †Slug Hugger® dies must be ordered punch size plus clearance. Size restrictions apply. Slug Hugger 2 available on request. Contact Sales Desk for further information. * 'A' Dimension = longest distance across shape. • For add ons go to page 38.

Standard Shapes & Key Locations (Die View)											

Wilson Metric Style D Station

STRIPPER RETAINED WITH WIRE LOCK RING OR STRIPPER CLIPS

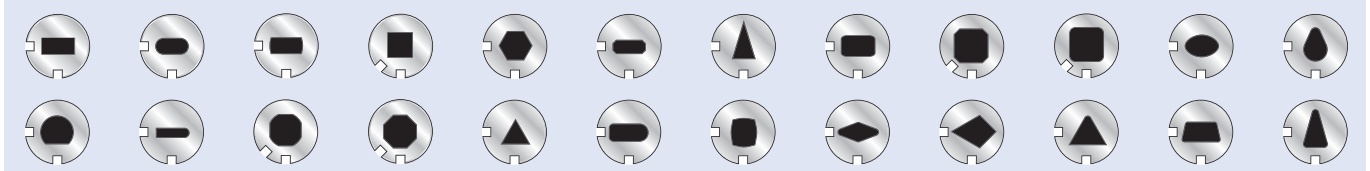
Up to 88.9mm 'A' Dimension*



Description		Cat. No.	Price
Guide Assembly	• Standard	5584	
	• Standard (LVD)	35198	
	• Standard WLS®	5593	
	• Standard WLS® (LVD)	35200	
Punches	• Round	1937	
	• Shape	1938	
	• Optima® Add On	-	
Strippers	• Round	1864	
	• Shape	1869	
Dies	• Round Slug Hugger®†	2198	
	• Round Standard	1865	
	• Shape Slug Hugger®†	2199	
	• Shape Standard	13810	
	• Ultima™ Add On (Round)	-	
	• Ultima™ Add On (Shape)	-	

Notes
Standard guide assys. are keyed for shapes at 0°, 90° & 225°.
1.6mm Rooftop shear is given to all punches with 'A' dimension greater than 50.8mm, and width greater than 6.35mm, at no extra charge.
All punches 6.35mm and under in width will be shipped with no shear unless specified.
† Slug Hugger® dies must be ordered punch size plus clearance. Size restrictions apply. Slug Hugger 2 available on request. Contact Sales Desk for further information.
* 'A' Dimension = longest distance across shape.
• For add ons go to page 38.

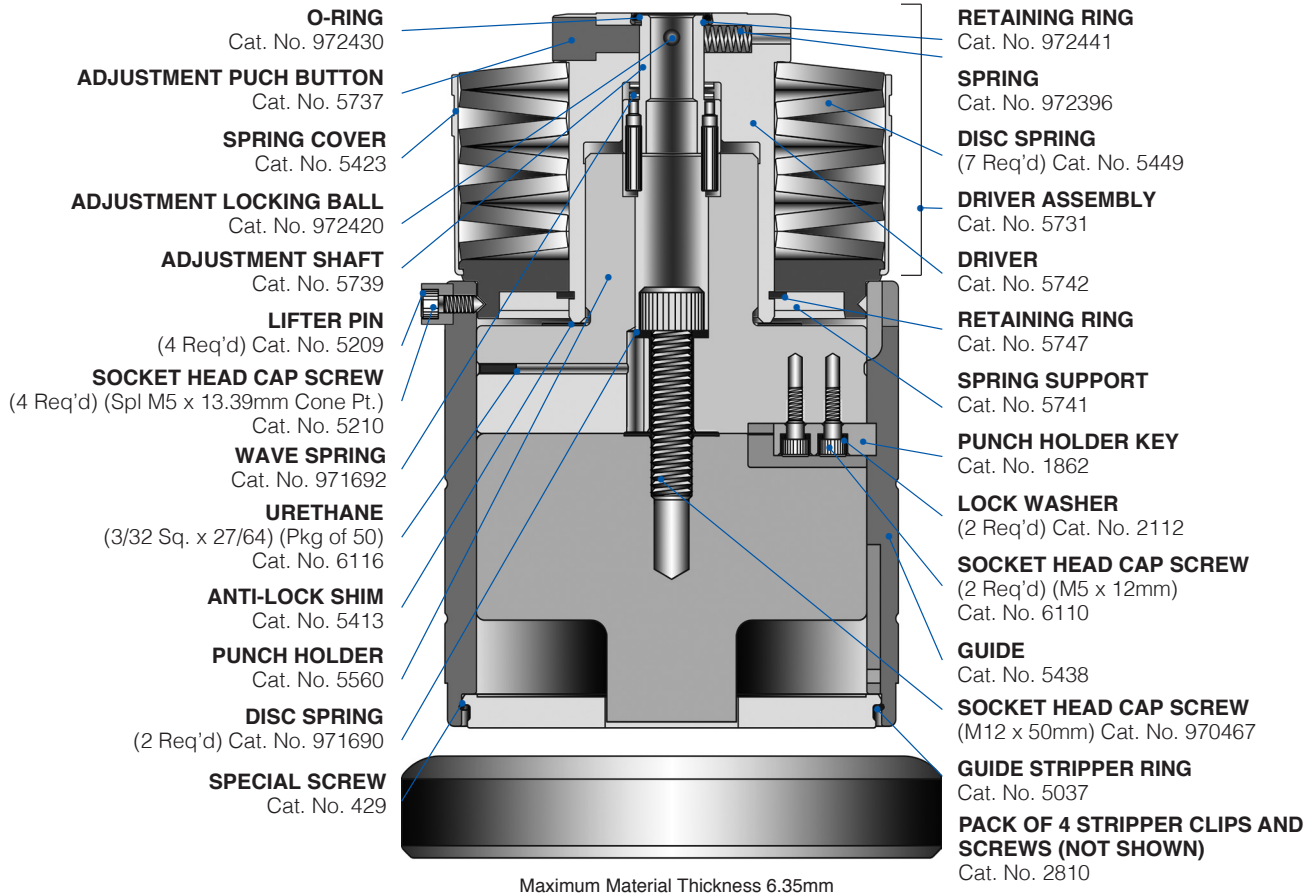
Standard Shapes & Key Locations (Die View)



Wilson Metric Style E Station

STRIPPER RETAINED WITH WIRE LOCK RING OR STRIPPER CLIPS

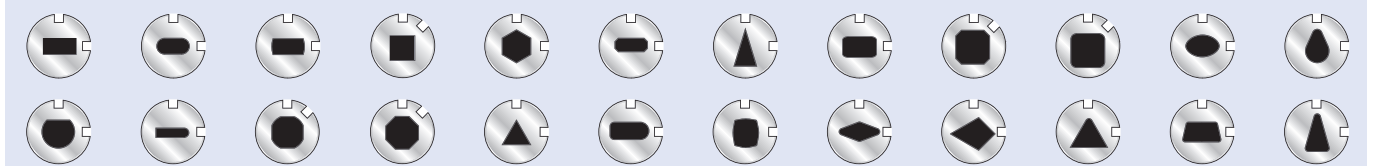
Up to 114.3mm 'A' Dimension*



Description		Cat. No.	Price
Guide Assembly	• Standard	5585	
	• Standard WLS®	5594	
Punches	• Round	1941	
	• Shape	1942	
	• Optima® Add On	-	
Strippers	• Round	1877	
	• Shape	1882	
Dies	• Round Slug Hugger®†	2200	
	• Round Standard	1878	
	• Shape Slug Hugger®†	2201	
	• Shape Standard	13817	
	• Ultima™ Add On (Round)	-	
	• Ultima™ Add On (Shape)	-	

Notes
Standard guide assys. are keyed for shapes at 0° & 90°.
1.6mm Rooftop shear is given to all punches with 'A' dimension greater than 50.8mm, and width greater than 6.35mm, at no extra charge.
All punches 6.35mm and under in width will be shipped with no shear unless specified.
† Slug Hugger® dies must be ordered punch size plus clearance. Size restrictions apply. Slug Hugger 2 available on request. Contact Sales Desk for further information.
* 'A' Dimension = longest distance across shape.
• For add ons go to page 38.

Standard Shapes & Key Locations (Die View)



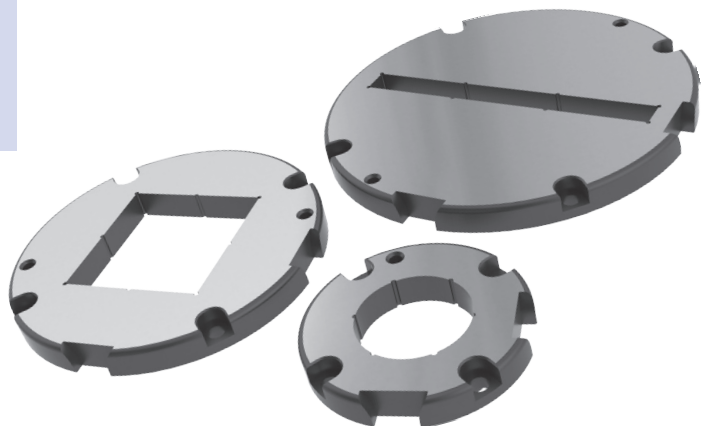
Wilson Amada® Style ABS Punches, Bolt-on Strippers and Punch Assemblies now available from Wilson Tool.



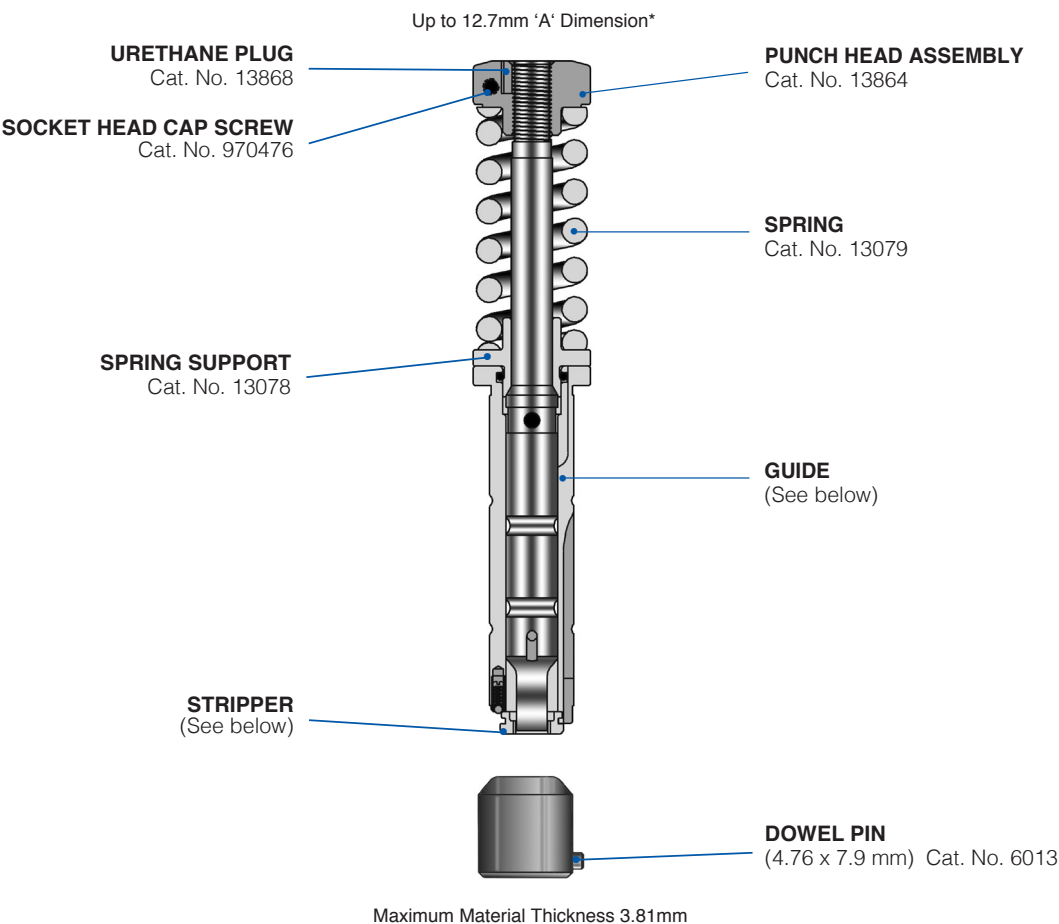
Punches, guides and strippers are fully compatible and interchangeable with Amada® original ABS tooling.

Description		Cat. No.	Price
Bolt-on Strippers	C Station		
	• Round	13629	
	• Shape	13630	
	D Station		
	• Round	13631	
	• Shape	13632	
	E Station		
	• Round	13633	
	• Shape	13634	

Bolt-on strippers are available for Amada® manufactured holders only.



Wilson Metric Style ABS A Station

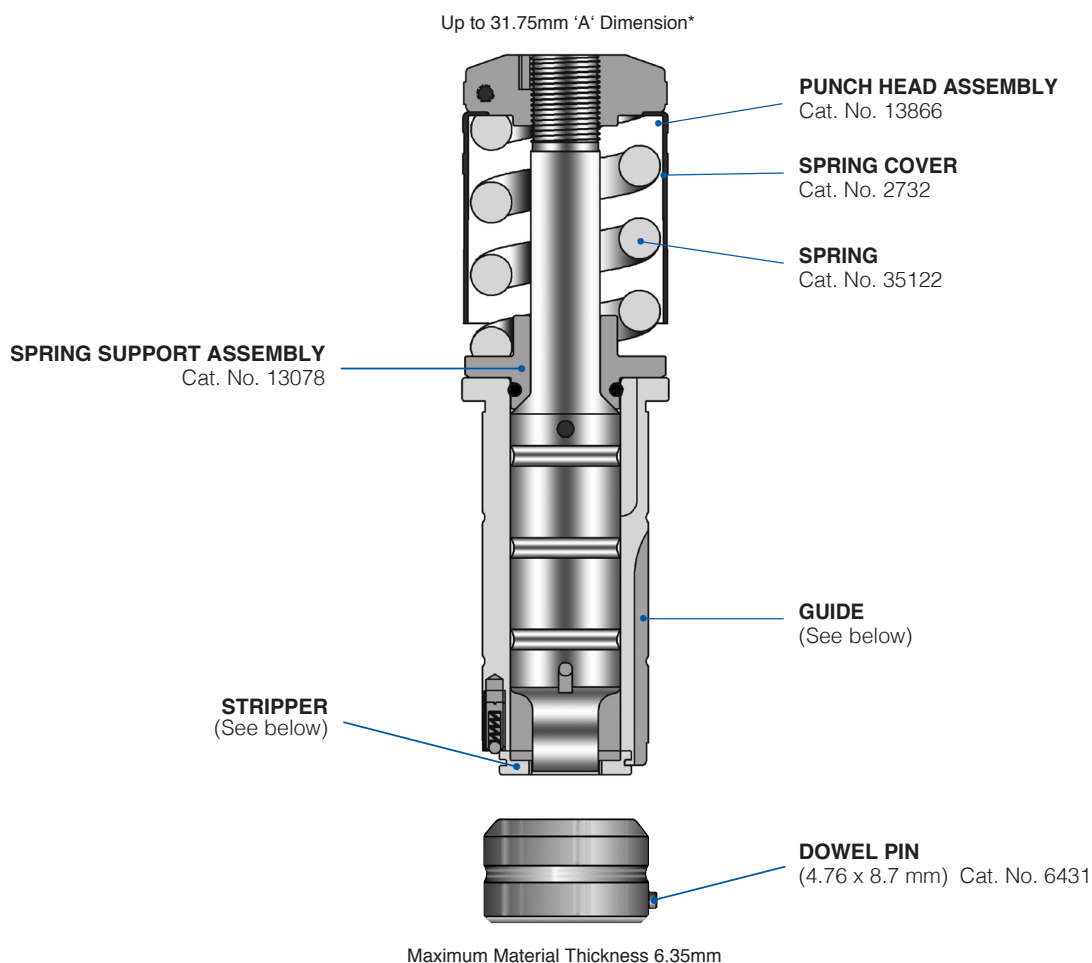


Description		Cat. No.	Price
Punch & Guide Assembly	• Round	13856	
	• Shape Fitted	13858	
	• Optima® Add On	-	
Punches	• Round	13827	
	• Shape	13870	
	• Optima® Add On	-	
Guides	• Round	13073	
	• Shape (0°)	13074	
	• Shape (0° & 45°)	13075	
	• Shape (0° & 90°)	13076	
Stripper	• Round	13045	
	• Shape Fitted	13152	
Dies	• Round Slug Hugger®†	2192	
	• Round Standard	1808	
	• Shape Slug Hugger®†	2193	
	• Shape Standard	13801	
	• Ultima™ Add On (Round)	-	
	• Ultima™ Add On (Shape)	-	

Notes
† Slug Hugger® dies must be ordered punch size plus clearance. Size restrictions apply. Contact Sales Desk for further information. Slug Hugger 2 available on request.
* 'A' Dimension = longest distance across shape.
• For add ons go to page 38.

Standard Shapes & Key Locations (Die View)											

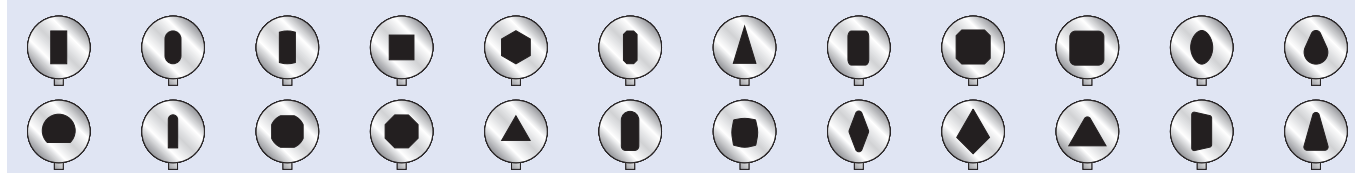
Wilson Metric Style ABS B Station



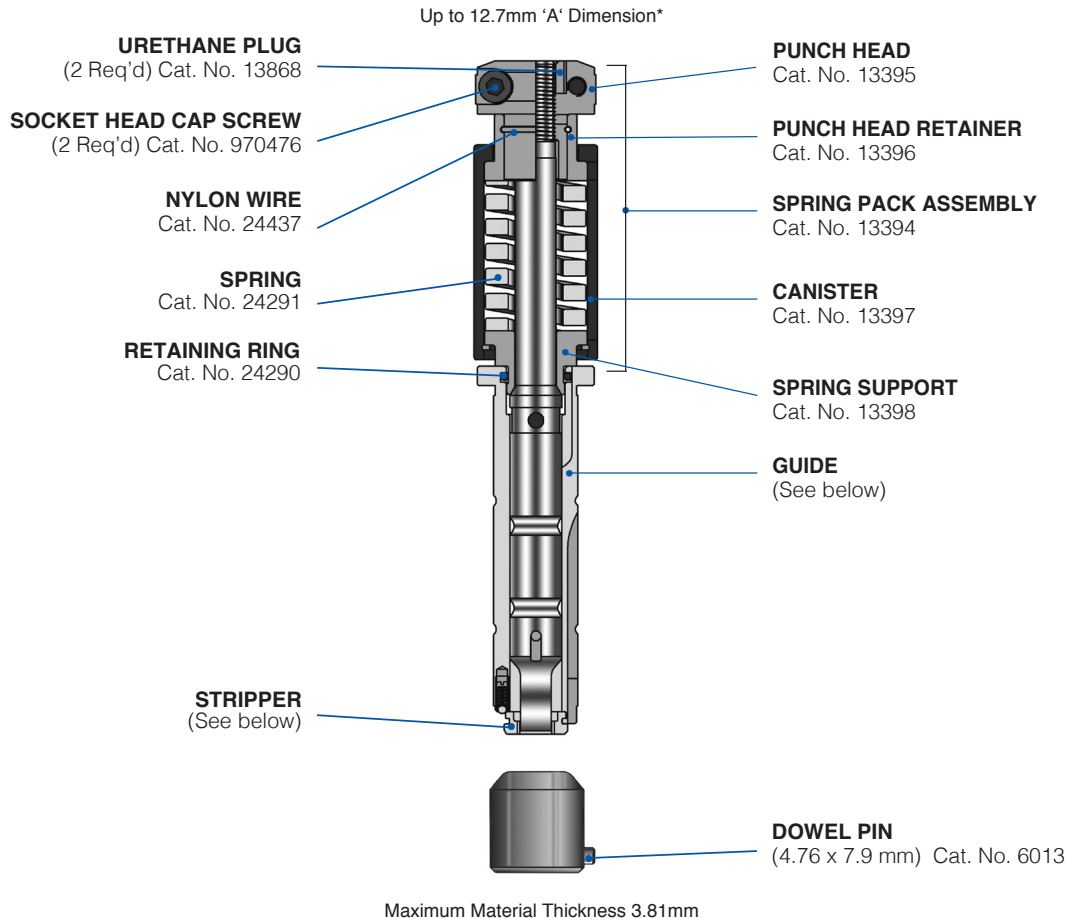
Description		Cat. No.	Price
Punch & Guide Assembly	• Round	13860	
	• Shape Fitted	13862	
	• Optima® Add On	-	
Punches	• Round	13828	
	• Shape	13872	
	• Optima® Add On	-	
Guides	• Round	13097	
	• Shape (0°)	13098	
	• Shape (0° & 45°)	13099	
	• Shape (0° & 90°)	13100	
Stripper	• Round	2433	
	• Shape Fitted	2432	
Dies	• Round Slug Hugger®†	2194	
	• Round Standard	2021	
	• Shape Slug Hugger®†	2195	
	• Shape Standard	13804	
	• Ultima™ Add On (Round)	-	
	• Ultima™ Add On (Shape)	-	

Notes
† Slug Hugger® dies must be ordered punch size plus clearance. Size restrictions apply. Slug Hugger 2 available on request. Contact Sales Desk for further information.
* 'A' Dimension = longest distance across shape.
• For add ons go to page 38.

Standard Shapes & Key Locations (Die View)



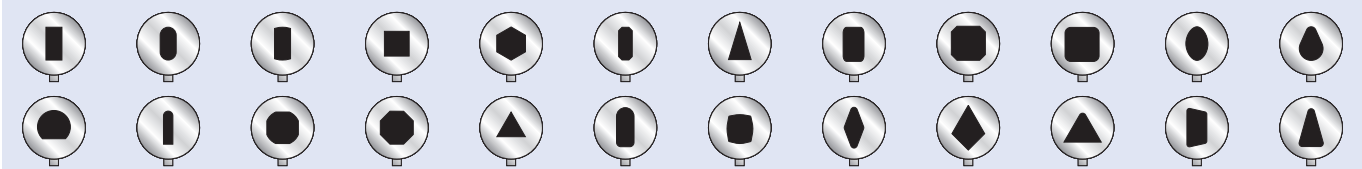
ABS Quick Adjust A Station

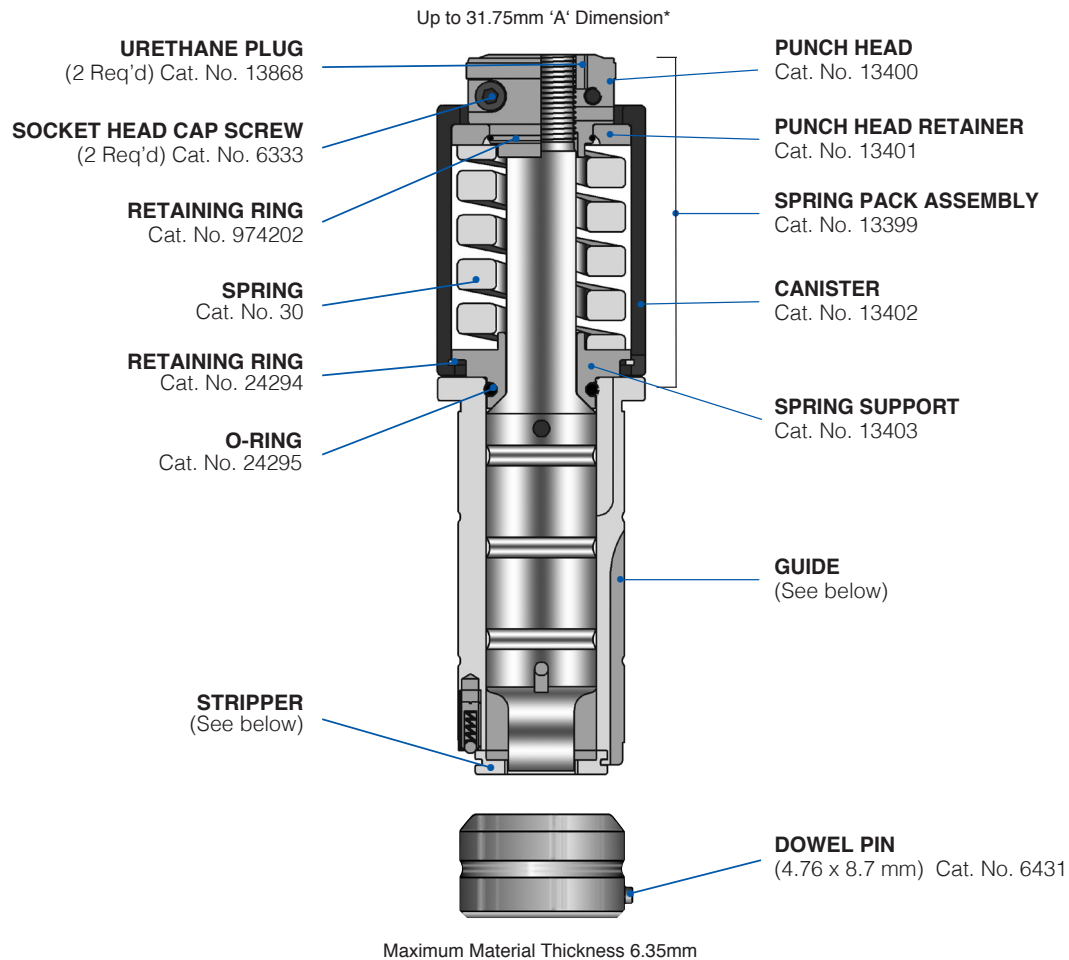


Description		Cat. No.	Price
Punch & Guide Assembly	• Round	13823	
	• Shape Fitted	13824	
	• Optima® Add On	-	
Punches	• Round	13827	
	• Shape	13870	
	• Optima® Add On	-	
Guides	• Round	13073	
	• Shape (0°)	13074	
	• Shape (0° & 45°)	13075	
	• Shape (0° & 90°)	13076	
Stripper	• Round	13045	
	• Shape Fitted	13152	
Dies	• Round Slug Hugger®†	2192	
	• Round Standard	1808	
	• Shape Slug Hugger®†	2193	
	• Shape Standard	13801	
	• Ultima™ Add On (Round)	-	
	• Ultima™ Add On (Shape)	-	

Notes
† Slug Hugger® dies must be ordered punch size plus clearance. Size restrictions apply. Contact Sales Desk for further information. Slug Hugger 2 available on request.
* 'A' Dimension = longest distance across shape.
• For add ons go to page 38.

Standard Shapes & Key Locations (Die View)





Description		Cat. No.	Price
Punch & Guide Assembly	• Round	13825	
	• Shape Fitted	13826	
	• Optima® Add On	-	
Punches	• Round	13828	
	• Shape	13872	
	• Optima® Add On	-	
Guides	• Round	13097	
	• Shape (0°)	13098	
	• Shape (0° & 45°)	13099	
	• Shape (0° & 90°)	13100	
Stripper	• Round	2433	
	• Shape Fitted	2432	
Dies	• Round Slug Hugger®†	2194	
	• Round Standard	2021	
	• Shape Slug Hugger®†	2195	
	• Shape Standard	13804	
	• Ultima™ Add On (Round)	-	
	• Ultima™ Add On (Shape)	-	

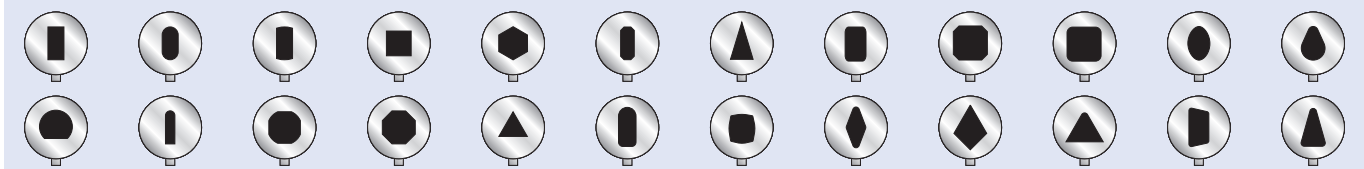
Notes

† Slug Hugger® dies must be ordered punch size plus clearance. Size restrictions apply. Slug Hugger 2 available on request. Contact Sales Desk for further information.

* 'A' Dimension = longest distance across shape.

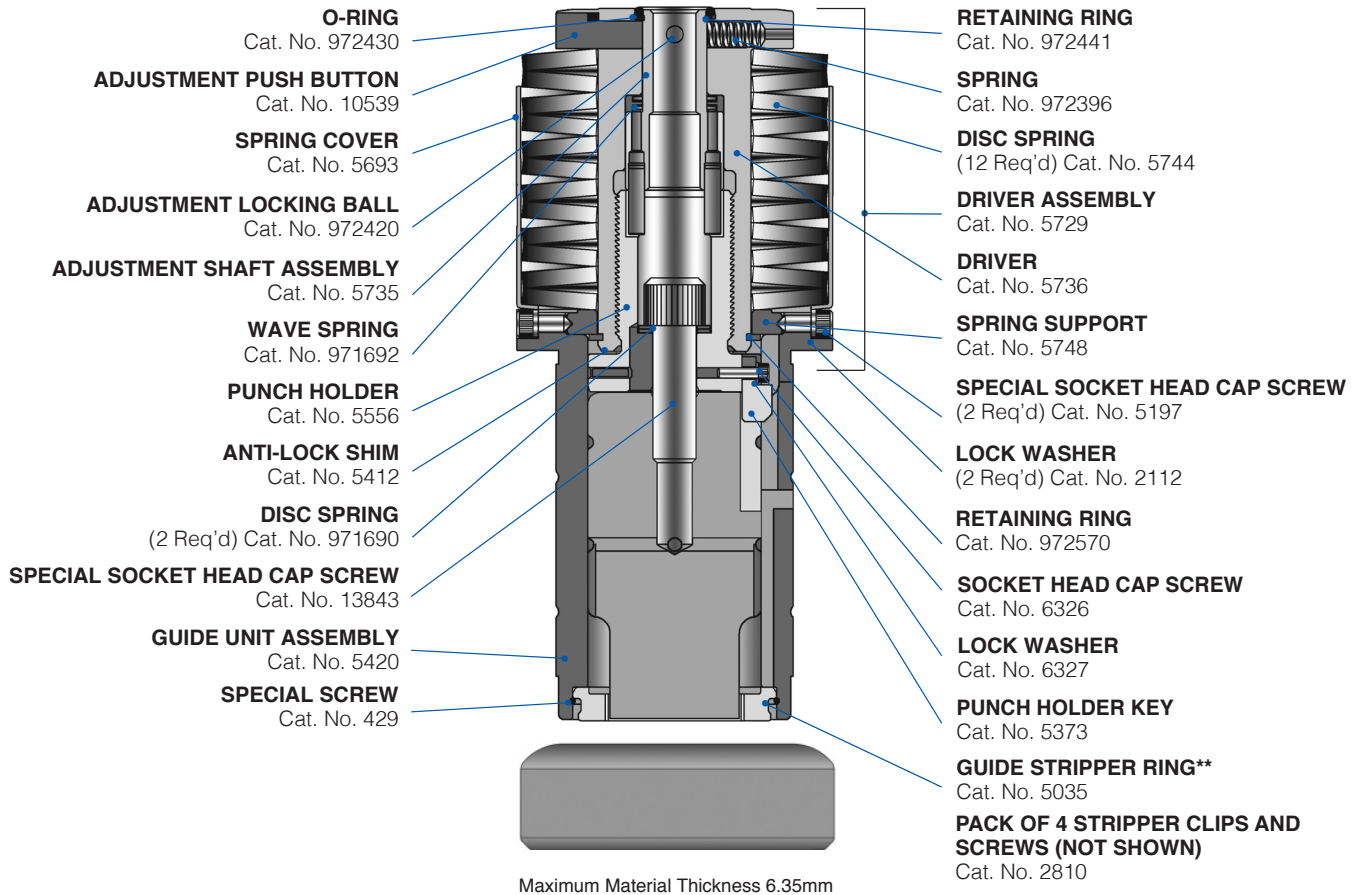
- For add ons go to page 38.

Standard Shapes & Key Locations (Die View)



Wilson Metric Style ABS C Station

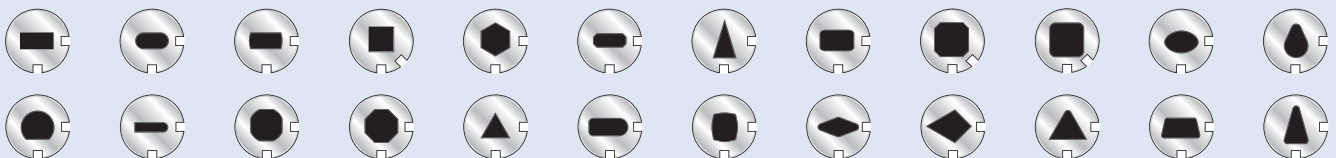
STRIPPER RETAINED WITH STRIPPER CLIPS Up to 50.8mm 'A' Dimension*



Description		Cat. No.	Price
Guide Assembly		13084	
Punches	• Round	13614	
	• Shape	13615	
	• Optima® Add On	-	
Strippers	• Round	5150	
	• Shape	5151	
Dies	• Round Slug Hugger®†	2196	
	• Round Standard	1850	
	• Shape Slug Hugger®†	2197	
	• Shape Standard	13807	
	• Ultima™ Add On (Round)	-	
	• Ultima™ Add On (Shape)	-	

Notes
Standard guide assys. are keyed for shapes at 0°, 90° and 225°.
All punches will be shipped with no shear unless specified.
† Slug Hugger® dies must be ordered punch size plus clearance. Size restrictions apply.
Slug Hugger 2 available on request. Contact Sales Desk for further information.
** Stripper ring must be used with 4X blanking screws Cat No. 5006 & washers 970485 for ABS (supplied and assembled).
Cat No. 2810 pack of 4 stripper clips & screws supplied but not assembled as an alternative method to hold stripper.
* 'A' Dimension = longest distance across shape.
• For add ons go to page 38.

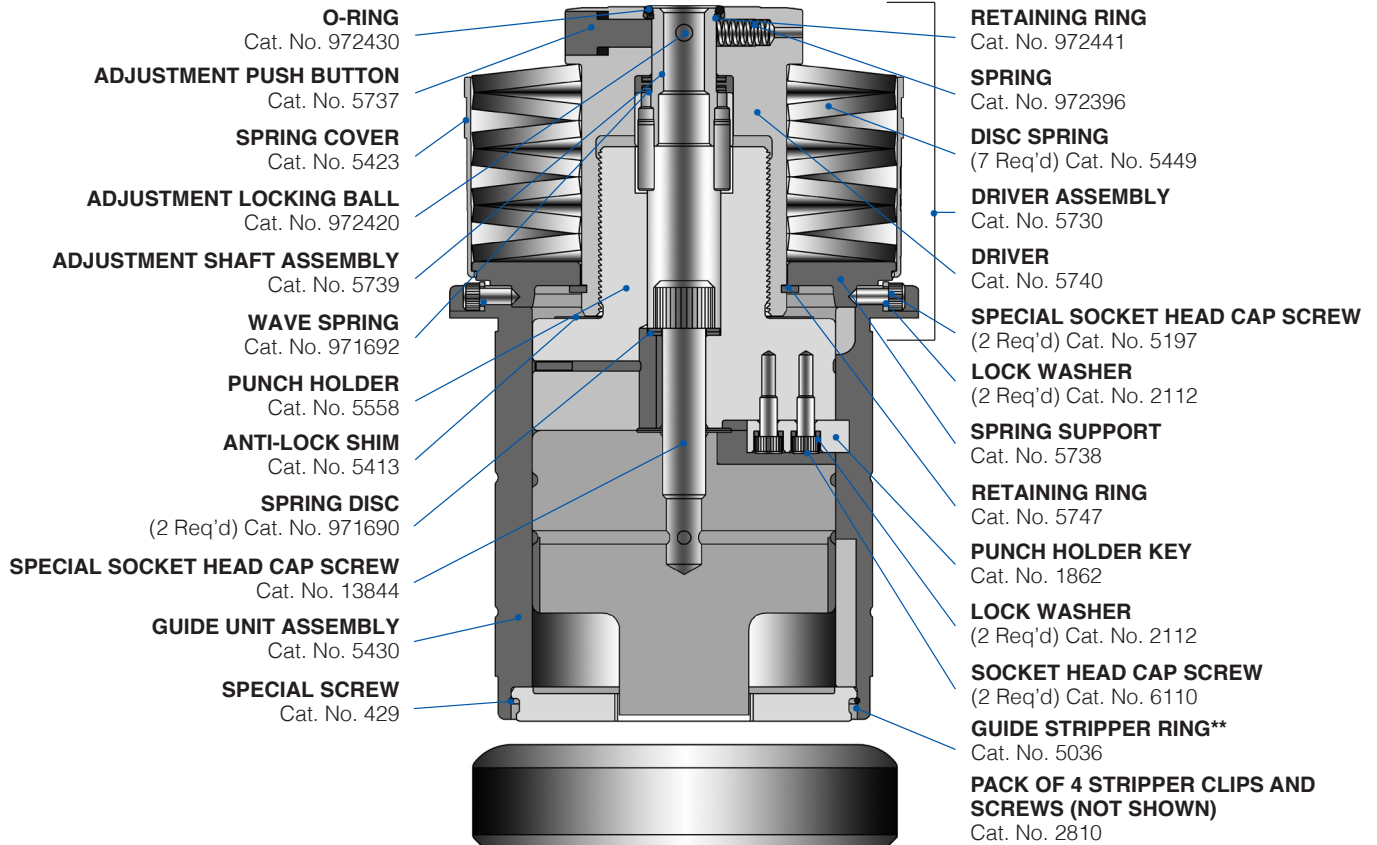
Standard Shapes & Key Locations (Die View)



Wilson Metric Style ABS D Station

STRIPPER RETAINED WITH STRIPPER CLIPS

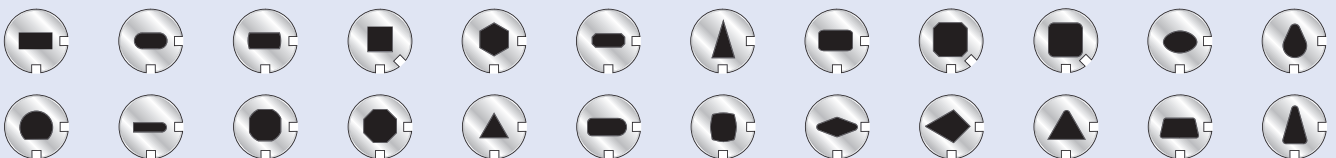
Up to 88.9mm 'A' Dimension*



Description		Cat. No.	Price
Guide Assembly		13085	
Punches	• Round • Shape • Optima® Add On	13616 13617 -	
Strippers	• Round • Shape	5152 5153	
Dies	• Round Slug Hugger®† • Round Standard • Shape Slug Hugger®† • Shape Standard • Ultima™ Add On (Round) • Ultima™ Add On (Shape)	2198 1865 2199 13810 - -	

Notes
Standard guide assys. are keyed for shapes at 0°, 90° and 225°.
All punches will be shipped with no shear unless specified.
†Slug Hugger® dies must be ordered punch size plus clearance. Size restrictions apply.
Slug Hugger 2 available on request. Contact Sales Desk for further information.
** Stripper ring must be used with 4X blanking screws Cat No. 5006 & washers 970485 for ABS (supplied and assembled). Cat No. 2810 pack of 4 stripper clips & screws supplied but not assembled as an alternative method to hold strippers.
* 'A' Dimension = longest distance across shape.
• For add ons go to page 38.

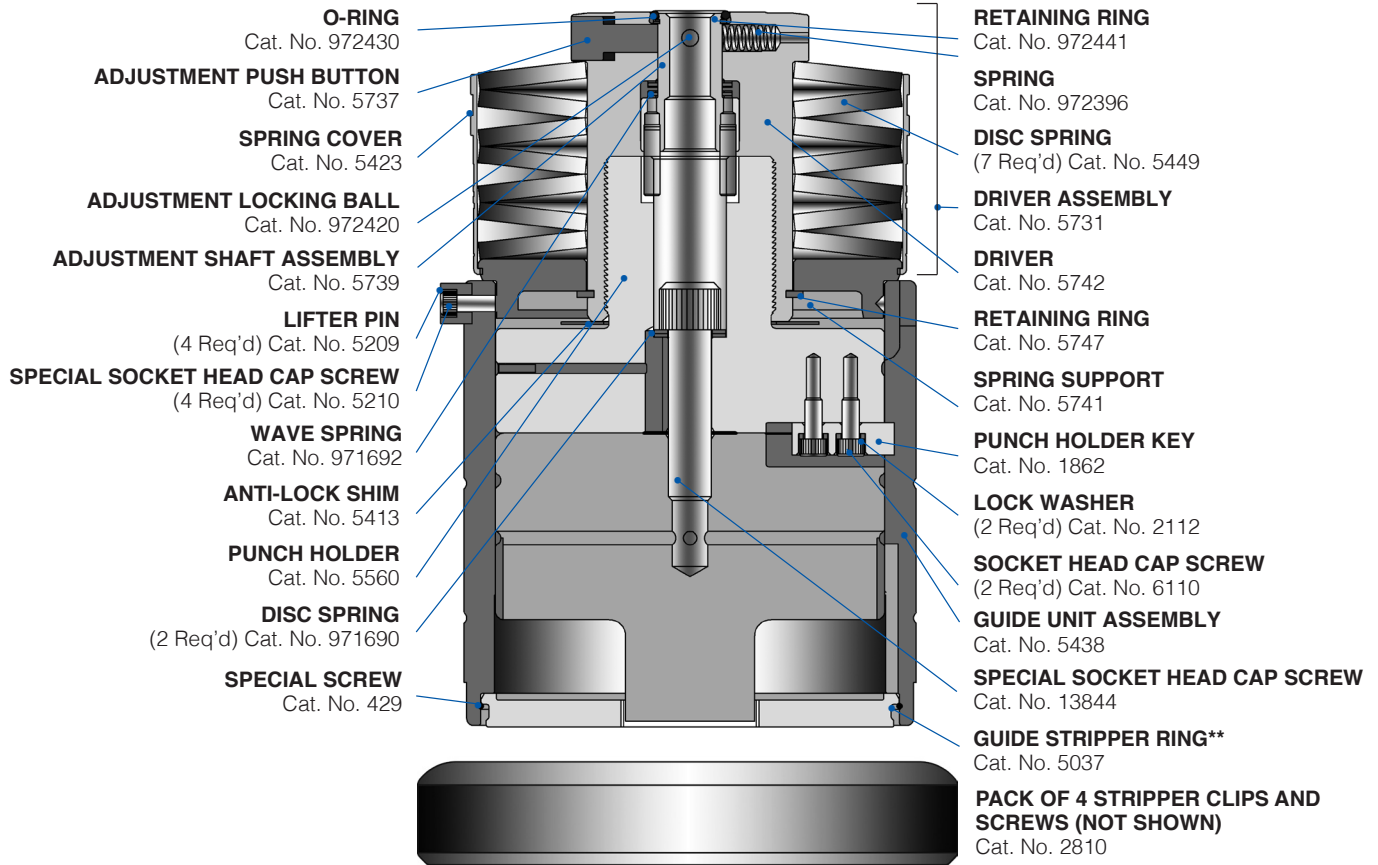
Standard Shapes & Key Locations (Die View)



Wilson Metric Style ABS E Station

STRIPPER RETAINED WITH STRIPPER CLIPS

Up to 114.3mm 'A' Dimension*

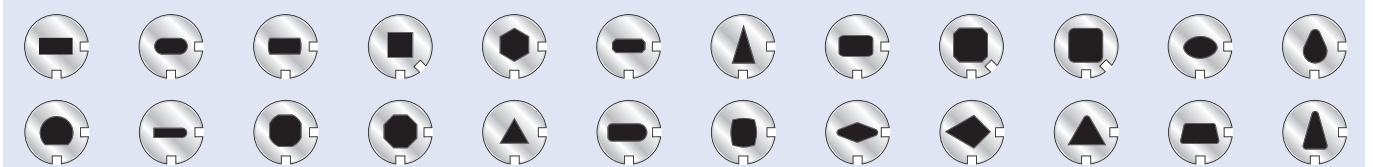


Maximum Material Thickness 6.35mm

Description		Cat. No.	Price
Guide Assembly		13088	
Punches	• Round	13618	
	• Shape	13619	
	• Optima® Add On	-	
Strippers	• Round	5154	
	• Shape	5155	
Dies	• Round Slug Hugger®†	2200	
	• Round Standard	1878	
	• Shape Slug Hugger®†	2201	
	• Shape Standard	13817	
	• Ultima™ Add On (Round)	-	
	• Ultima™ Add On (Shape)	-	

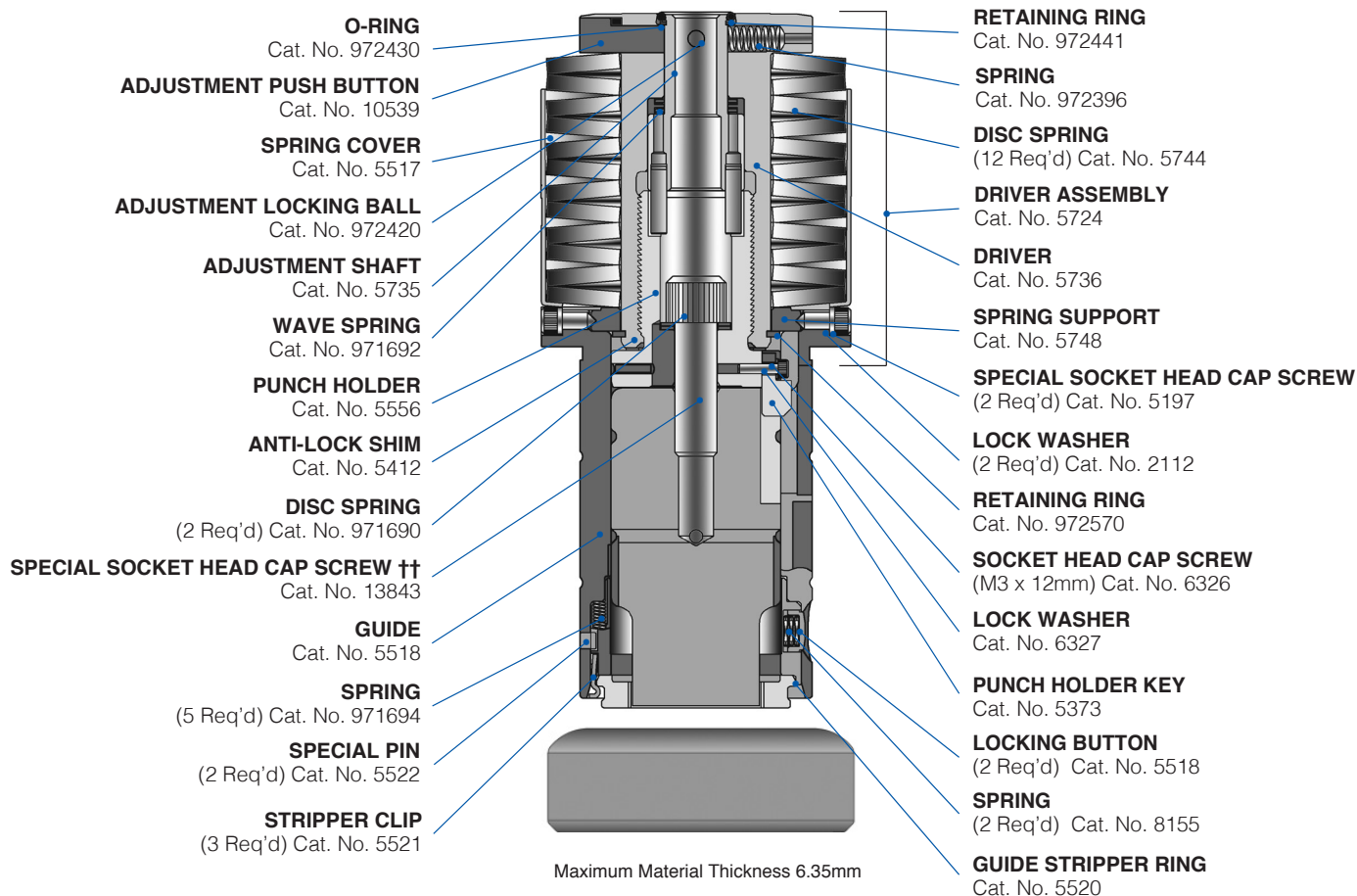
Notes
Standard guide assys. are keyed for shapes at 0°, 90° and 225°.
All punches will be shipped with no shear unless specified.
†Slug Hugger® dies must be ordered punch size plus clearance.
Size restrictions apply.
Slug Hugger 2 available on request. Contact Sales Desk for further information.
** Stripper ring must be used with 4X blanking screws Cat No. 5006 & washers 970485 for ABS (supplied with assembled).
Cat No. 2810 pack of 4 stripper clips & screws supplied but not assembled as an alternative method to hold strippers.
* 'A' Dimension = longest distance across shape.
• For add ons go to page 38.

Standard Shapes & Key Locations (Die View)



Wilson Metric Style ABS Quick Release C Station

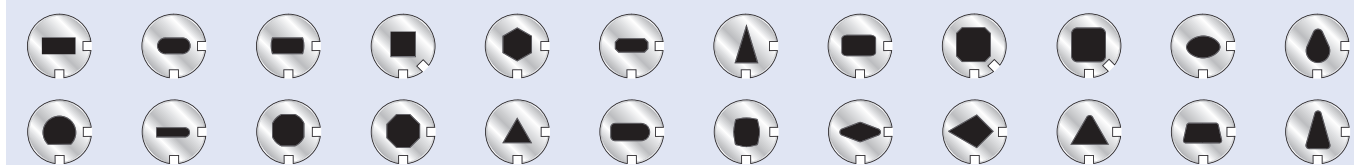
WITH PUSH BUTTON STRIPPER RETENTION
Up to 50.8mm 'A' Dimension*



Description		Cat. No.	Price
Guide Assembly		13829	
Punches	• Round	13614	
	• Shape	13615	
	• Optima® Add On	-	
Strippers	• Round	5150	
	• Shape	5151	
Dies	• Round Slug Hugger®†	2196	
	• Round Standard	1850	
	• Shape Slug Hugger®†	2197	
	• Shape Standard	13807	
	• Ultima™ Add On (Round)	-	
	• Ultima™ Add On (Shape)	-	

Notes
Standard guide assys. are keyed for shapes at 0°, 90° and 225°.
All punches will be shipped with no shear unless specified.
† Slug Hugger® dies must be ordered punch size plus clearance. Size restrictions apply.
Slug Hugger 2 available on request. Contact Sales Desk for further information.
†† M12 bolt Cat No. 6605 included but not assembled.
* 'A' Dimension = longest distance across shape.
• For add ons go to page 38.

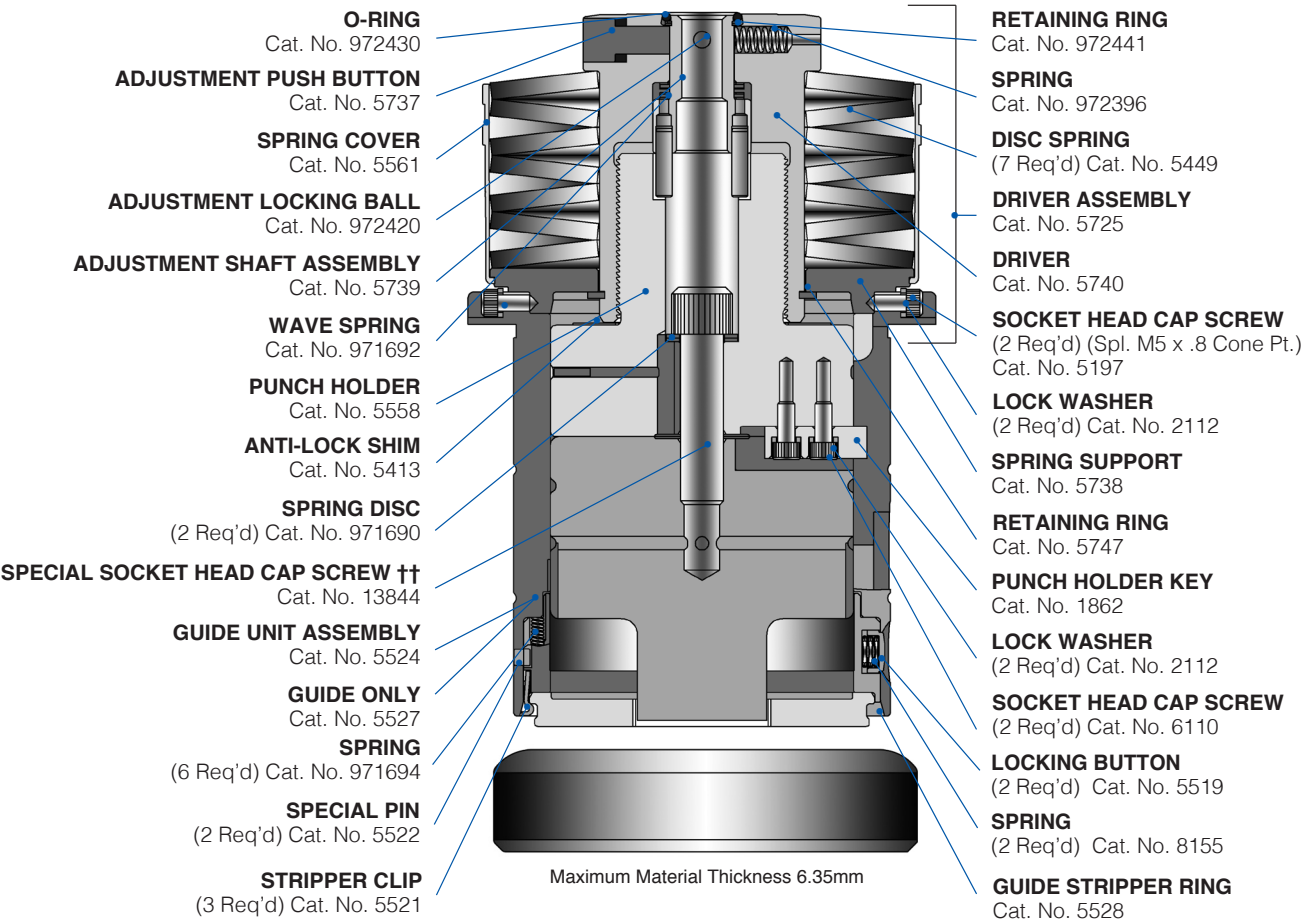
Standard Shapes & Key Locations (Die View)



Wilson Metric Style ABS Quick Release D Station

WITH PUSH BUTTON STRIPPER RETENTION

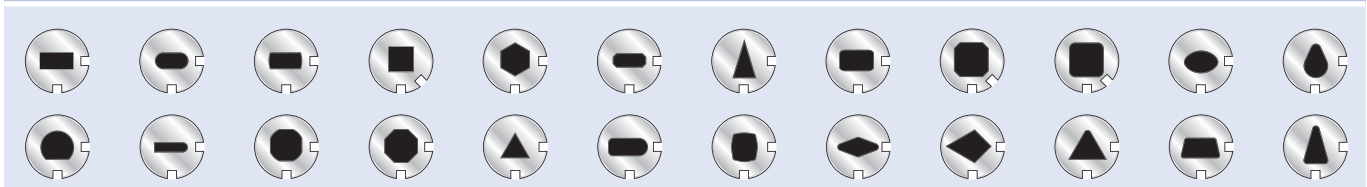
Up to 88.9mm 'A' Dimension*



Description		Cat. No.	Price
Guide Assembly		13830	
Punches	• Round	13616	
	• Shape	13617	
	• Optima® Add On	-	
Strippers	• Round	5152	
	• Shape	5153	
Dies	• Round Slug Hugger®†	2198	
	• Round Standard	1865	
	• Shape Slug Hugger®†	2199	
	• Shape Standard	13810	
	• Ultima™ Add On (Round)	-	
	• Ultima™ Add On (Shape)	-	

Notes
Standard guide assys. are keyed for shapes at 0°, 90° & 225°.
1.6mm Rooftop shear is given to all punches with 'A' dimension greater than 50.8mm, and width greater than 6.35mm, at no extra charge.
All punches 6.35mm and under in width will beshipped with no shear unless specified.
† Slug Hugger® dies must be ordered punch size plus clearance. Size restrictions apply. Slug Hugger 2 available on request. Contact Sales Desk for further information.
†† M12 bolt Cat No. 970467 included but not assembled.
* 'A' Dimension = longest distance across shape.
• For add ons go to page 38.

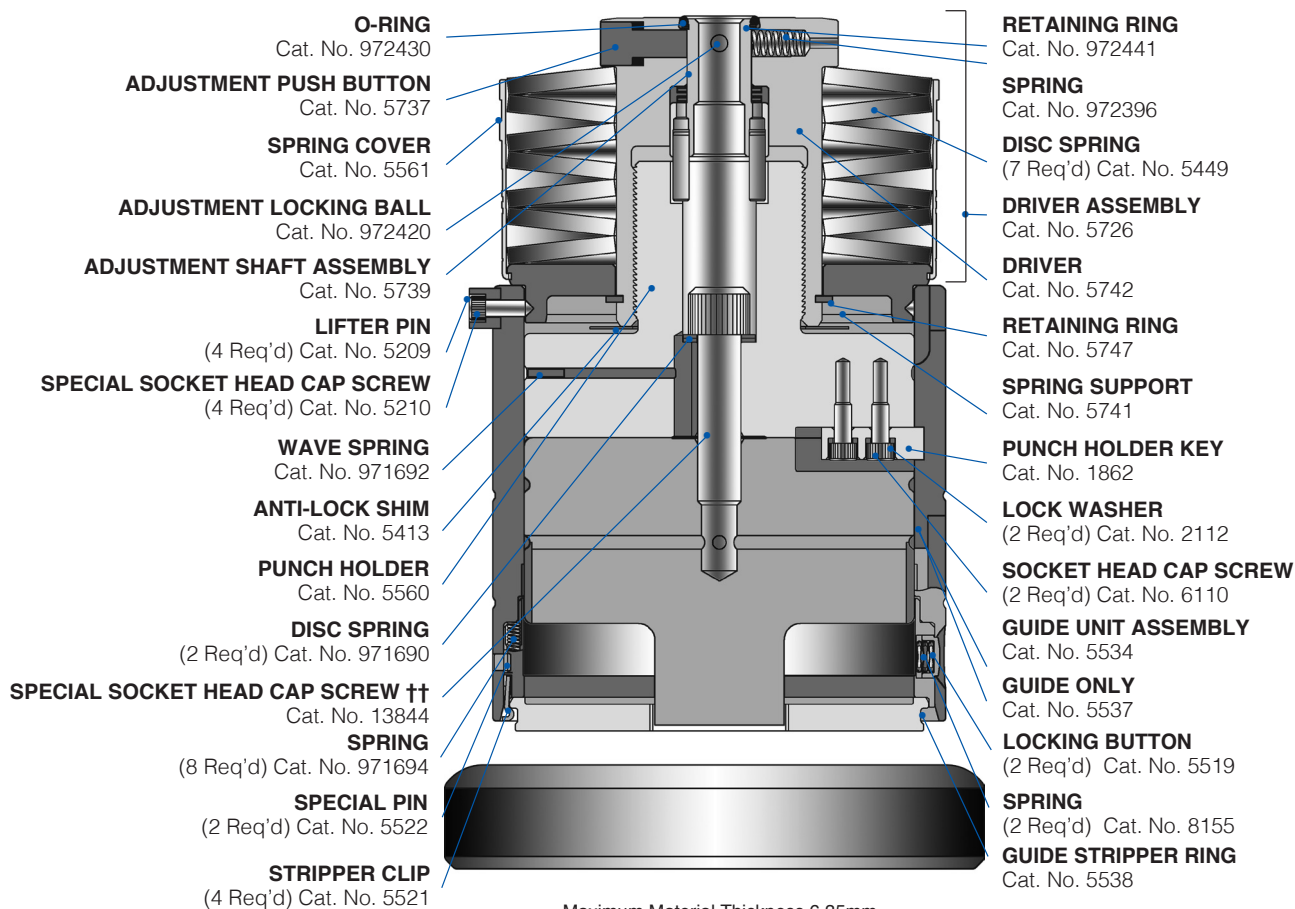
Standard Shapes & Key Locations (Die View)



Wilson Metric Style ABS Quick Release E Station

WITH PUSH BUTTON STRIPPER RETENTION

Up to 114.3mm 'A' Dimension*

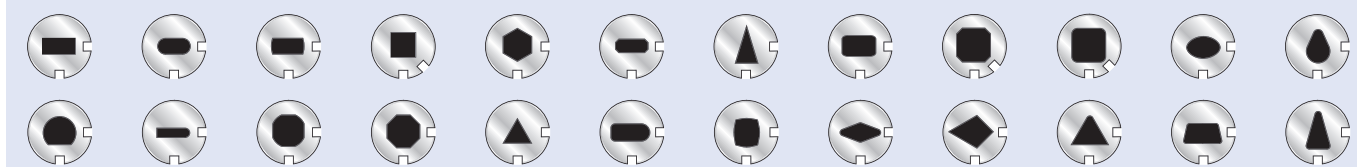


Maximum Material Thickness 6.35mm

Description		Cat. No.	Price
Guide Assembly		13831	
Punches	• Round	13618	
	• Shape	13619	
	• Optima® Add On	-	
Strippers	• Round	5154	
	• Shape	5155	
Dies	• Round Slug Hugger®†	2200	
	• Round Standard	1878	
	• Shape Slug Hugger®†	2201	
	• Shape Standard	13817	
	• Ultima™ Add On (Round)	-	
	• Ultima™ Add On (Shape)	-	

Notes
Standard guide assys. are keyed for shapes at 0° & 90°.
1.6mm Rooftop shear is given to all punches with 'A' dimension greater than 50.8mm, and width greater than 6.35mm, at no extra charge.
All punches 6.35mm and under in width will be shipped with no shear unless specified.
† Slug Hugger® dies must be ordered punch size plus clearance. Size restrictions apply. Slug Hugger 2 available on request. Contact Sales Desk for further information.
†† M12 bolt Cat No. 970467 included but not assembled.
* 'A' Dimension = longest distance across shape.
• For add ons go to page 38.

Standard Shapes & Key Locations (Die View)



Slitting, complex shapes, clusters and close to clamps – DuraDie is the perfect solution for all these jobs

Slitting Solution

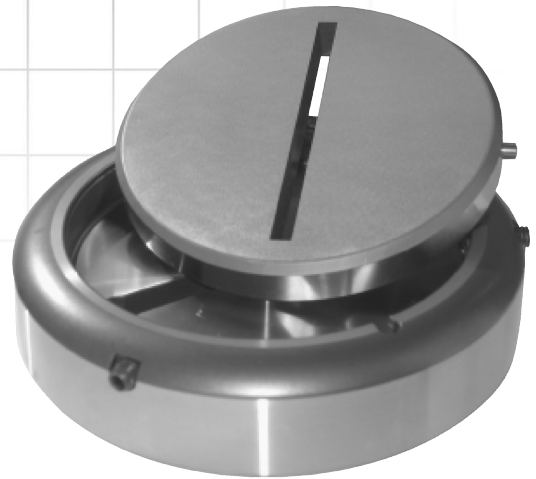
This is a special die holder assembly which provides you with the ideal slitting solution. The die inserts are fully supported by the die base and are hard wearing and economical to replace.

Problem Solving

The DuraDie assembly is also the perfect solution when you are punching complex two dimensional shapes and cluster patterns with small webs between holes. In fact the DuraDie system can help whenever die strength is an issue.

Shock Resistant

The aperture (which closely follows the profile in the die insert), is cut into the shock resistant die holder which fully supports the special die blade and the specially located shims.

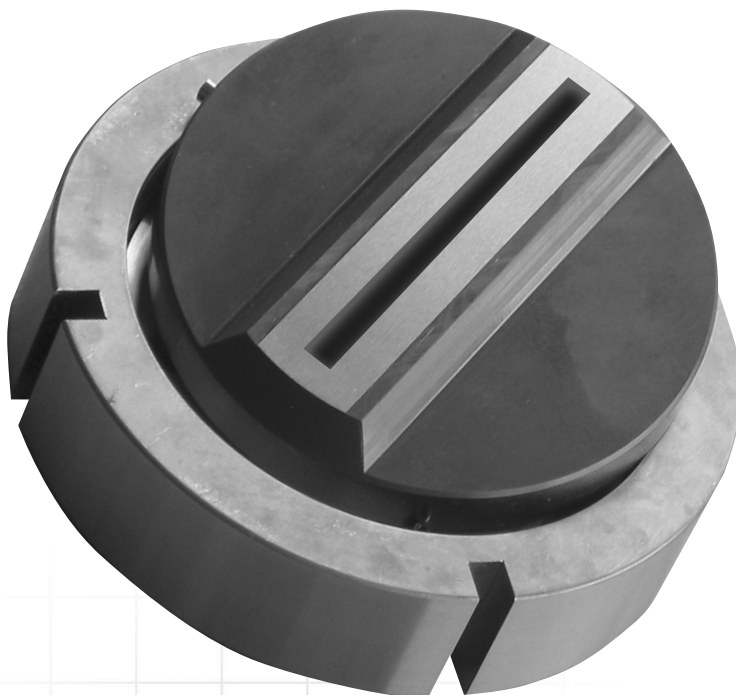


Durable

With a die insert made using Ultima™, a special powdered tool steel, you will get more hits between regrinds and reduced downtime.

Practical & Economical

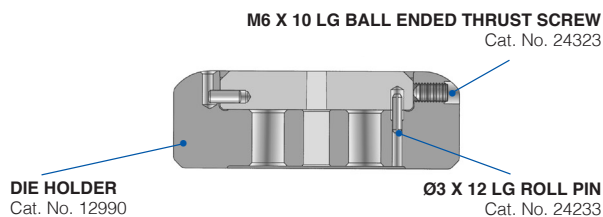
The complete assembly consists of a special die insert, a shim pack and a specially reinforced die holder. You can order duplicate die inserts for different materials and if you need to replace a worn die all you need is a new insert.



DURADIE

WILSON TOOL

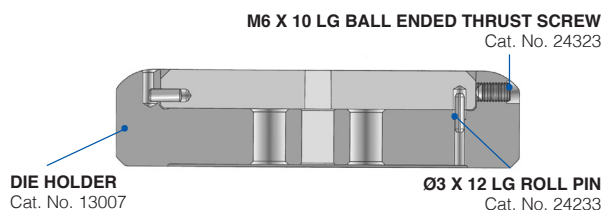
50.8mm (C) Station Slitting



Description	Cat. No.	Price
Die Base Assembly (not including die blade)	12989	
Die Blade (Slughugger)	12992	
Shim Pack	12995	
Knockout Tool	24310	

Maximum length * = 51mm Maximum width * = 7mm *Subject to certain restrictions

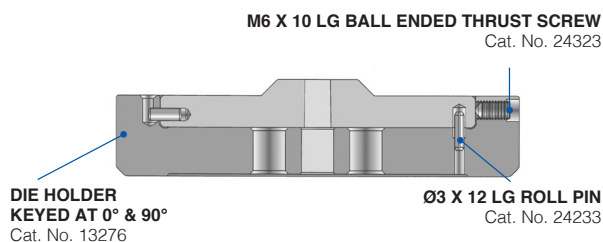
88.9mm (D) Station Slitting



Description	Cat. No.	Price
Die Base Assembly (not including die blade)	13006	
Die Blade (Slughugger)	13009	
Shim Pack	13012	
Knockout Tool	24310	

Maximum length * = 86mm Maximum width * = 7mm *Subject to certain restrictions

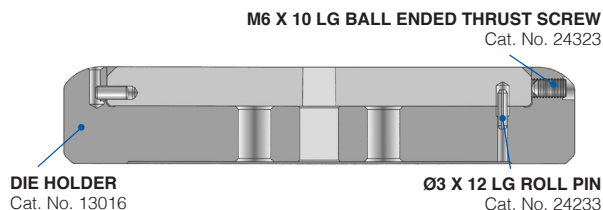
88.9mm (D) Station Close to Clamps



Description	Cat. No.	Price
Die Base Assembly 0&90° (not including die blade)	13276	
Die Blade – relieved on 1 side (Slughugger)	13280	
Die Blade – relieved on 2 sides (Slughugger)	13282	
Shim Pack	13012	
Knockout Tool	24310	

Maximum length * = 81mm Maximum width * = 7mm *Subject to certain restrictions

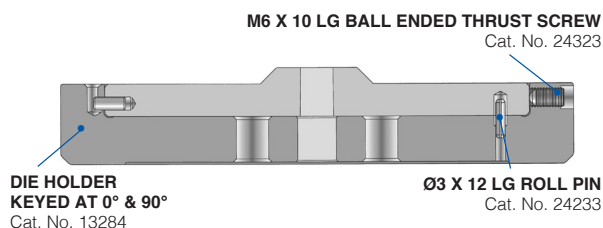
114.3mm (E) Station Slitting



Description	Cat. No.	Price
Die Base Assembly (not including die blade)	13015	
Die Blade (Slughugger)	13014	
Shim Pack	13017	
Knockout Tool	24313	

Maximum length * = 111mm Maximum width * = 11mm *Subject to certain restrictions

114.3mm (E) Station Close to Clamps



Description	Cat. No.	Price
Die Base Assembly 0&90° (not including die blade)	13284	
Die Blade – relieved on 1 side (Slughugger)	13288	
Die Blade – relieved on 2 sides (Slughugger)	13290	
Shim Pack	13017	
Knockout Tool	24313	

Maximum length * = 111mm Maximum width * = 11mm *Subject to certain restrictions

Fast efficient slitting... even close to the clamps

Reduced Costs

The replaceable punch blade is made of Ultima™, a special powdered metallurgy high speed steel that gives you more hits between regrinds and helps to reduce down time.

Practical

With its patented HP push button length adjustment and stripper release, the new DuraBlade assembly is quick and easy to use.

Increased Profits

DuraBlade is designed for improved close to clamps operation. This means that more of the sheet is available to you and less material is wasted.

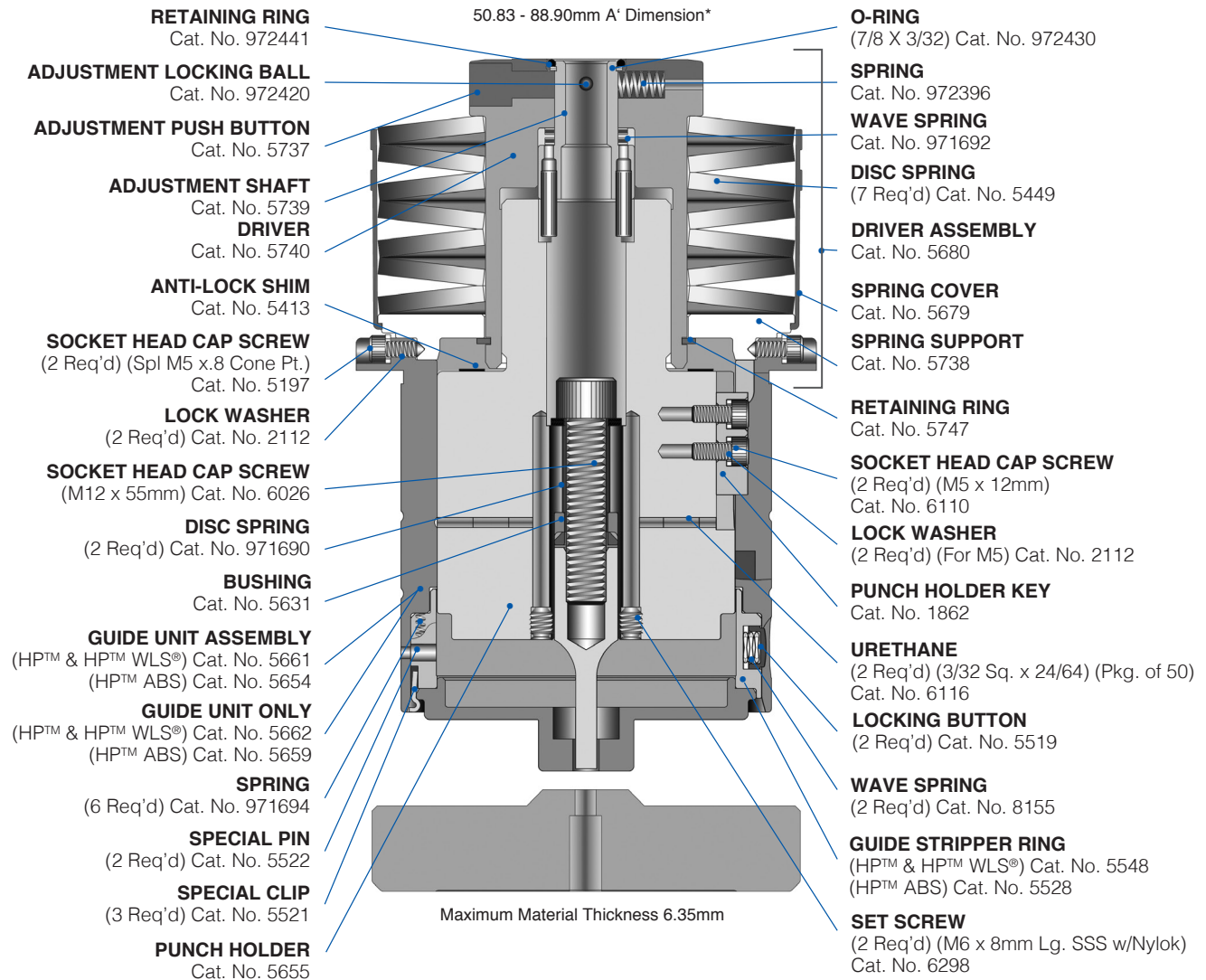


Accurate

The punch blade is fully guided right to the surface of the material resulting in much cleaner results for your slitting/parting tasks and reduced wear and tear on the punch and die.

The DuraBlade assembly is available for the D & E stations of most Thick Turret machines in standard, ABS and WLS configurations.

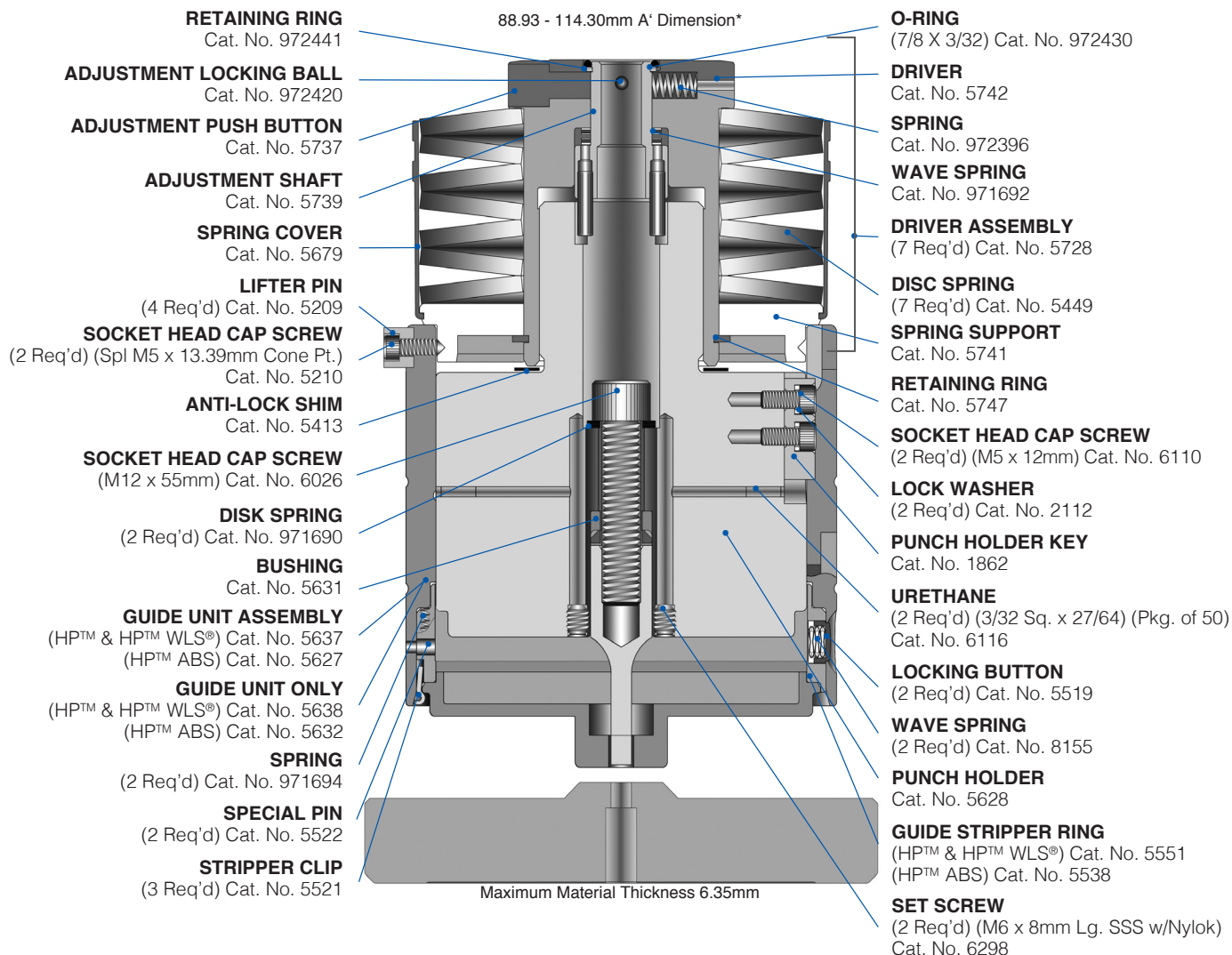
HP DURA BLADE



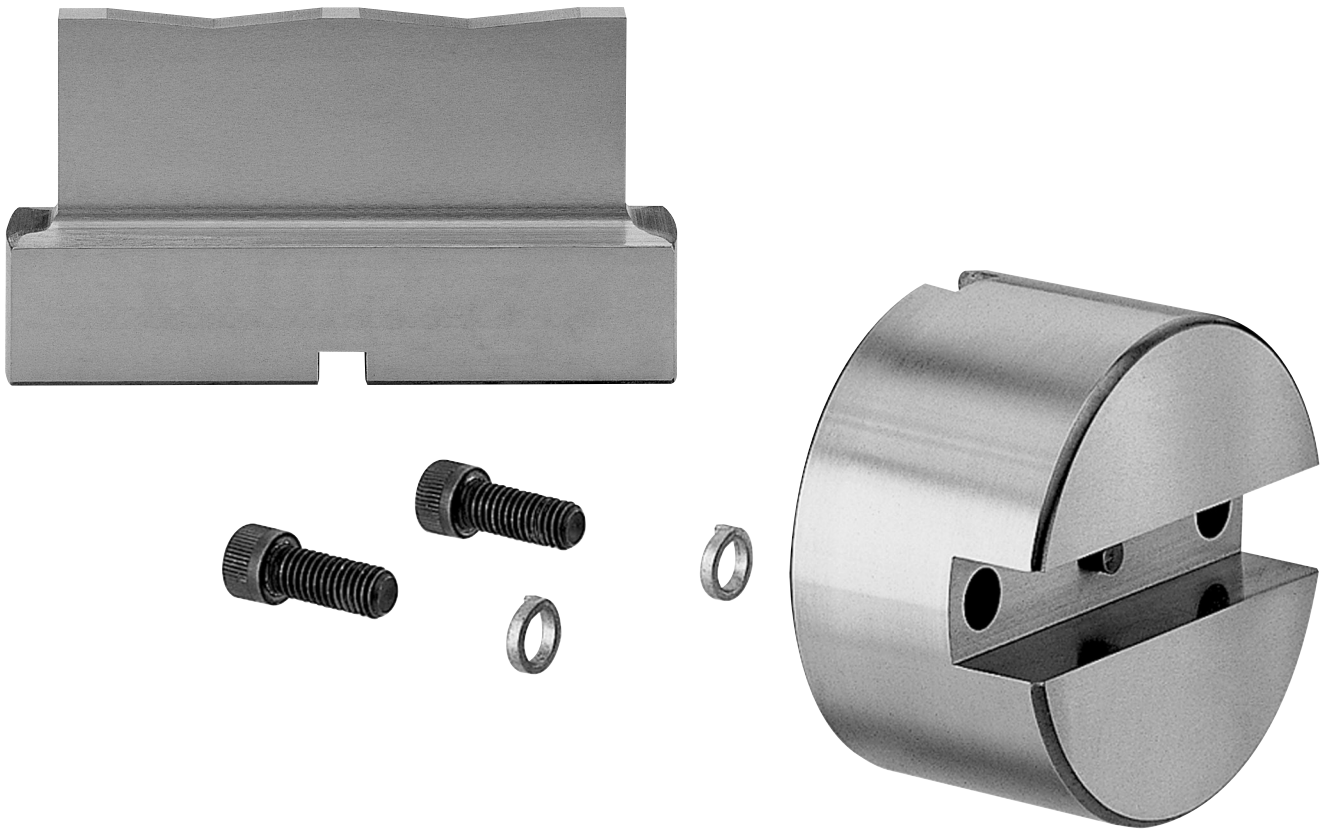
Description		HP™		HP™ ABS	
		Cat. No.	Price	Cat. No.	Price
Guide Assembly		5663		5653	
Punches	• Blade • Optima® Add On	5657 -		5657 -	
Stripper	• Thick Clamps	5656		5664	
Dies	• Slug Hugger®† (relief 2 sides, shape at 0 & 90°)	5330		5330	
	• Standard (relief 2 sides, shape at 0 & 90°)	5328		5328	

- Notes**
- HP™ DuraBlade™ guide assemblies are keyed for shapes at 0°, 90° & 135°.
 - One-sided relief stripper plates and dies available upon request. Contact sales desk for price and availability.
 - Single 90° die key option available upon request. Contact sales desk for price and availability.
 - Maximum width for blade insert is 19.05mm
 - † Slug Hugger® dies must be ordered punch size plus clearance. Size restrictions apply. Slug Hugger 2 available on request. Contact Sales Desk for further information.
 - * 'A' Dimension = longest distance across shape.
 - For add ons go to page 38.

HP DuraBlade E Station



Description		HP™		HP™ ABS		Notes
		Cat. No.	Price	Cat. No.	Price	
Guide Assembly		5639		5626		<ul style="list-style-type: none"> HP™ DuraBlade™ guide assemblies are keyed for shapes at 0° & 90°. One-sided relief stripper plates and dies available upon request. Contact sales desk for price and availability. Single 90° die key option available upon request. Contact sales desk for price and availability. Maximum width for blade insert is 19.05mm <p>† Slug Hugger® dies must be ordered punch size plus clearance. Size restrictions apply. Slug Hugger 2 available on request. Contact Sales Desk for further information.</p> <p>* 'A' Dimension = longest distance across shape.</p> <ul style="list-style-type: none"> For add ons go to page 38.
Punches	<ul style="list-style-type: none"> Blade Optima® Add On 	5630		5630		
Stripper	<ul style="list-style-type: none"> Thick Clamps 	5629		5640		
Dies	<ul style="list-style-type: none"> Slug Hugger®† (relief 2 sides, shape at 0 & 90°) 	5340		5340		
	<ul style="list-style-type: none"> Standard (relief 2 sides shape at 0 & 90°) 	5338		5338		



Replaceable Insert Assembly

Station	Body (M - 12)		Punch Insert		Set (M - 12)	
	Cat. No.	Price	Cat. No.	Price	Cat. No.	Price
50.8mm (C)	2625		2590		2624	
88.9mm (D)	2286		1967		2372	
114.3mm (E)	2287		1970		2373	

Parts Description	Cat. No.	Price
Socket Head Cap Screw – 3/8" - 16 x 1-1/2" long (for 50.8mm (C) station)	6391	
Socket Head Cap Screw – 3/8" - 16 x 1-1/2" long (for 88.9mm (D) & 114.3mm (E) stations)	6019	
High Collar Lock Washer for 3/8" screw	2129	
Dowel Pin – 1/4" Dia. x 450" long (All stations)	6004	

Notes

- * Optima® is standard on punch inserts.
- * Blade insert punches under 9.53mm in width will be shipped with no shear unless specified.
- * Double Valley Shear is recommended for widths of 4.75mm up to 9.53mm and minimum lengths of 50.8mm when used for nibbling.
- * Undersized dimensions will incur additional charges. Please consult the fee schedule for the appropriate station to determine the charge.
- * See shear chart on page 37.
- * For widths less than 2.36mm, consult the sales desk.
- * Maximum width 19mm.
- * Inserts are available as obround to be used with rectangle dies, to eliminate 'Saw Tooth Effect'.
- For add ons go to page 38.

Close to Clamp Tooling



88.9mm (D) Station for punching close to clamps

Description	Cat. No.	Price
Dies		
• Slug Hugger®† (relief 2 sides, shp at 90°)	5157	
• Slug Hugger®† (relief 2 sides, shp at 0°-90°)	5330	
• Slug Hugger®† (relief 1 side, shp at 90°)	2464	
• Slug Hugger®† (relief 1 side, shp at 0°-90°)	5333	
• Standard (relief 2 sides, shp at 90°)	13814	
• Standard (relief 2 sides, shp at 0°-90°)	13813	
• Standard (relief 1 side, shp at 90°)	13812	
• Standard (relief 1 side, shp at 0°-90°)	13811	

114.3mm (E) Station for punching close to clamps

Description	Cat. No.	Price
Dies		
• Slug Hugger®† (relief 2 sides, shp at 90°)	5159	
• Slug Hugger®† (relief 2 sides, shp at 0°-90°)	5340	
• Slug Hugger®† (relief 1 side, shp at 90°)	2467	
• Slug Hugger®† (relief 1 side, shp at 0°-90°)	5343	
• Standard (relief 2 sides, shp at 90°)	13821	
• Standard (relief 2 sides, shp at 0°-90°)	13820	
• Standard (relief 1 side, shp at 90°)	13819	
• Standard (relief 1 side, shp at 0°-90°)	13818	

Notes

† Slug Hugger® dies must be ordered punch size plus clearance. Size restrictions apply. Contact Sales Desk for further information.

* 'A' Dimension = longest distance across shape.

Punch Shims, Die Shims and Slug Ejectors

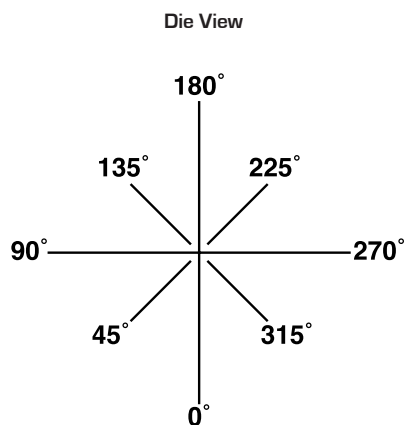
Die Shims			
Station	Quantity	Cat. No.	Price
0.25mm Thick – Individually			
12.7mm (A)	1	2101	
31.75mm (B)	1	2097	
50.8mm (C)	1	2089	
88.9mm (D)	1	2081	
114.3mm (E)	1	2073	
0.25mm Thick – Package			
12.7mm (A)	25	2208	
31.75mm (B)	25	2209	
50.8mm (C)	10	2210	
88.9mm (D)	5	2211	
114.3mm (E)	5	2212	
0.75mm Thick – Individually			
12.7mm (A)	1	2721	
31.75mm (B)	1	2723	
50.8mm (C)	1	2725	
88.9mm (D)	1	2727	
114.3mm (E)	1	2729	
0.75mm Thick – Package			
12.7mm (A)	25	2722	
31.75mm (B)	25	2724	
50.8mm (C)	10	2726	
88.9mm (D)	5	2728	
114.3mm (E)	5	2730	
1.5mm Thick – Individually			
12.7mm (A)	1	2104	
31.75mm (B)	1	2100	
50.8mm (C)	1	2092	
88.9mm (D)	1	2084	
114.3mm (E)	1	2076	
1.5mm Thick – Package			
12.7mm (A)	25	2172	
31.75mm (B)	25	2173	
50.8mm (C)	10	2174	
88.9mm (D)	5	2175	
114.3mm (E)	5	2176	

Punch Shims			
Station	Quantity	Cat. No.	Price
Individually			
12.7mm (A)	1	13080	
31.75mm (B)	1	152	
50.8mm (C)	1	2096	
88.9mm (D)	1	2088	
114.3mm (E)	1	2080	
Package			
31.75mm (B)	25	98	
50.8mm (C)	10	2169	
88.9mm (D)	5	2170	
114.3mm (E)	5	2171	

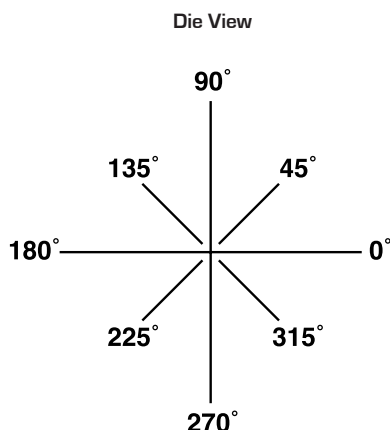
Slug Ejectors			
Square Urethane			
Hole Diameter in Punch	Quantity	Cat. No.	Price
3.2mm	50	6116	
4.8mm	50	6117	
9.5mm	50	6118	
12.7mm	50	6119	
Assortment	50	6410	

Non Standard Keying

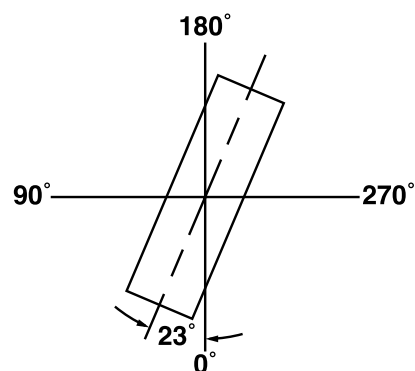
When ordering shapes at non-standard angles, use the diagrams below to eliminate any confusion.



Front of Machine
Wilson Tool's keying diagram.



Front of Machine
This key location matches Amada's® turret punch press programming method.



Example
Shape at 23°

Shape at single angles other than standard (Note: No additional charge on A & B Stations for shape at 45° increments)

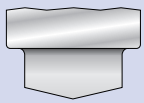
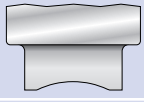
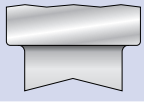
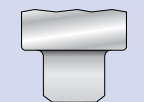
Station	Punches	Dies	Guides or Strippers
12.7mm (A)	No Charge		No Charge
31.75mm (B)			Not Applicable
50.8mm (C)			Not Applicable
88.9mm (D)			Not Applicable
114.3mm (E)			Not Applicable

Standard Keying, plus extra pins or keys for shapes at other than 45° increments

Station	Punches	Dies	Guides or Strippers
12.7mm (A)	Not Available	Not Available	
31.75mm (B)	Not Available	Not Available	
50.8mm (C)			Not Applicable
88.9mm (D)			Not Applicable
114.3mm (E)			Not Applicable

Standard Keying, plus extra pins or keys for shapes at 45° increments

Station	Punches		Dies		Guides or Strippers
	Available Options	Add On Price	Available Options	Add On Price	
12.7mm (A)	Not available	Not available	Not available	Not available	
31.75mm (B)	0° & 45°		0° & 45°		
	0° & 180°		0° & 180°		
50.8mm (C)	45° Increments		45° Increments		Not applicable
88.9mm (D)	45° Increments		45° Increments		Not applicable
114.3mm (E)	45° Increments		45° Increments		Not applicable

Type of Shear		Benefit	Limitation
	Rooftop	Best shear for punching at maximum tonnages.	When nibbling, bite must be 75% of punch dimension or excessive side loading will result.
	Concave or Double Concave	Best shear for nibbling because it inverts stresses.	The punch is less resistant to breakage when punching at high tonnages because of inverted stresses.
	Inverted Rooftop	Also good shear for nibbling because it inverts stresses.	More susceptible to breakage because of a sharp focal point for stresses – use with great care.
	Double Valley Shear	Best shear for nibbling when shape is long and narrow.	The punch is less resistant to breakage when punching at high tonnages because of inverted stresses.
	JK Shear	A special punch tip shear that allows you to punch high strength materials with a reduced risk of breakage.	Can only be used on punches up to 25.4mm diameter or 'A' dimension*.

Special Shears					
Station	'A' Dimensions *	Inverted Rooftop		Double Valley	
		Single Concave		Double Concave	
		1.6mm Shear	3.2mm Shear	1.6mm Shear	3.2mm Shear
31.75mm (B)	Within 31.75mm		N/A		N/A
50.8mm (C)	Within 50.8mm				
88.9mm (D)	Within 88.9mm				
114.3mm (E)	Within 114.3mm				

JK Shear	
Shape	Add on Price
Round	
Rectangle, Square, Hexagon	
Single 'D', Double 'D'	
Obround	


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

% x Material Thickness=Total Clearance

Notes
<p>If specified: 3.2mm maximum rooftop shear can be given at N/C for any round or shape in 50.8mm (C), 88.9mm (D) or 114.3mm (E).</p> <p>For rooftop shear on any round or shape in 12.7mm (A) or 31.75mm (B) stations, add</p> <ul style="list-style-type: none"> • 1.6mm rooftop shear is given to all punches with 'A' dimension* greater than 50.8mm and width greater than 6.35mm at no extra charge. All punches 6.35mm and under in width will be shipped with no shear unless specified. <p>*'A' Dimension = longest distance across shape.</p> <p>**NOTE: In some instances, inverted rooftop is substituted for single and double concave shears.</p>

Add Ons

A Station Add Ons			
Add ons for Rounds			
Small Diameter 0.79 - 1.50mm Clearance < 0.10mm	Punch	Die	Stripper N/C N/C
Add ons for Shapes			
Small Widths 0.79 - 1.0mm Clearance < 0.10mm	Punch	Die	Stripper N/C
Add to round or shape punch for extra straight before radius, extra back taper, or no back taper.			

Stubby Style (A) Station			
 <p>Note: Must use stubby style die and stripper with stubby style punch Use Standard Punch and Die Price Plus:</p>	Punch		Die
	Round (2.3mm max dia.) add	Round add	Shape add
	Shape add		

B Station Add Ons			
Add ons for Rounds			
Small Diameter 0.79 - 1.50mm Clearance < 0.10mm	Punch	Die	Stripper N/C N/C
Add ons for Shapes			
Small Widths 0.79 - 1.0mm 'A' Dimension < 11.10mm Clearance < 0.10mm	Punch N/C	Die N/C	Stripper N/C N/C
Add to round or shape punch for extra straight before radius, extra back taper, or no back taper.			

C Station Add Ons			
Add ons for Rounds			
Small Diameter < 25.4mm Clearance < 0.10mm	Punch	Die N/C	Stripper N/C N/C
Add ons for Shapes			
Small Widths 0.79 - 1.0mm 1.01 - 2.34mm Small 'A' Dimension < 29.21mm 29.22 - 31.72 Clearance < 0.10mm	Punch N/C	Die N/C N/C N/C	Stripper N/C N/C N/C
Add to round or shape punch for extra straight before radius, extra back taper, or no back taper.			

D Station Add Ons			
Add ons for Rounds			
Small Diameter 48.26mm 48.27 - 50.77mm Clearance < 0.10mm	Punch	Die N/C N/C	Stripper N/C N/C N/C
Add ons for Shapes			
Small Widths 0.79 - 1.0mm 1.01 - 2.34mm Small 'A' Dimension < 48.26mm 48.27 - 50.77mm Clearance < 0.10mm	Punch N/C	Die N/C N/C N/C	Stripper N/C N/C N/C
Add to round or shape punch for extra straight before radius, extra back taper, or no back taper.			

E Station Add Ons			
Add ons for Rounds			
Small Diameter < 86.36mm 86.37 - 88.87mm Clearance < 0.10mm	Punch	Die N/C N/C	Stripper N/C N/C N/C
Add ons for Shapes			
Small Widths 0.79 - 1.0mm 1.01 - 2.34mm Small 'A' Dimension < 86.36mm 86.37 - 88.87mm Clearance < 0.10mm	Punch N/C	Die N/C N/C N/C	Stripper N/C N/C N/C
Add to round or shape punch for extra straight before radius, extra back taper, or no back taper.			

Wilson Tool International, Ltd. - United Kingdom
Stirling Road, South Marston Industrial Estate,
Swindon, Wiltshire, SN3 4TQ, United Kingdom
Tel (Free): 0800-373748 | Tel: +44 1793 831818
Fax (Free): 0800-373758 | Fax: +44 1793 831945 or 46
Email: sales@wilsontool.eu.com

Wilson Tool International, Inc. - United States

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

Wilson Tool International - China

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

Wilson Tool International - Germany

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

Wilson Tool International A/S - Denmark

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

Wilson Tool International - France

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

Wilson Tool International - Argentina

Tel: +54 114 7634004 | Fax: +54 114 5084190
Email: ventasargentina@wilsontool.com

Wilson Tool - South Africa (Pty) Limited

Tel: +27 877 217 875 | Fax: 086 657 8629
Email: simon.penney@wilsontool.com

The Wilson Tool Company S. de R.L. de C.V. - Mexico

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

Exacta Precision Products - Ontario

Tel: 800-268-5573 | Fax: 800-668-9314
Email: info@exactapunch.com

Exacta FabTool - Ontario

Tel: 905-840-2240 | Fax: 905-840-1032
Email: info@exactafabtool.com