

WILSON THICK TURRET TOOL SYSTEM



Suitable for use on Amada, Danobat (Goiti), Dimeco, Durma, Euromac, LVD Strippit, Pivatic, Prima Power, Wemo and other thick turret punch presses

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 overheads.
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

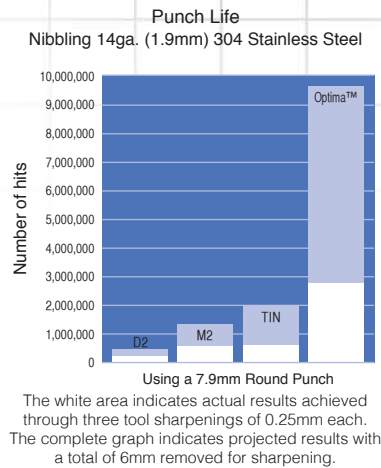
The New Standard in Tooling Performance!

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.

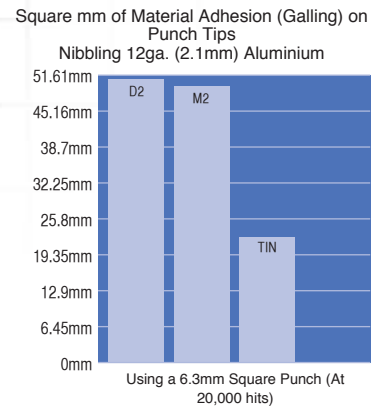
Some of the many benefits that you will enjoy with our Optima[®] coating include:

- 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

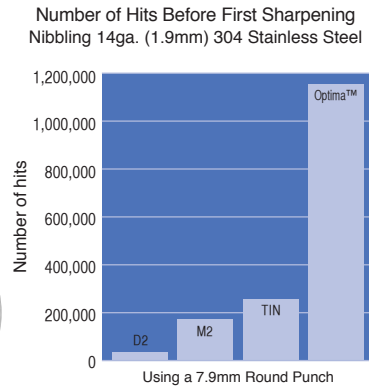
Punch Life



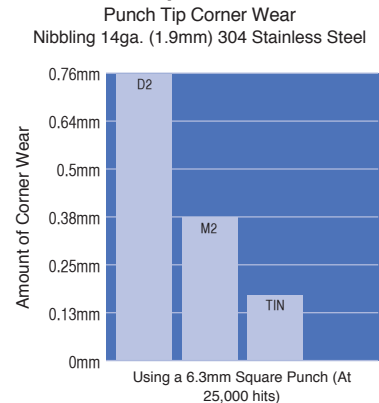
Material Adhesion



Number of Hits



Tip Wear



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 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.

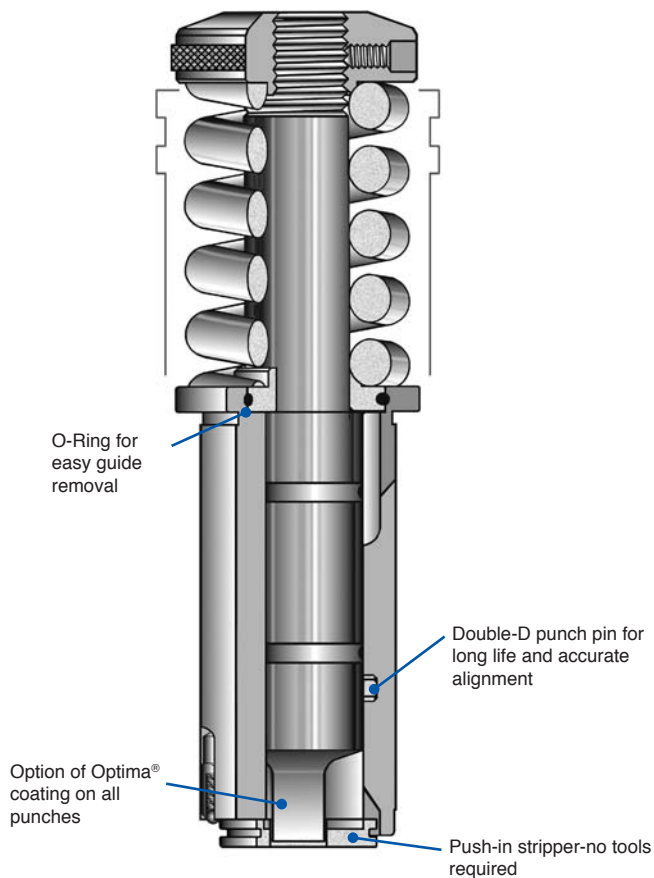
HPX is Wilson Tool's premium tool holder system for A & B stations. With quick-change EXP punches and push in stripper plates, it is possible to use the same holder for multiple punches rather than purchasing full assemblies for each job. EXP punches are manufactured from Ultima® powdered tool steel 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.

HP is Wilson Tool's standard tool system, designed for fast, easy punch length adjustments and with replaceable HP punches. Tools can be adjusted with no tools or buttons; a simple twist of the punch head is all that is required.

Basix is Wilson Tool's economy tool system; compatible with Wilson-style full body 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.

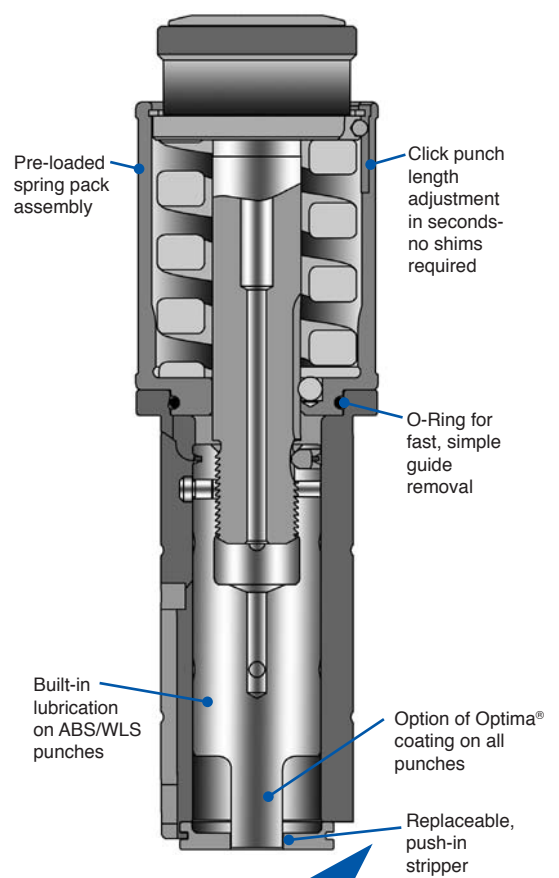
Economy



basix

See Pages 8-9

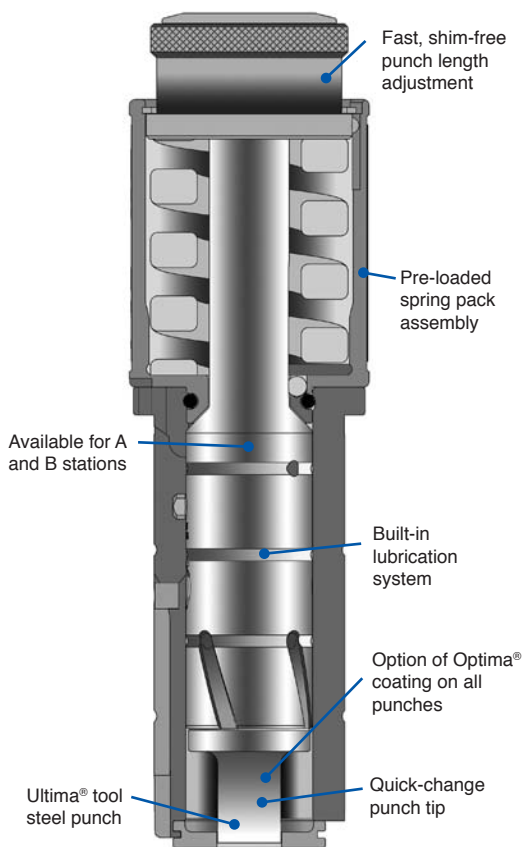
Standard



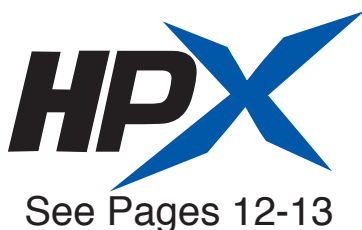
HP

See Pages 10-11

Premium



	Economy	Standard	Premium
	basix	HP	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 25 standard shapes?	••••	••••	••••
	Go To Pages 8-9	Go To Pages 10-11	Go To Pages 12-13



Features and Benefits - C, D and E Stations

Wilson Thick Turret Tool Systems

for C, D & E Stations

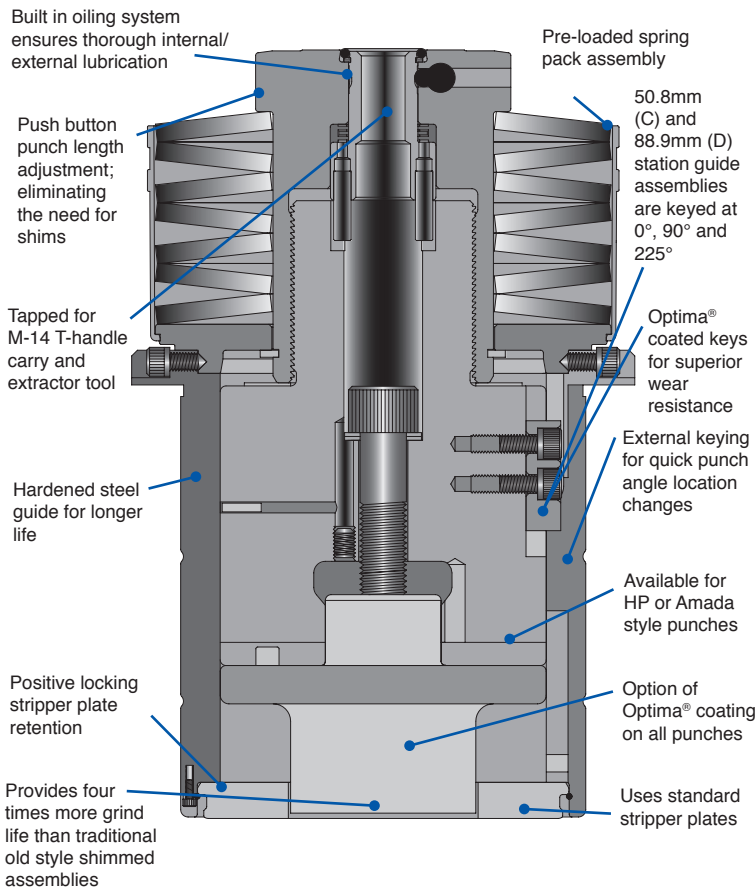
Wilson Tool offers two ranges of C, D & E station standard tools with feature sets to suit different applications and budgets.

Wilson High Performance (HP) 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 Wilson HP the most advanced thick turret tool system in the industry. Wilson HP is compatible with all Series 90 punches and stripper plates, the Amada PDC system, and is available in ABS and gravity-fed lubrication configurations.

Wilson Standard is Wilson Tool's standard tool system for C, D & E stations. Designed with many of the features of the HP tool system (including patented push button length adjustment and hardened steel construction), but with manual stripper retention using stripper clips or a wire lock ring. As with HP, Wilson Standard is compatible with all Series 90 punches and stripper plates, the Amada PDC system, and is 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.

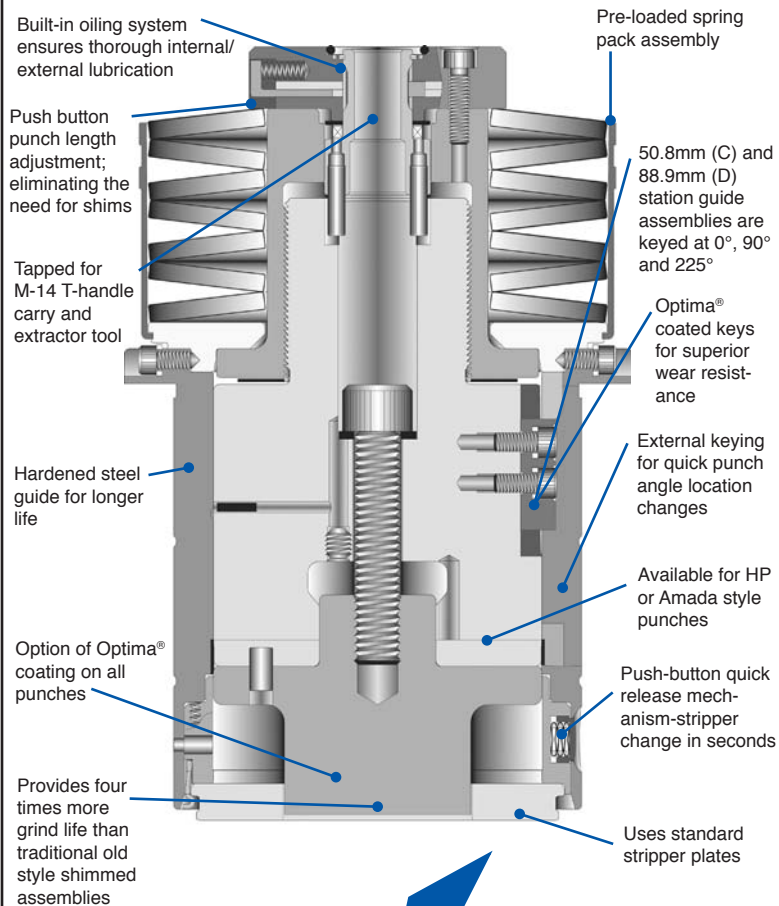
Standard



Wilson Standard


See Pages 20-22

Premium

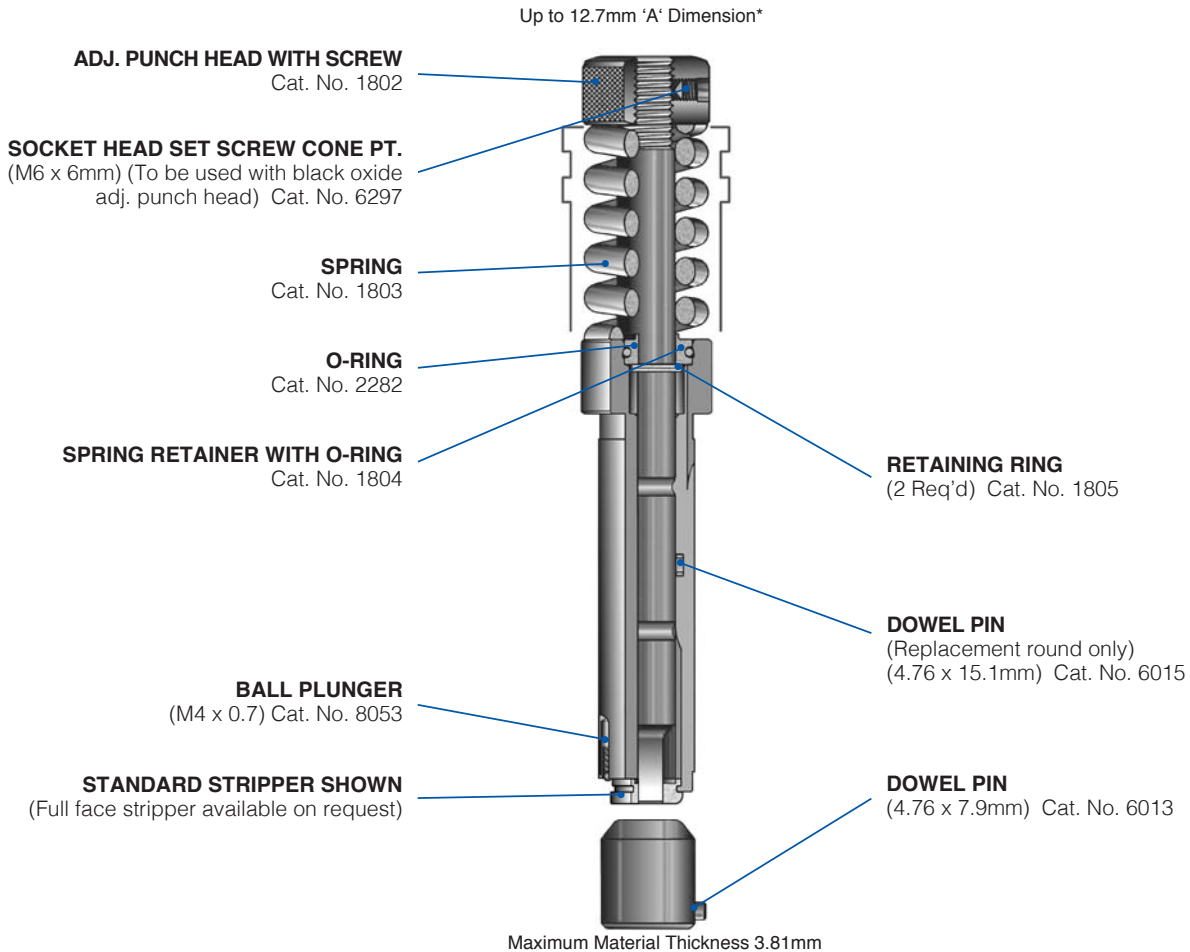


See Pages 23-25



	Standard	Premium
	Wilson Standard	
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 25 standard shapes?	●●●●	●●●●
	Go To Pages 20-22	Go To Pages 23-25

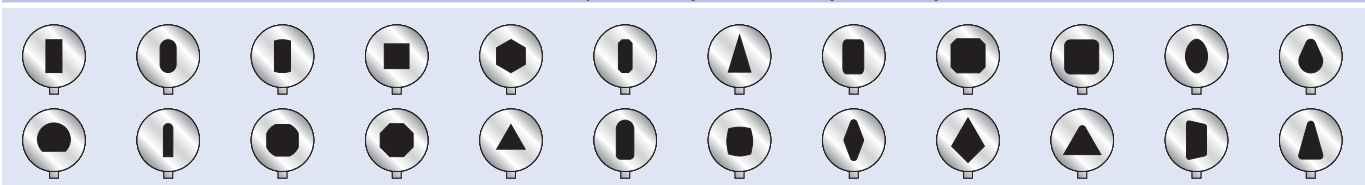
Basix Wilson Style A Station

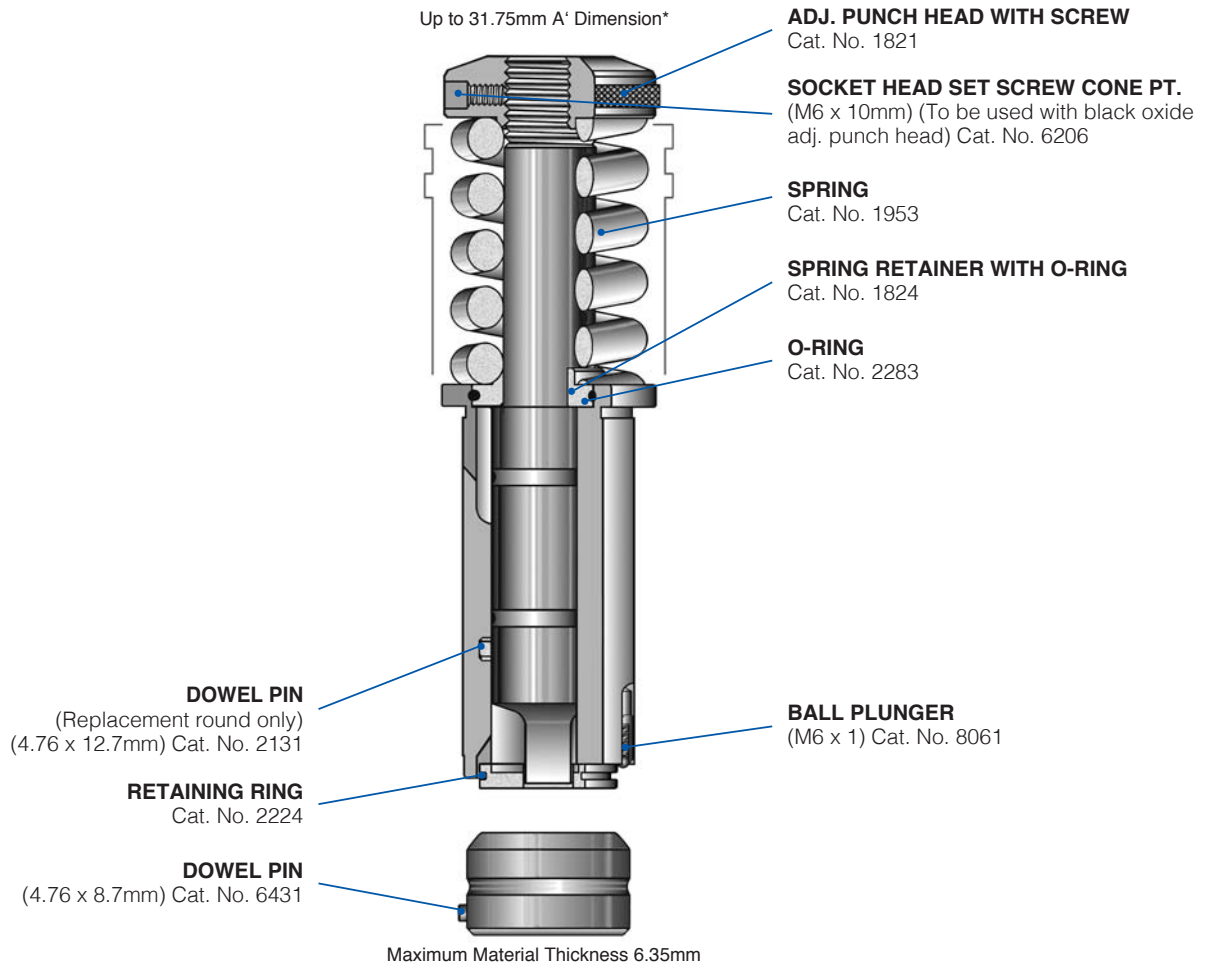


Description		Cat. No.	Price
Punch & Guide Assembly	• Round	13453	
	• Shape Fitted	13455	
	• Optima® Add On	-	
Punches	• Round	1807	
	• Shape	1816	
	• Optima® Add On	-	
Guides	• Round	2821	
	• Shape (0°)	2822	
	• Shape (0° & 45°)	2903	
	• Shape (0° & 90°)	2904	
Stripper	• Round	13044	
	• Shape Fitted	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"> • For add ons go to page 33. <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>

Standard Shapes & Key Locations (Die View)

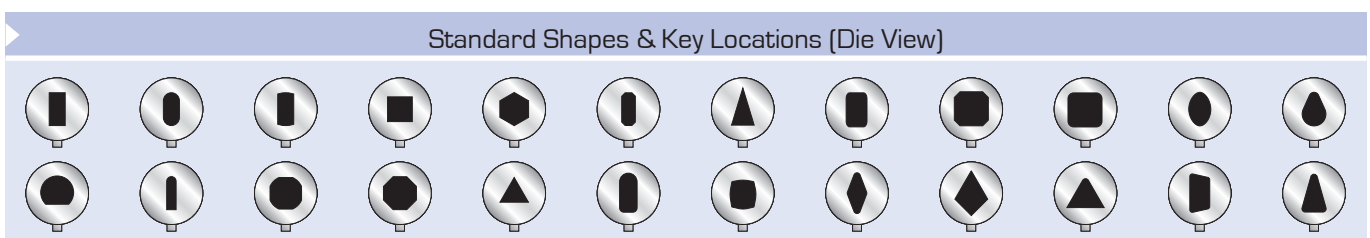




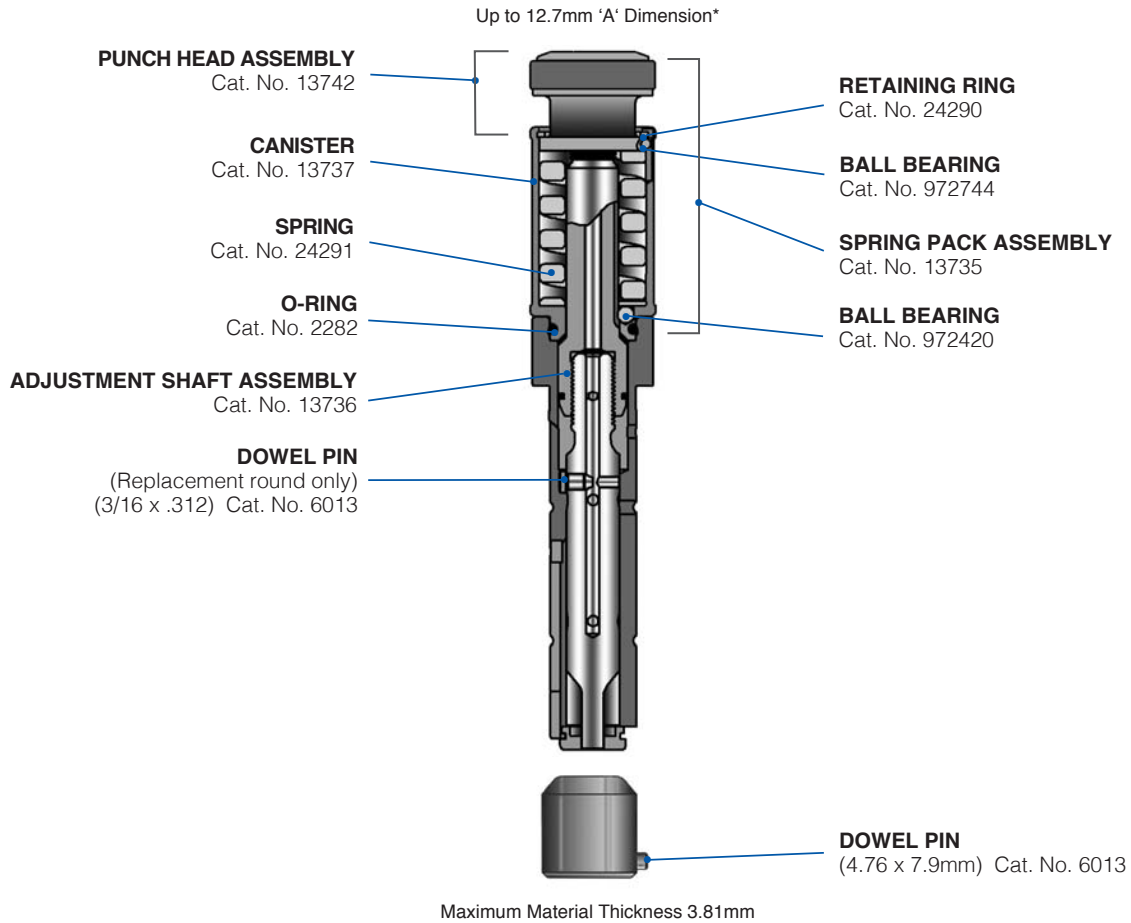
Description		Cat. No.	Price
Punch & Guide Assembly	• Round	2851	
	• Shape Fitted	2853	
	• Optima® Add On	-	
Punches	• Round	1827	
	• Shape	1839	
	• Optima® Add On	-	
Guides	• Round	2859	
	• Shape (0°)	2860	
	• Shape (0° & 45°)	2861	
	• Shape (0° & 90°)	2862	
Stripper	• Round	1890	
	• Shape Fitted	1917	
Dies	• Round Slug Hugger®†	2194	
	• Round Standard	2021	
	• Shape Slug Hugger®†	2195	
	• Shape Standard	13804	
	• Ultima® Add On(Round)	-	
	• Ultima® Add On(Shape)	-	

Notes

- For add ons go to page 33.
- † 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.



HP A Station



Description	HP ²		HP ² ABS	
	Cat. No.	Price	Cat. No.	Price
Punch & Guide Assembly	• Round	13767	13770	
	• Shape Fitted	13769	13772	
	• Optima [®] Add On	-	-	
	• Ultima [®] Add On (Round)	-	-	
	• Ultima [®] Add On (Shape)	-	-	
Punches	• Round	2405	2385	
	• Shape	2406	2389	
	• Optima [®] Add On	-	-	
	• Ultima [®] Add On (Round)	-	-	
	• Ultima [®] Add On (Shape)	-	-	
Guides	• Round	2821	2835	
	• Shape (0°)	2822	2836	
	• Shape (0° & 45°)	2903	2907	
	• Shape (0° & 90°)	2904	2908	
	• Stripper	13044	13045	
Stripper	• Round	13143	13152	
	• Shape Fitted	-	-	
Dies	• Round Slug Hugger [®] †	2192	2192	
	• Round Standard	1808	1808	
	• Shape Slug Hugger [®] †	2193	2193	
	• Shape Standard	13801	13801	
	• Ultima [®] Add On (Round)	-	-	
	• Ultima [®] Add On (Shape)	-	-	

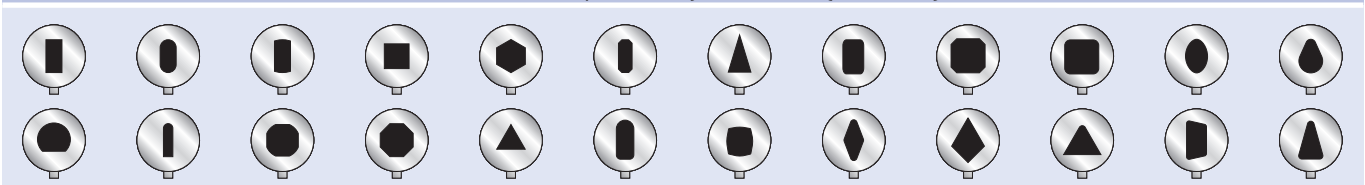
Notes

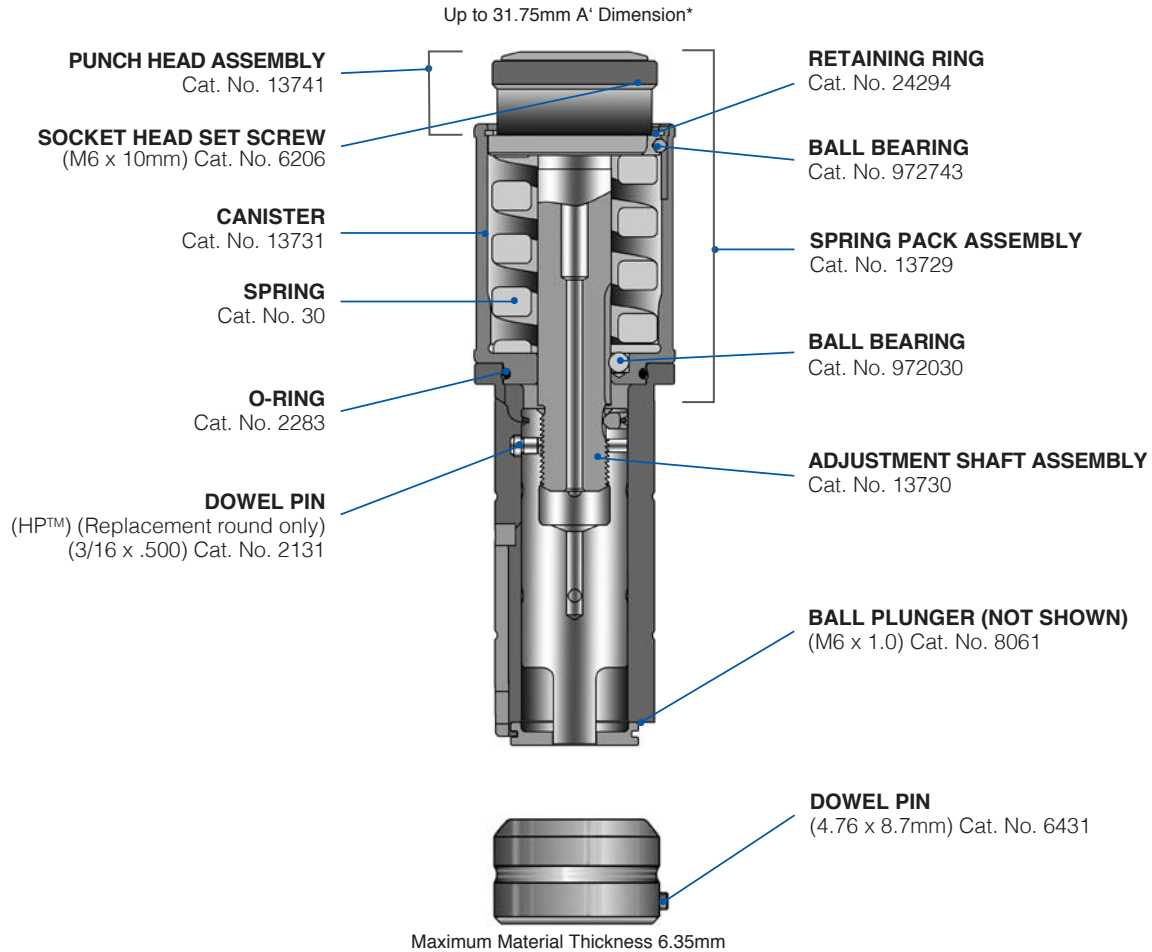
- Std. keying for square guides is 0° & 45°.
- For add ons go to page 33.
- Formerly known as HP².

† 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.

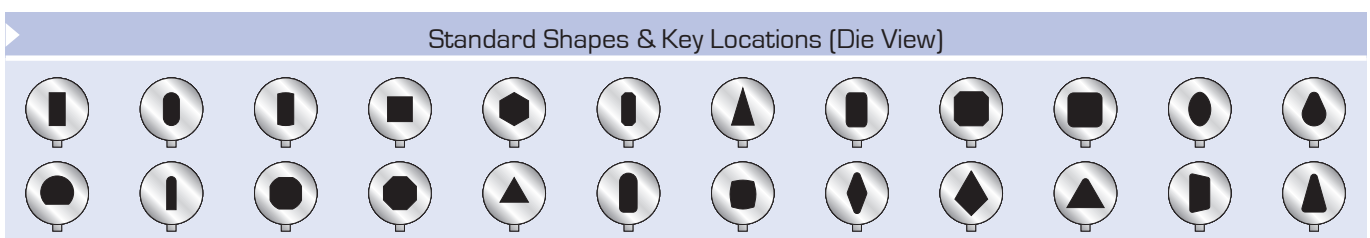
Standard Shapes & Key Locations (Die View)



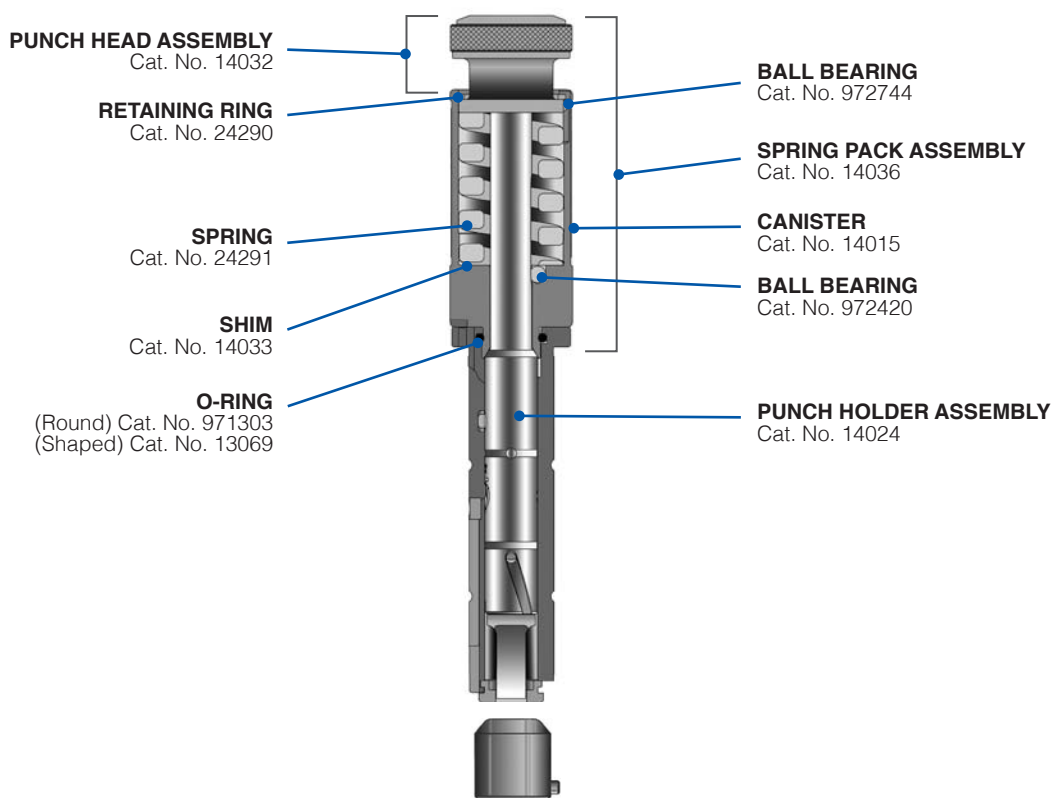


Description	HP ² ™		HP ² ABS	
	Cat. No.	Price	Cat. No.	Price
Punch & Guide Assembly	• Round	13779	13782	
	• Shape Fitted	13781	13784	
	• Optima® Add On	-	-	
	• Ultima® Add On (Round)	-	-	
	• Ultima® Add On (Shape)	-	-	
Punches	• Round	2407	2398	
	• Shape	2408	2399	
	• Optima® Add On	-	-	
	• Ultima® Add On (Round)	-	-	
	• Ultima® Add On (Shape)	-	-	
Guides	• Round	2859	2881	
	• Shape (0°)	2860	2882	
	• Shape (0° & 45°)	2861	2883	
	• Shape (0° & 90°)	2862	2884	
Stripper	• Round	1890	2433	
	• Shape Fitted	1917	2432	
Dies	• Round Slug Hugger®†	2194	2194	
	• Round Standard	2021	2021	
	• Shape Slug Hugger®†	2195	2195	
	• Shape Standard	13804	13804	
	• Ultima® Add On (Round)	-	-	
	• Ultima® Add On (Shape)	-	-	

Notes
• Std. keying for square guides is 0° & 45°.
• For add ons go to page 33.
• Formerly known as HP ² .
† 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.



Available May 2012

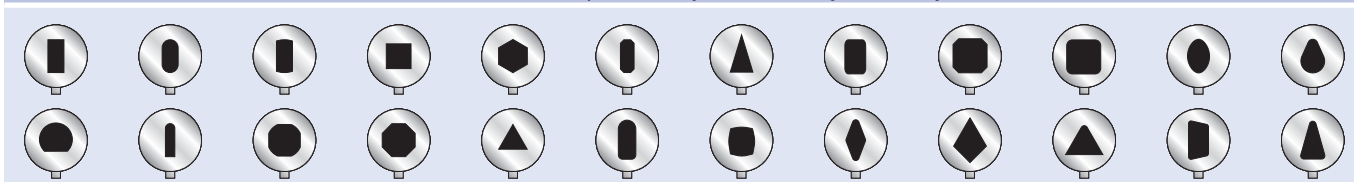


Maximum Material Thickness 3.81mm

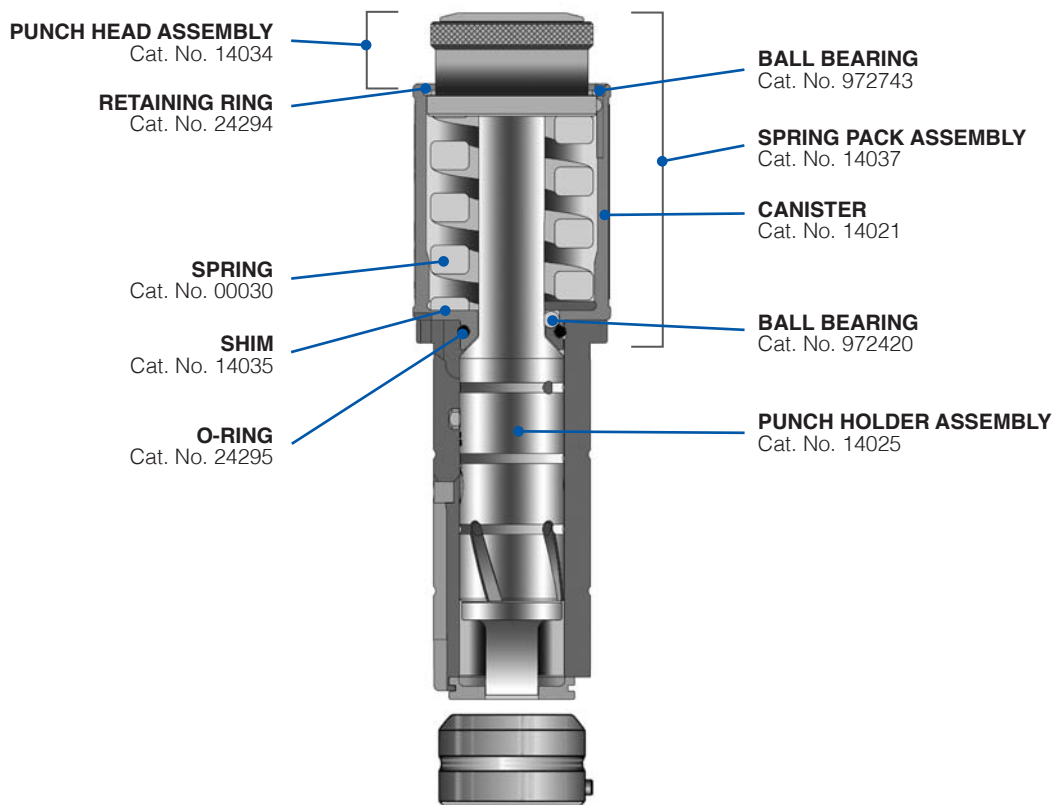
Description		Cat. No.	Price
Punch & Guide Assembly ¹	• Round	14026	
	• Shape Fitted	14012	
	• Optima® Add On	-	
Guide Assembly ²		14027	
Punches	• Round	13904	
	• Shape	13905	
	• Optima® Add On	-	
Guides	• Round	13073	
	• Shape (0°)	13074	
	• Shape (0° & 45°)	13075	
	• Shape (0° & 90°)	13076	
Stripper	• 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 33. <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> <ol style="list-style-type: none"> 1. Includes guide assembly, punch and stripper 2. Guide assembly only. Punch and stripper to be bought separately.

Standard Shapes & Key Locations (Die View)



Available May 2012

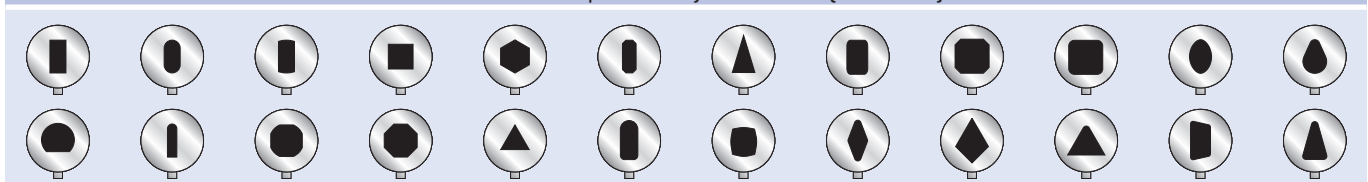


Maximum Material Thickness 6.35mm

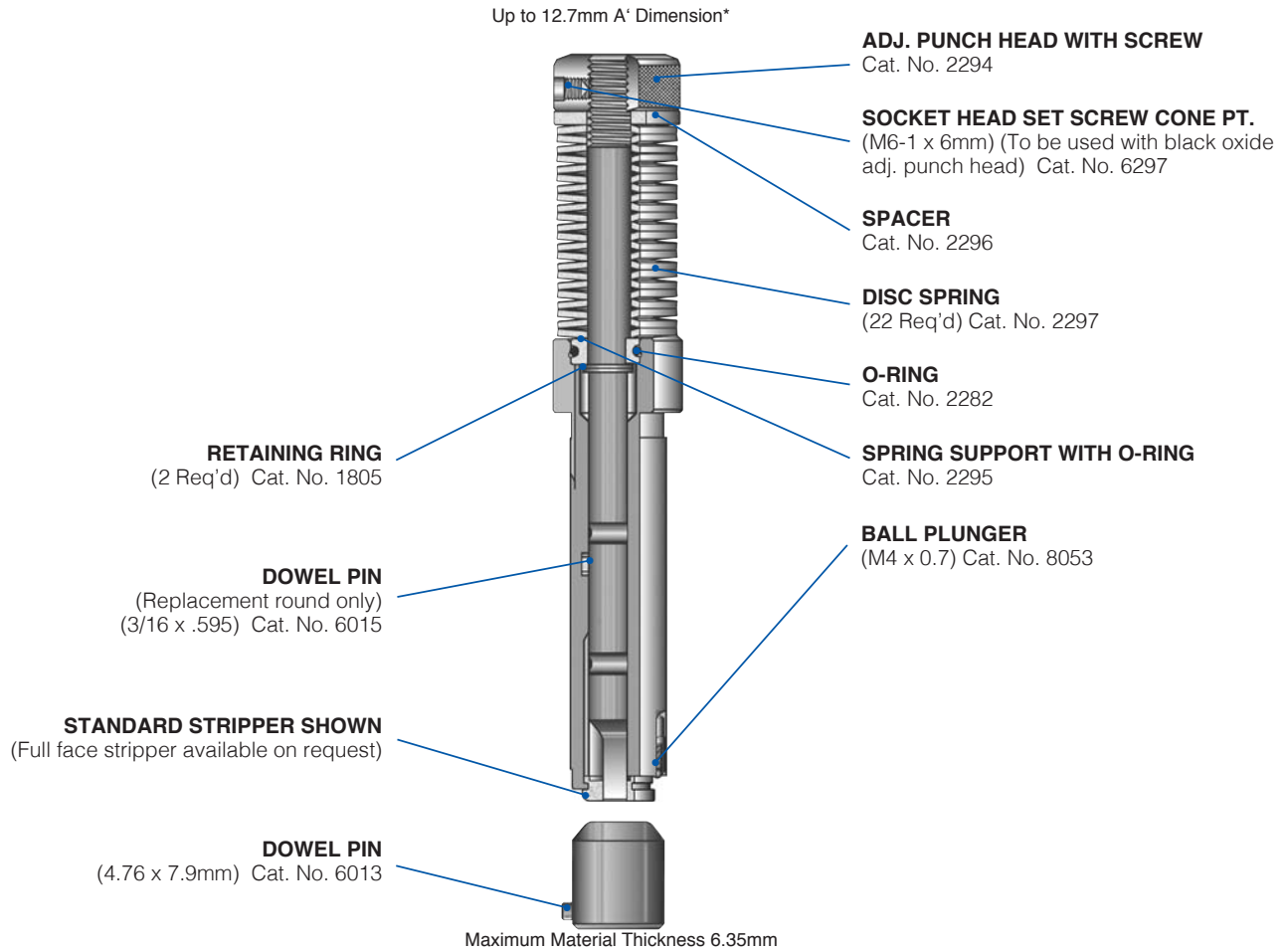
Description		Cat. No.	Price
Punch & Guide Assembly ¹	• Round	14029	
	• Shape Fitted	14018	
	• Optima® Add On	-	
Guide Assembly ²		14030	
Punches	• Round	13916	
	• Shape	13917	
	• Optima® Add On	-	
Guides	• Round	13097	
	• Shape (0°)	13098	
	• Shape (0° & 45°)	13099	
	• Shape (0° & 90°)	13100	
Stripper	• 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
<ul style="list-style-type: none"> • Fully compatible with ABS and non-ABS machines • For add ons go to page 33.
<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 Heavy Duty A Station

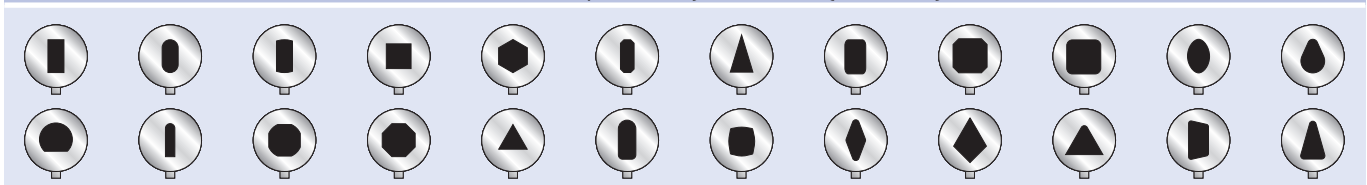


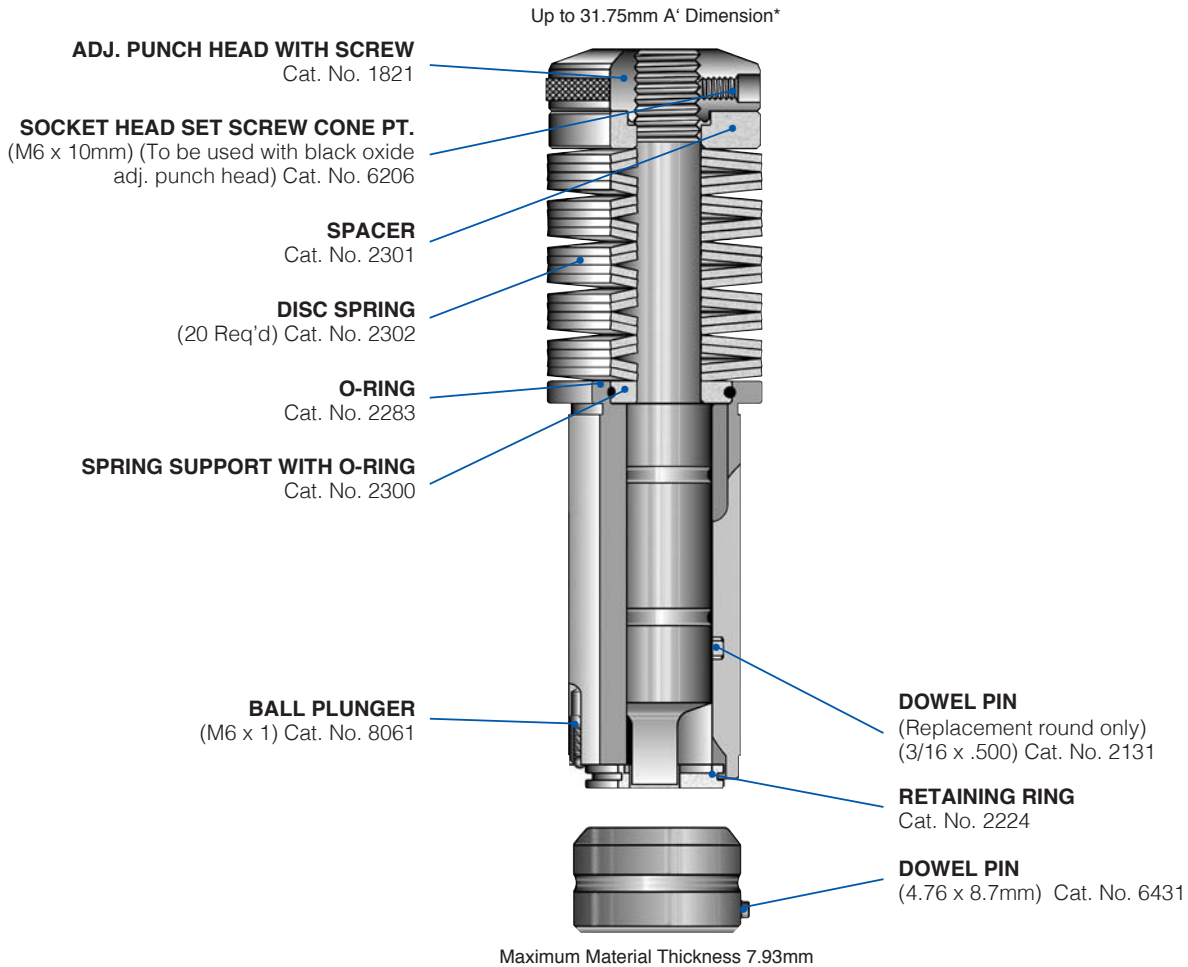
Description		Cat. No.	Price
Punch & Guide Assembly	• Round	2292	
	• Shape Fitted	2293	
	• Optima® Add On	-	
Punches	• Round	2303	
	• Shape	2304	
	• Optima® Add On	-	
Guides	• Round	2821	
	• Shape (0°)	2822	
	• Shape (0° & 45°)	2903	
	• Shape (0° & 90°)	2904	
Stripper	• Round	13044	
	• Shape Fitted	13143	
Dies	• Round Slug Hugger®†	2192	
	• Round Standard	1808	
	• Shape Slug Hugger®†	2193	
	• Shape Standard	13801	
	• Ultima® Add On(Round)	-	
	• Ultima® Add On(Shape)	-	

Notes

- For add ons go to page 33.
- † 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.

Standard Shapes & Key Locations (Die View)

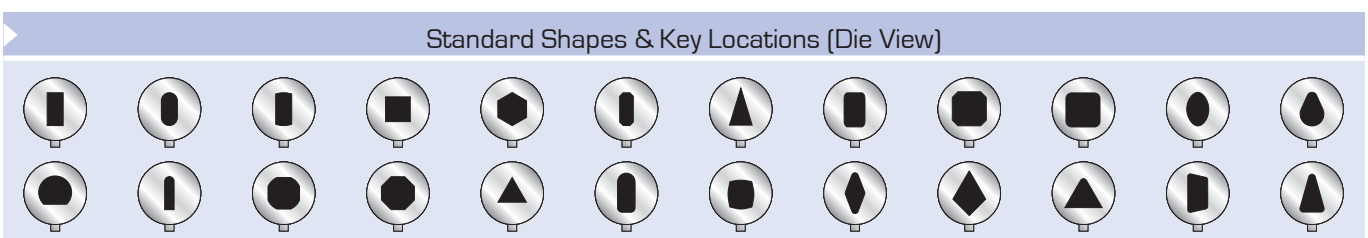




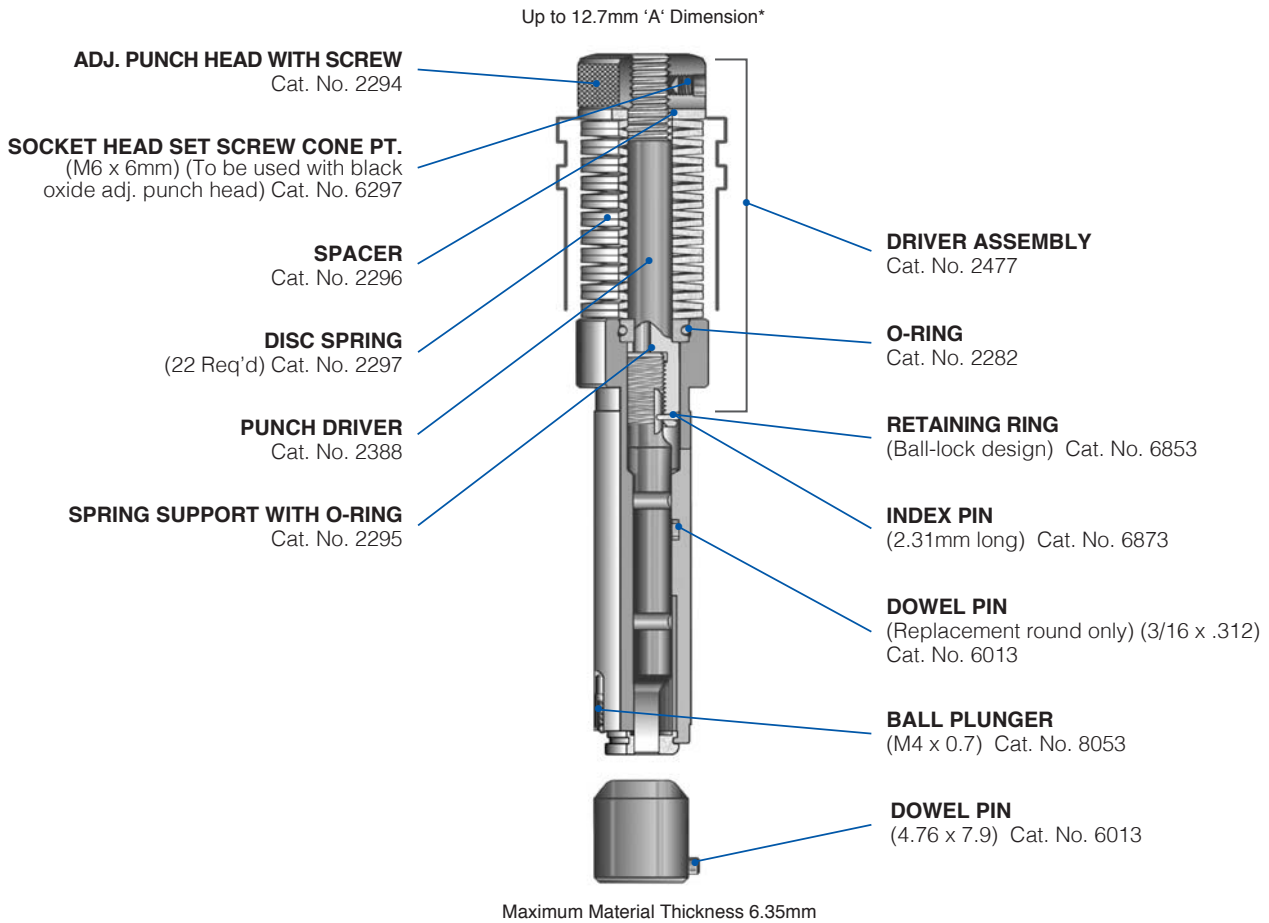
Description		Cat. No.	Price
Punch & Guide Assembly	• Round	2298	
	• Shape Fitted	2299	
	• Optima® Add On	-	
Punches	• Round	2305	
	• Shape	2306	
	• Optima® Add On	-	
Guides	• Round	2859	
	• Shape (0°)	2860	
	• Shape (0° & 45°)	2861	
	• Shape (0° & 90°)	2862	
Stripper	• Round	1890	
	• Shape Fitted	1917	
Dies	• Round Slug Hugger®†	2194	
	• Round Standard	2021	
	• Shape Slug Hugger®†	2195	
	• Shape Standard	13804	
	• Ultima® Add On(Round)	-	
	• Ultima® Add On(Shape)	-	

Notes

- For add ons go to page 33.
- † 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.



HP Heavy Duty A Station



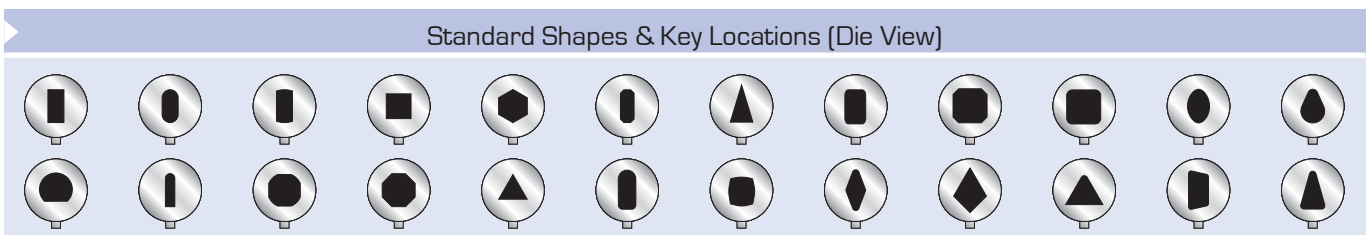
Description	HP™		HP™ ABS	
	Cat. No.	Price	Cat. No.	Price
Punch & Guide Assembly	• Round	12857	12861	
	• Shape Fitted	13182	13185	
	• Optima® Add On	-	-	
	• Ultima® Add On (Round)	-	-	
	• Ultima® Add On (Shape)	-	-	
Punches	• Round	2405	2385	
	• Shape	2406	2389	
	• Optima® Add On	-	-	
	• Ultima® Add On (Round)	-	-	
	• Ultima® Add On (Shape)	-	-	
Guides	• Round	2821	2835	
	• Shape (0°)	2822	2836	
	• Shape (0° & 45°)	2903	2907	
	• Shape (0° & 90°)	2904	2908	
Stripper	• Round	13044	13045	
	• Shape Fitted	13143	13152	
Dies	• Round Slug Hugger®†	2192	2192	
	• Round Standard	1808	1808	
	• Shape Slug Hugger®†	2193	2193	
	• Shape Standard	13801	13801	
	• Ultima® Add On (Round)	-	-	
	• Ultima® Add On (Shape)	-	-	

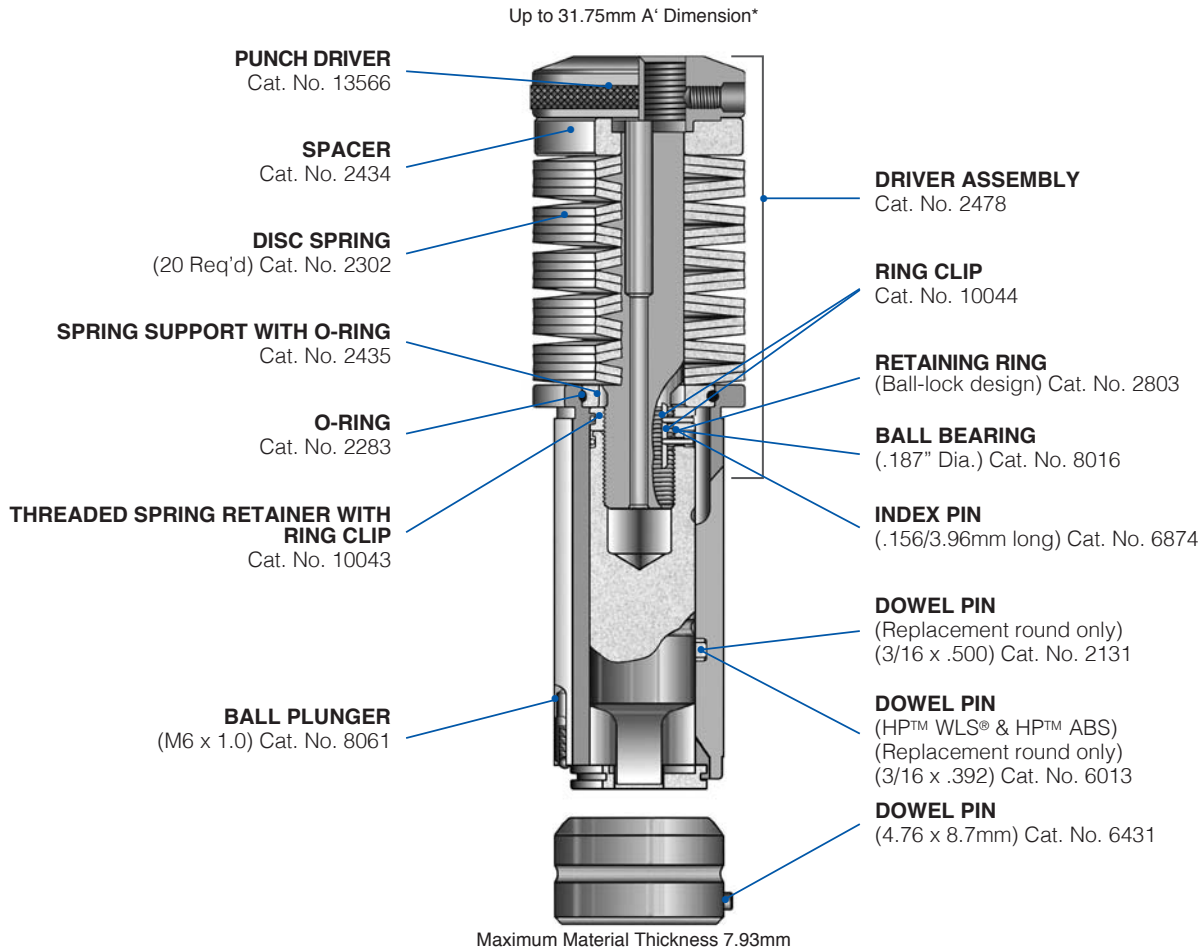
Notes

- Std. keying for square guides is 0° & 45°.
- For add ons go to page 33.

† 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.

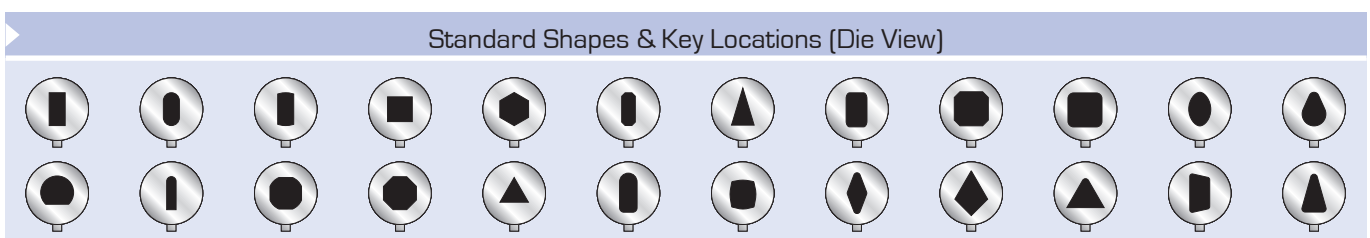
* 'A' Dimension = Longest distance across shape.



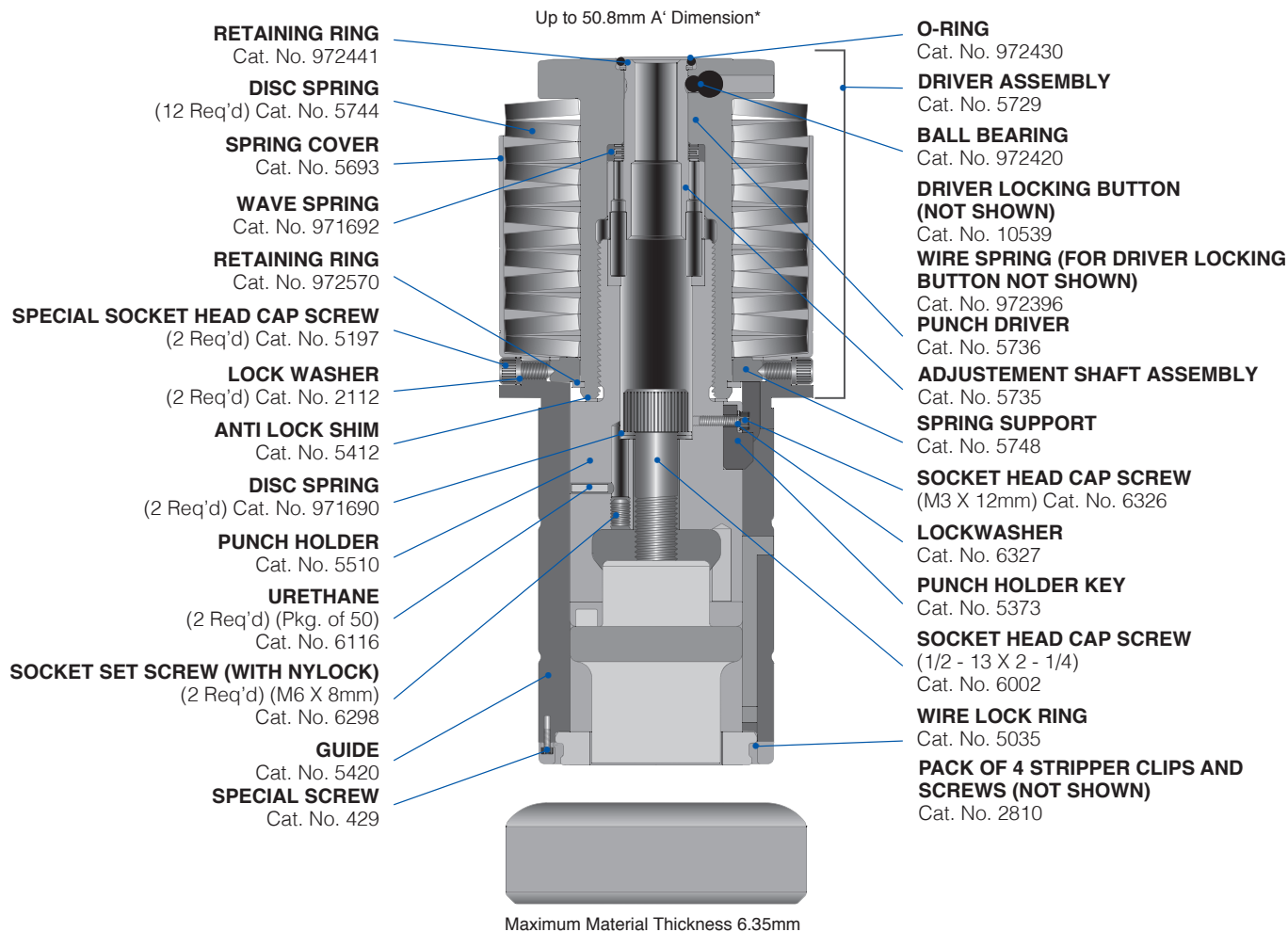


Description	HP™		HP™ ABS	
	Cat. No.	Price	Cat. No.	Price
Punch & Guide Assembly	• Round	12873	12877	
	• Shape Fitted	13194	13197	
	• Optima® Add On	-	-	
	• Ultima® Add On (Round)	-	-	
	• Ultima® Add On (Shape)	-	-	
Punches	• Round	2407	2398	
	• Shape	2408	2399	
	• Optima® Add On	-	-	
	• Ultima® Add On (Round)	-	-	
	• Ultima® Add On (Shape)	-	-	
Guides	• Round	2859	2881	
	• Shape (0°)	2860	2882	
	• Shape (0° & 45°)	2861	2883	
	• Shape (0° & 90°)	2862	2884	
Stripper	• Round	1890	2433	
	• Shape Fitted	1917	2432	
Dies	• Round Slug Hugger®†	2194	2194	
	• Round Standard	2021	2021	
	• Shape Slug Hugger®†	2195	2195	
	• Shape Standard	13804	13804	
	• Ultima® Add On (Round)	-	-	
	• Ultima® Add On (Shape)	-	-	

Notes
• Std. keying for square guides is 0° & 45°.
• For add ons go to page 33.
† 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.



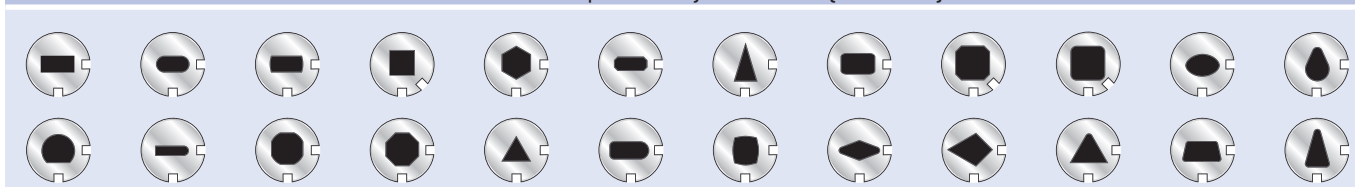
STRIPPER RETAINED WITH WIRE LOCK RING OR STRIPPER CLIPS



Description		Cat. No.	Price
Guide Assembly	• Standard	5586	
	• Standard (LVD)	35194	
	• Standard WLS®	5595	
	• Standard WLS® (LVD)	35195	
Punches	• Round	5026	
	• Shape	5025	
	• Optima® Add On	-	
	• Ultima® Add On (Round)	-	
	• Ultima® Add On (Shape)	-	
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)	-	

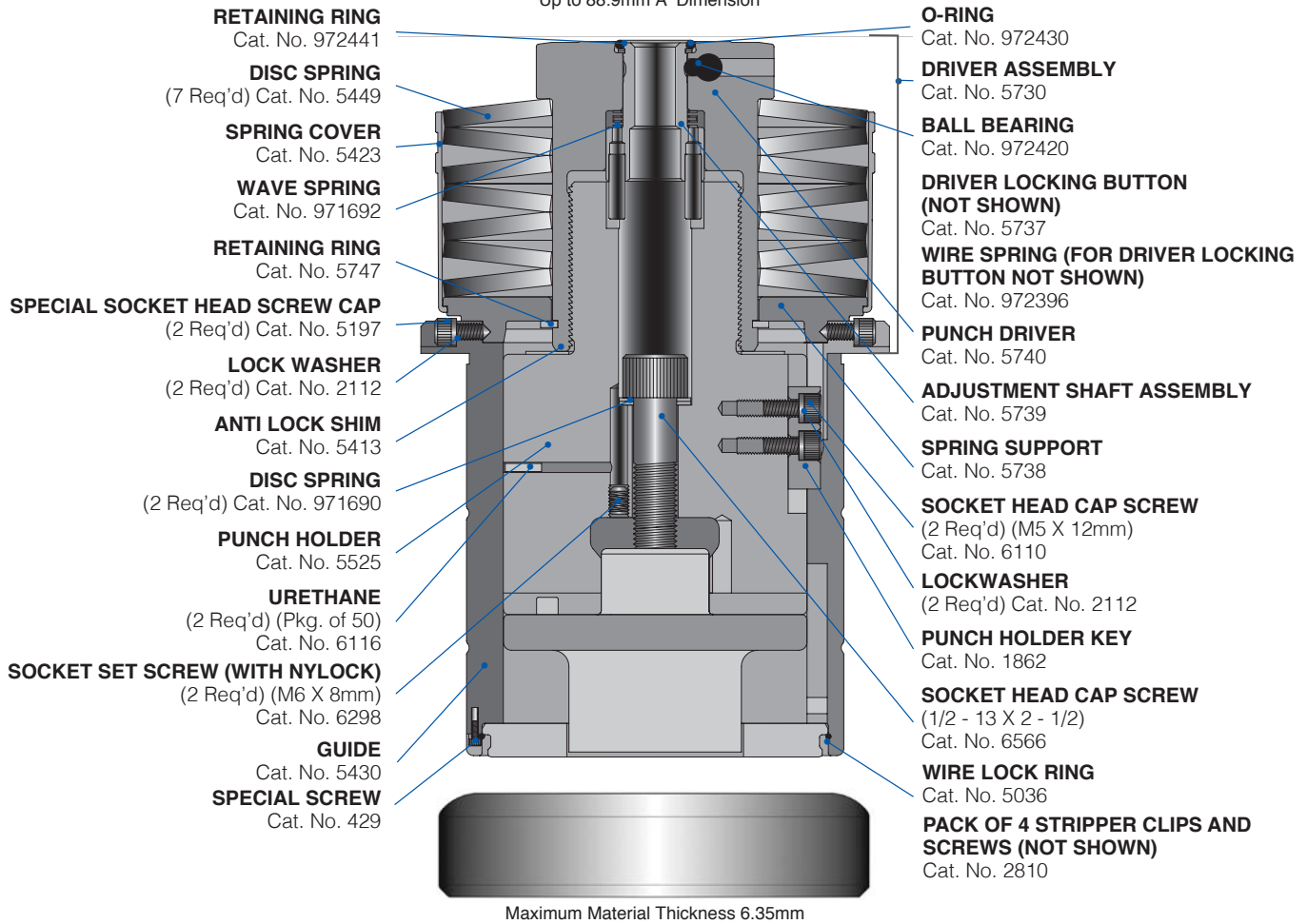
Notes
<ul style="list-style-type: none"> • For add ons go to page 33. • Standard guide assys. are keyed for shapes at 0°, 90° and 225°. • All punches will be shipped with no shear unless specified. <p>† Slug Hugger® dies must be ordered punch size plus clearance. Size restrictions apply. Slug Hugger 2 available on request. Contact Sales Desk for further information.</p> <p>* 'A' Dimension = longest distance across shape.</p>

Standard Shapes & Key Locations (Die View)



STRIPPER RETAINED WITH WIRE LOCK RING OR STRIPPER CLIPS

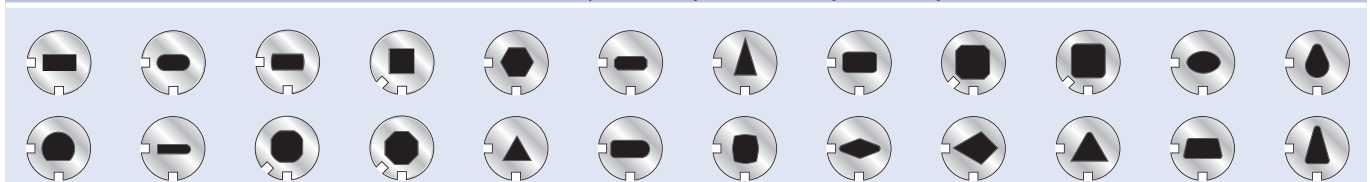
Up to 88.9mm A' Dimension*



Description		Cat. No.	Price
Guide Assembly	• Standard	5587	
	• Standard (LVD)	35201	
	• Standard WLS®	5596	
	• Standard WLS® (LVD)	35202	
Punches	• Round	5028	
	• Shape	5027	
	• Optima® Add On	-	
	• Ultima® Add On (Round)	-	
	• Ultima® Add On (Shape)	-	
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
<ul style="list-style-type: none"> • For add ons go to page 33. • 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. <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>

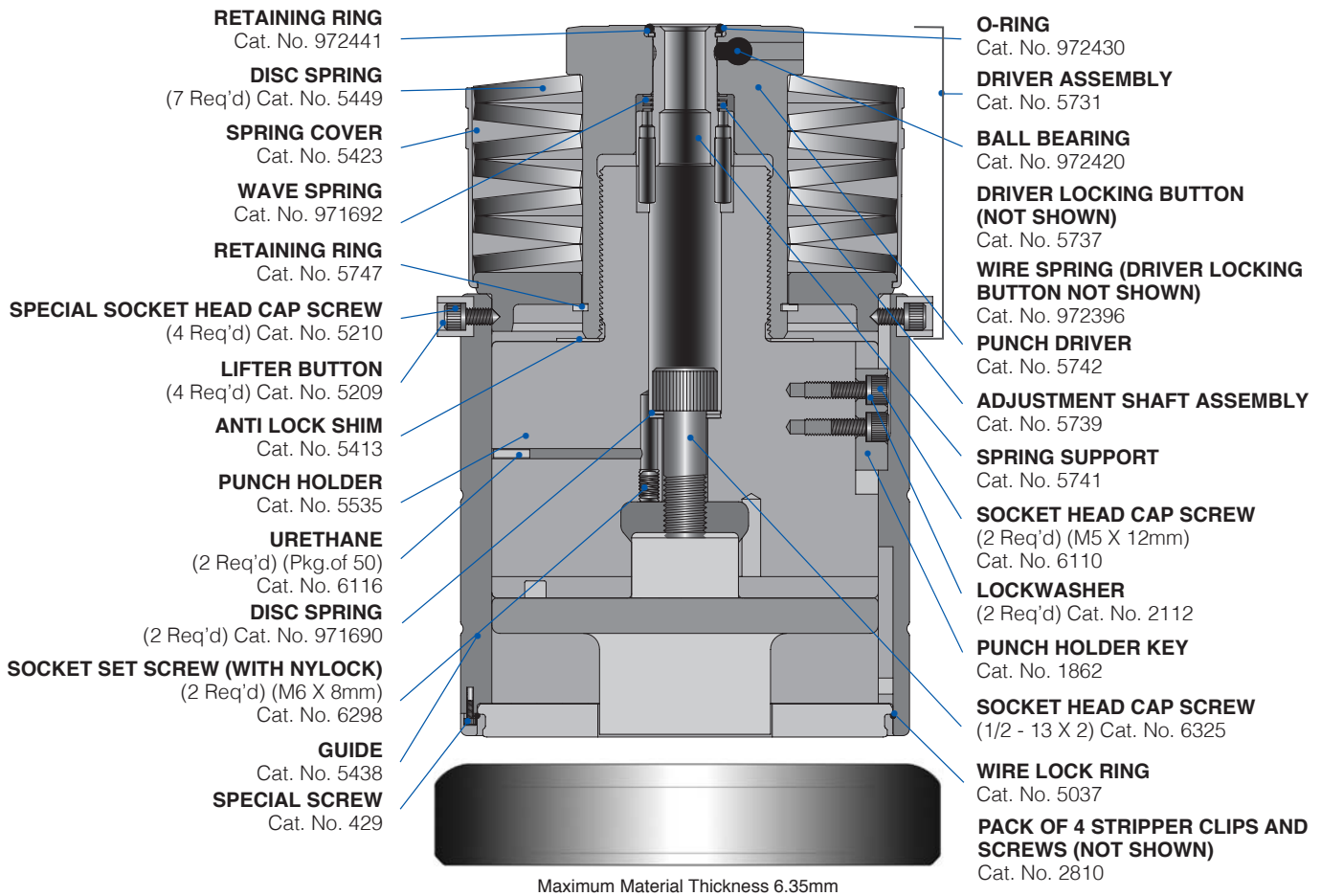
Standard Shapes & Key Locations (Die View)



Wilson Standard E Station

STRIPPER RETAINED WITH WIRE LOCK RING OR STRIPPER CLIPS

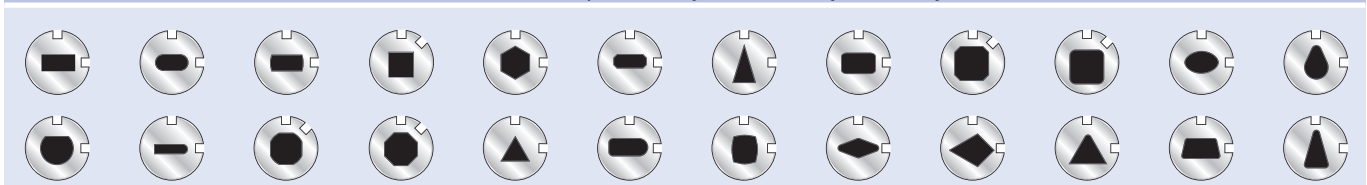
Up to 114.3mm A' Dimension*



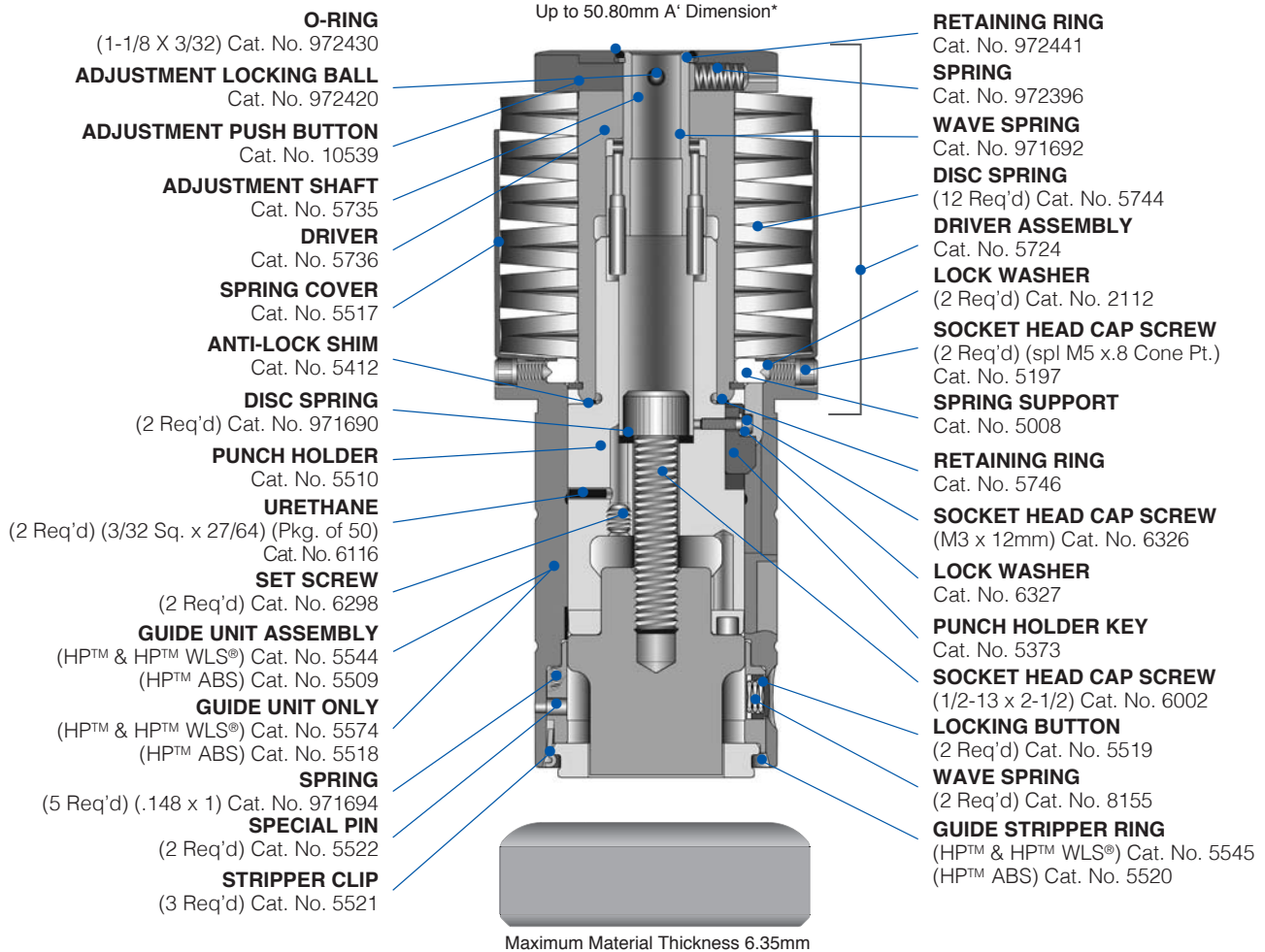
Description	Cat. No.	Price
Guide Assembly	• Standard	5588
	• Standard (LVD)	35205
	• Standard WLS®	5597
	• Standard WLS® (LVD)	35207
Punches	• Round	5030
	• Shape	5029
	• Optima® Add On	-
	• Ultima® Add On (Round)	-
	• Ultima® Add On (Shape)	-
Strippers	• Round	1877
	• Shape	1882
Dies	• Round Slug Hugger®†	2200
	• Round Standard	1878
	• Shape Slug Hugger®†	2201
	• Shape Standard	13817
	• Ultima® Add On(Round)	-
	• Ultima® Add On(Shape)	-

Notes
• For add ons go to page 33.
• 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.

Standard Shapes & Key Locations (Die View)



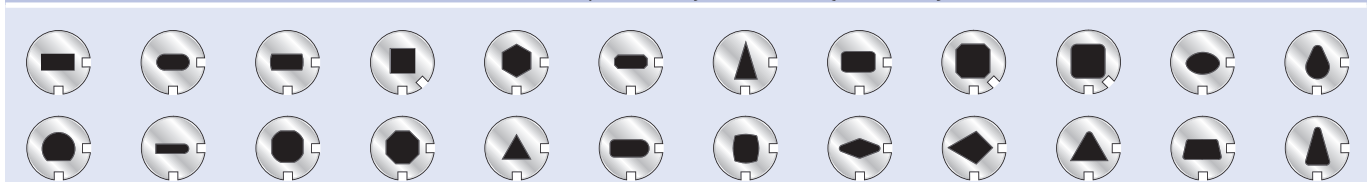
WITH PUSH BUTTON STRIPPER RETENTION



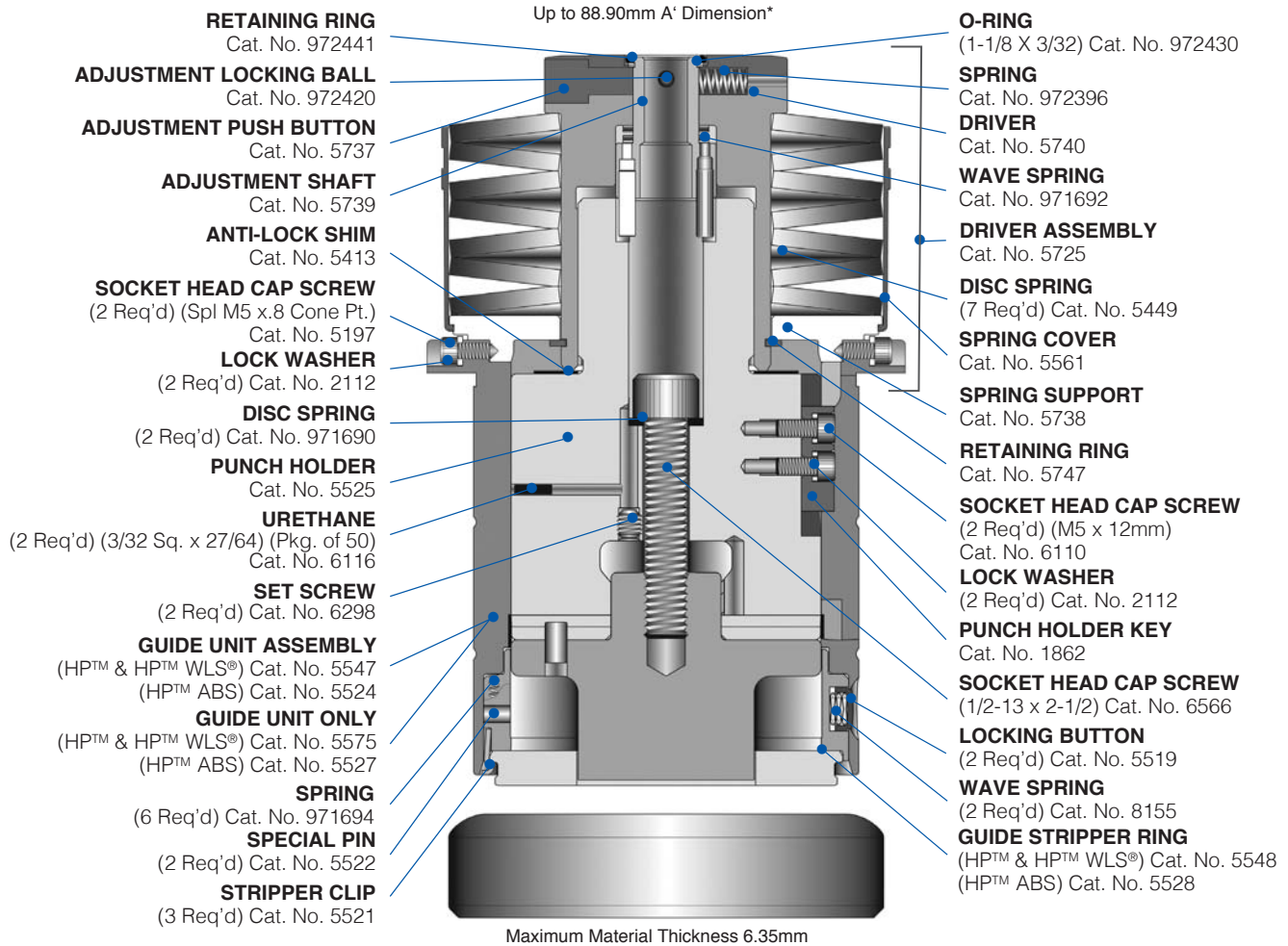
Description	HP™		HP™ ABS	
	Cat. No.	Price	Cat. No.	Price
Guide Assembly	5552		5508	
Punches	• Round	5026	5026	
	• Shape	5025	5025	
	• Optima® Add On	-	-	
	• Ultima® Add On (Round)	-	-	
Stripper	• Round	1848	5150	
	• Shape Fitted	1854	5151	
Dies	• Round Slug Hugger®†	2196	2196	
	• Round Standard	1850	1850	
	• Shape Slug Hugger®†	2197	2197	
	• Shape Standard	13807	13807	
	• Ultima® Add On (Round)	-	-	
	• Ultima® Add On (Shape)	-	-	

Notes
• HP™ guide assys. are keyed for shapes at 0°, 90° & 225°.
• All punches will be shipped with no shear unless specified.
• Heavy Duty tooling is available for 2" (C) stations.
• For add ons go to page 33.
† 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.

Standard Shapes & Key Locations (Die View)



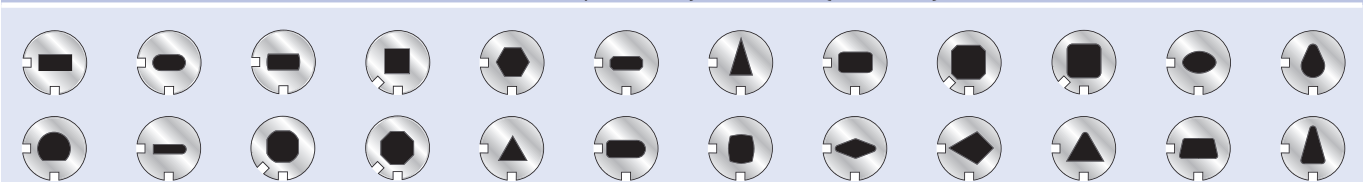
WITH PUSH BUTTON STRIPPER RETENTION



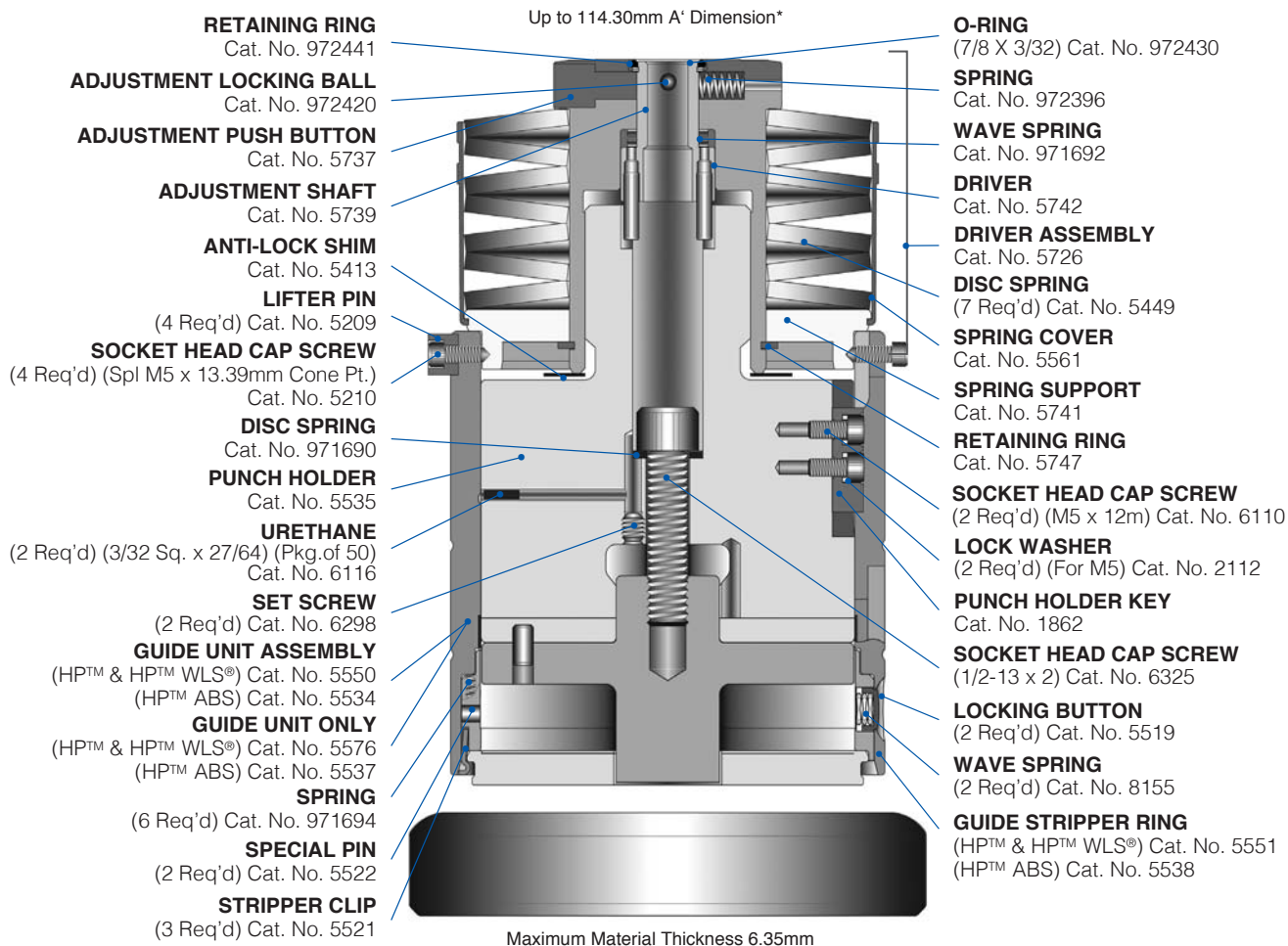
Description	HP™		HP™ ABS	
	Cat. No.	Price	Cat. No.	Price
Guide Assembly	5553		5523	
Punches	• Round	5028	5028	
	• Shape	5027	5027	
	• Optima® Add On	-	-	
	• Ultima® Add On (Round)	-	-	
Stripper	• Round	1864	5152	
	• Shape Fitted	1869	5153	
Dies	• Round Slug Hugger®†	2198	2198	
	• Round Standard	1865	1865	
	• Shape Slug Hugger®†	2199	2199	
	• Shape Standard	13810	13810	
	• Ultima® Add On (Round)	-	-	
	• Ultima® Add On (Shape)	-	-	

Notes
<ul style="list-style-type: none"> • HP™ 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. • For add ons go to page 33. <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>

Standard Shapes & Key Locations (Die View)



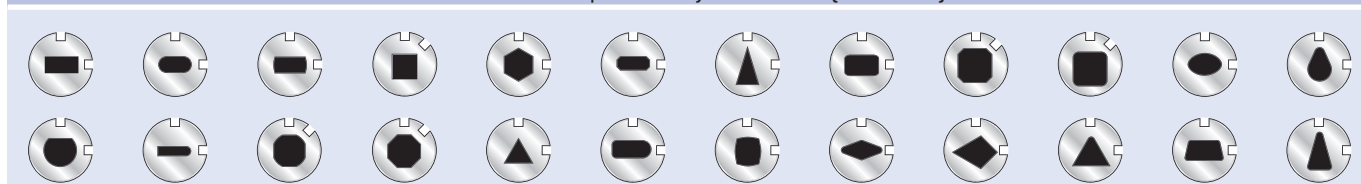
WITH PUSH BUTTON STRIPPER RETENTION



Description	HP™		HP™ ABS	
	Cat. No.	Price	Cat. No.	Price
Guide Assembly	5554		5533	
Punches	• Round	5030	5030	
	• Shape	5029	5029	
	• Optima® Add On	-	-	
	• Ultima® Add On (Round)	-	-	
	• Ultima® Add On (Shape)	-	-	
Stripper	• Round	1877	5154	
	• Shape Fitted	1882	5155	
Dies	• Round Slug Hugger®†	2200	2200	
	• Round Standard	1878	1878	
	• Shape Slug Hugger®†	2201	2201	
	• Shape Standard	13817	13817	
	• Ultima® Add On (Round)	-	-	
	• Ultima® Add On (Shape)	-	-	

Notes
<ul style="list-style-type: none"> • HP™ 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. • For add ons go to page 33. <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>

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.

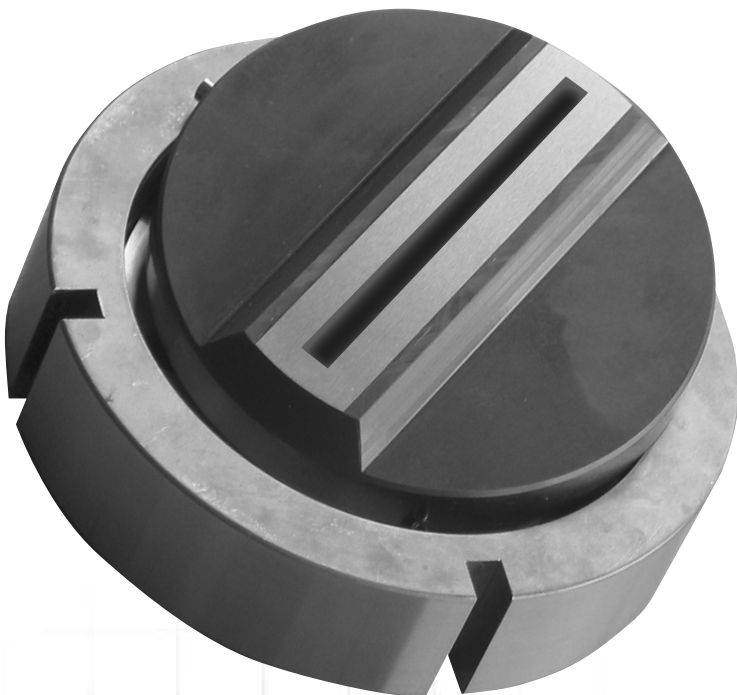


Durable

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

Practical & Economical

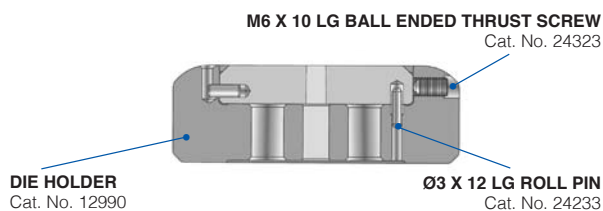
The complete assembly consists of a special die insert, a shim pack and a specially reinforced die holder. You can order duplicate die inserts for different materials and if you need to replace a worn die all you need is a new insert.



DURADIE

WILSON TOOL

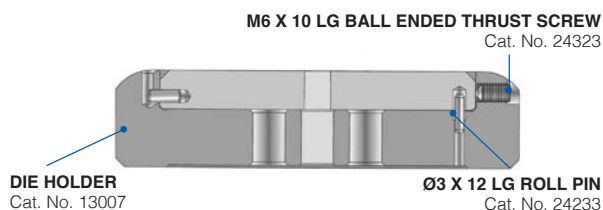
50.8mm (C) Station Slitting



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

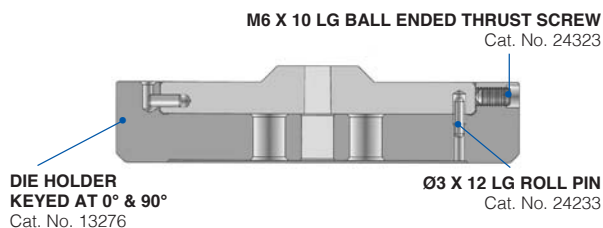
88.9mm (D) Station Slitting



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

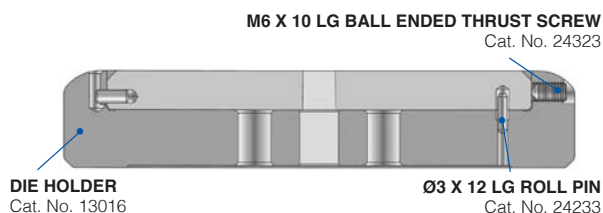
88.9mm (D) Station Close to Clamps



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

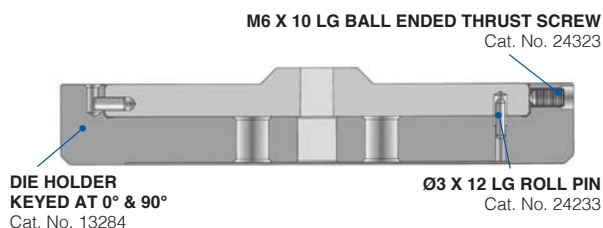
114.3mm (E) Station Slitting



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.



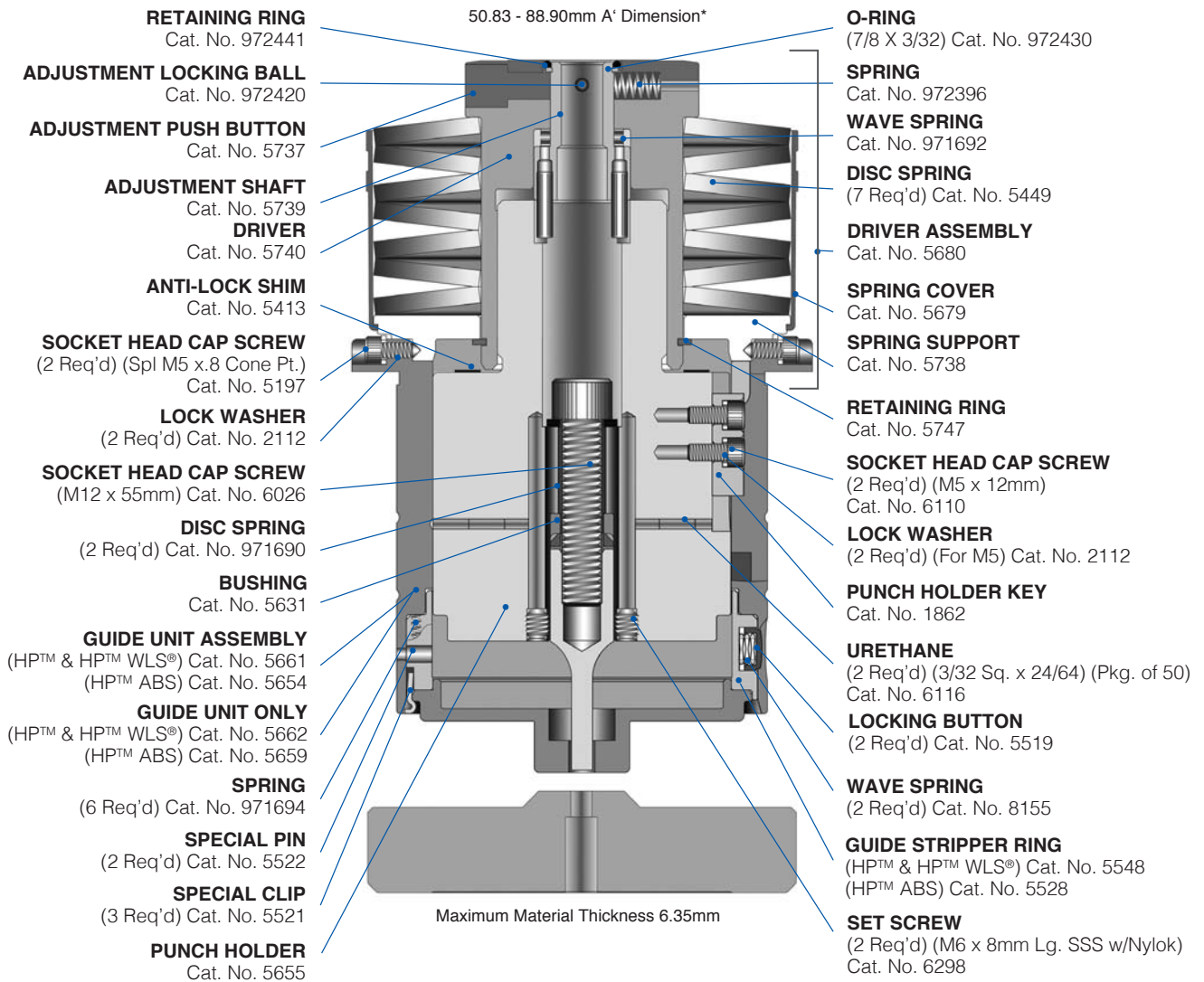
Accurate

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.



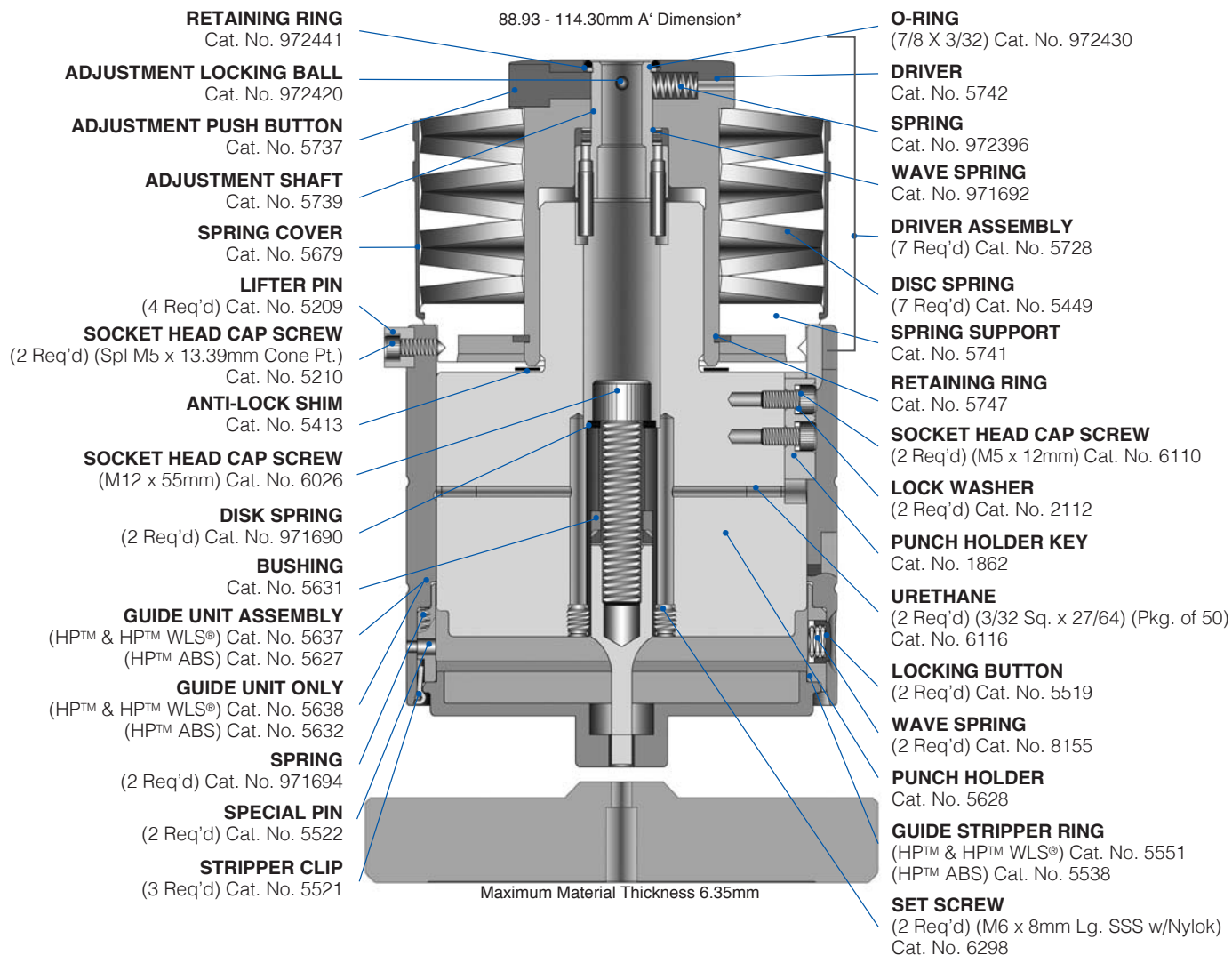
HP DURABLADE



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	For Dies go to page 29.			

Notes
<ul style="list-style-type: none"> • 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 <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 33.

HP DuraBlade E Station



Description	HP™		HP™ ABS	
	Cat. No.	Price	Cat. No.	Price
Guide Assembly	5639		5626	
Punches	• Blade • Optima® Add On	5630 -	5630 -	
Stripper	• Thick Clamps	5629	5640	
Dies	For Dies go to page 29.			

Notes
<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 † 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 33.



88.9mm (D) Station for punching close to clamps

Description	Cat. No.	Price
Guide Assembly	<ul style="list-style-type: none"> Thin Clamps 5179 Thick Clamps 5180 	
Punches	<ul style="list-style-type: none"> Thin Clamps 5027 Thick Clamps 5114 Optima® - Ultima® Add On - 	
Guide	<ul style="list-style-type: none"> (Guide Unit Assembly) 5112 Thin Clamps 5116 Thick Clamps 5116 	
Stripper	<ul style="list-style-type: none"> Thin Clamps 5100 Thick Clamps 5115 	
Dies	<ul style="list-style-type: none"> 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
Guide Assembly	<ul style="list-style-type: none"> Thin Clamps 5177 Thick Clamps 5178 	
Punches	<ul style="list-style-type: none"> Thin Clamps 5029 Thick Clamps 5109 Optima® - Ultima® Add On - 	
Guide	<ul style="list-style-type: none"> (Guide Unit Assembly) 5107 Thin Clamps 5111 Thick Clamps 5111 	
Stripper	<ul style="list-style-type: none"> Thin Clamps 5094 Thick Clamps 5110 	
Dies	<ul style="list-style-type: none"> 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 Positive (relief 2 sides, shp at 90°) 13821 Positive (relief 2 sides, shp at 0°-90°) 13820 Positive (relief 1 side, shp at 90°) 13819 Positive (relief 1 side, shp at 0°-90°) 13818 	

Notes

All punches will be shipped with no shear unless specified.

† 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.

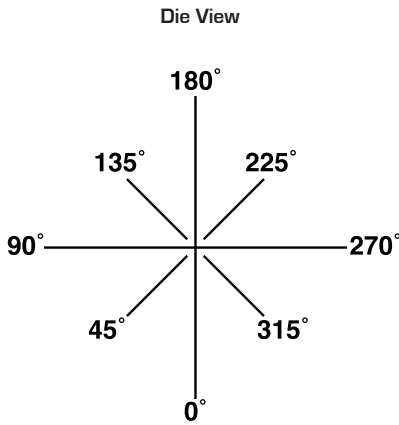
Die Shims and Slug Ejectors

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	1898	
31.75mm (B)	1	1899	
Package			
12.7mm (A)	25	2167	
31.75mm (B)	25	2168	

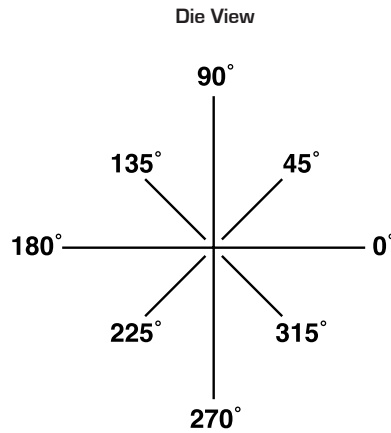
Slug Ejectors			
Square Urethane			
Hole Diameter in Punch	Quantity	Cat. No.	Price
3.2mm	50	6116	
4.8mm	50	6117	
9.5mm	50	6118	
12.7mm	50	6119	
Assortment	50	6410	

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



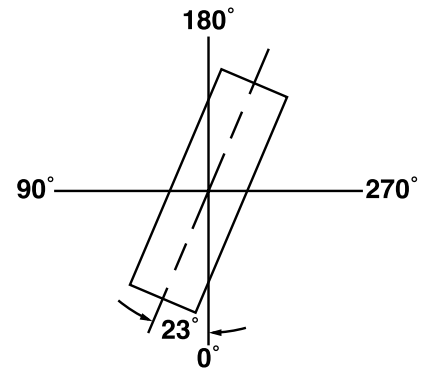
Front of Machine

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

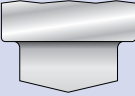
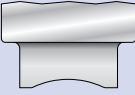
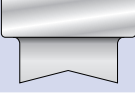
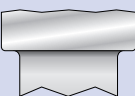
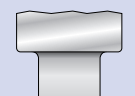
Standard Keying, plus extra pins or keys for shapes at other than 45° increments

Station	Punches	Dies	Guides or Stripper
12.7mm (A)	Not Available	Not Available	per key
31.75mm (B)	Not Available	Not Available	per key
50.8mm (C)	per pin	per key	Not Applicable
88.9mm (D)	per pin	per key	Not Applicable
114.3mm (E)	per pin	per key	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	per key
31.75mm (B)	0° & 45°		0° & 45°		per key
	0° & 180°		0° & 180°		per key
50.8mm (C)	45° Increments	per pin	45° Increments	per key	Not applicable
88.9mm (D)	45° Increments	per pin	45° Increments	per key	Not applicable
114.3mm (E)	45° Increments	per pin	45° Increments	per key	Not applicable

Shear Options

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			
Material	% Total Clearance		
	Minimum	Best	Maximum
Copper, 1/2 Hard	8	12	16
Brass, 1/2 Hard	6	11	16
Mild Steel	10	15	20
Steel 0.50C	12	18	24
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>

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.			

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.			

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 add (2.3mm max dia.)	Shape add	Round add Shape add

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 N/C
Add to round or shape punch for extra straight before radius, extra back taper, or no back taper.			

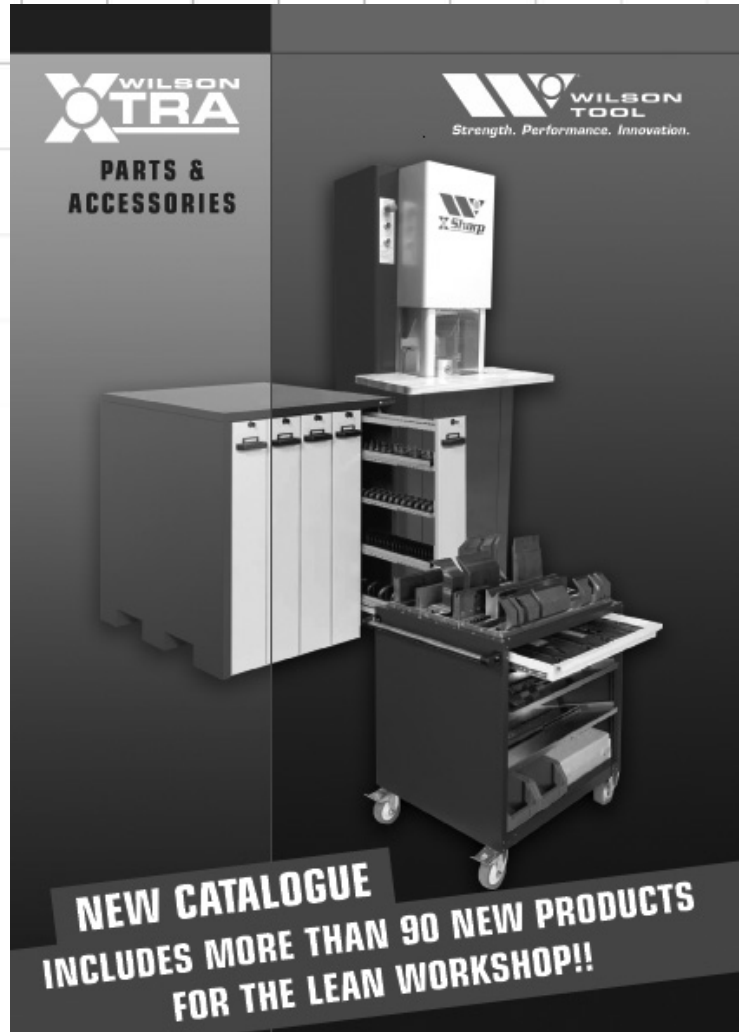
D Station Add Ons			
Add ons for Rounds			
Small Diameter < 48.26mm 48.27 - 50.77mm Clearance < 0.10mm	Punch	Die N/C N/C	Stripper N/C N/C N/C
Add ons for Shapes			
Small Widths 0.79 - 1.0mm 1.01 - 2.34mm Small 'A' Dimension < 48.26mm 48.27 - 50.77mm Clearance < 0.10mm	Punch N/C	Die N/C N/C N/C	Stripper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

Wilson Xtra Catalogue

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