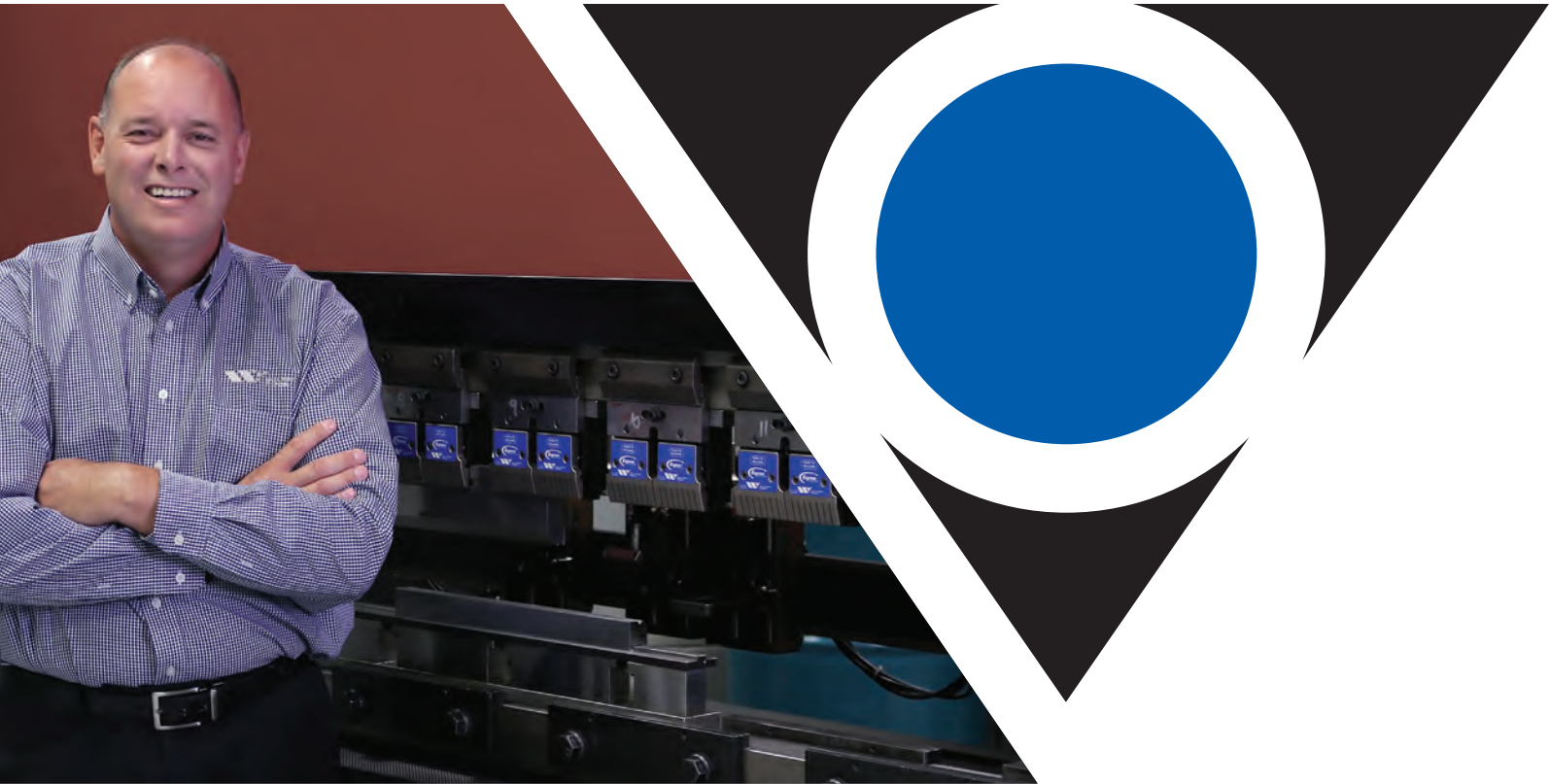




ATC TOOLING

FOR AMADA® PRESS BRAKES

WILSON TOOL INTERNATIONAL



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

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

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

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

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

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

Sincerely,
Brian Robinson
CEO, Wilson Enterprises

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CREDIT REQUIREMENTS All orders are subject to approval by our Credit Department. If you are a new account, please furnish us with your tax exempt status, a bank reference, three current supplier references and/or your current D&B rating with your first order. A credit limit will be imposed on new accounts until credit has been established.

PAYMENT TERMS Terms are net 10 days. Catalog prices are subject to change without notice.

FREIGHT Orders are shipped F.O.B. from our manufacturing facility. (International Shipments are Incoterms: Ex Works).

ORDER CANCELLATION In the event an order is cancelled, an additional charge will be assessed to cover the cost of labor and material.

RETURNED MATERIAL A handling/restocking fee will be applied to all standard products returned for credit. A return authorization number and shipping instructions must be obtained in advance before an item can be returned.

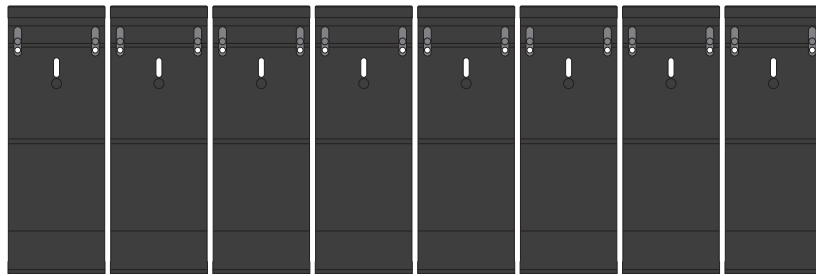
CLAIMS All claims or product shortages must be made within 30 days of the invoice date.

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SECTIONALIZED LENGTHS

SECTIONALIZED LENGTHS

Long Division (LX) Total Length = 800mm (31.5")



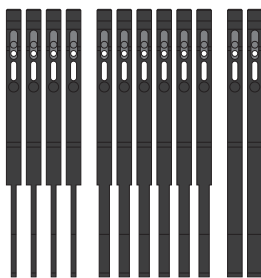
100mm (x8)

Short Division (SX) Total Length = 435mm (17.1")



80mm 60mm 50mm 30mm 25mm (x3) 20mm (x4) 15mm (x4)

Tab Division (TX)
Total Length = 110mm (4.3")



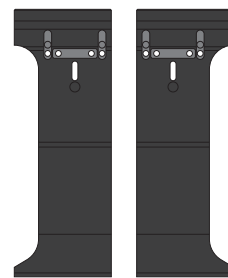
5mm (x4) 10mm (x6) 15mm (x2)

15mm Division (X15)
Total Length = 180mm (7.1")



15mm (x12)

Ear Sections (E)
Total Length = 200mm (7.8")



100mm (x2)

Stocker Capacity by Machine

Machine	PUNCH				DIE		
	Long	Short	Opt Ears	Total	Long	Short	Total
HG 1003 ATC	7	7	1	15	10	8	18
HG 1003 AR	7	7	1	15	10	8	18
HG 2204 ATC	13	4	1	18	20	5	25

FEATURES & OPTIONS



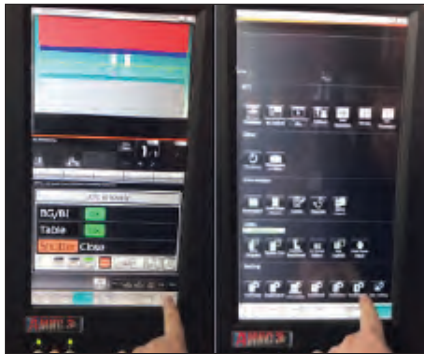
LASER MARKING

Wilson Tool clearly laser marks all of our ATC punches and dies with detail for easy tool identification.



HEAT TREATMENTS

Wilson Tool optimizes tooling durability with our patented Nitrex® high endurance treatment and/or laser hardening. All tools are black in color with a corrosion resistant surface leaving your tooling rust-free for extended life, improved accuracy and reduced material marking.



.FEL FILES

ATC machines are computer driven, and electronic files are a necessary tool to operate efficiently. Wilson Tool can provide you with FEL formatted files and help you load them. Most catalog items are already loaded into your control, but when tooling gets creative, we can provide the detail required by your machine.



TIP MODIFICATIONS

Tip modifications are available in all styles and sizes. Radii not listed in the catalog can be quoted with the fastest lead time available.

PUNCHES



201 – Standard Punches

Part # FEL	Angle	Radius mm (in.)	Height mm (in.)	Max Ton kN/m (T/m)	LX 8x100mm	SX 15	TX 12	X15 12x15mm	E L/R Ear
220 Height Family									
201342	84°	3.0 (.118)	254.52 (10.020)	1000 (100)					
201262	86°	0.2 (.008)	255.91 (10.075)						
201662		0.6 (.024)	255.72 (10.68)						
201202	90°	0.2 (.008)	255.92 (10.076)						
201602		0.6 (.024)	255.75 (10.069)						
240 Height Family									
201344	84°	3.0 (.118)	274.52 (10.808)	1000 (100)					
201264	86°	0.2 (.008)	275.91 (10.863)						
201664		0.6 (.024)	275.72 (10.855)						
201204	90°	0.2 (.008)	275.92 (10.863)						
201604		0.6 (.024)	275.75 (10.856)						



202 – Sash Punches

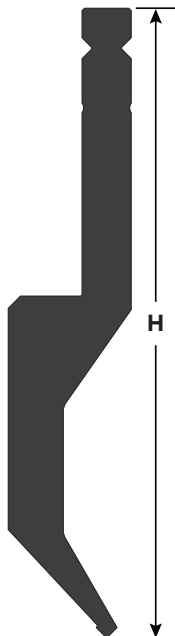
Part # FEL	Angle	Radius mm (in.)	Height mm (in.)	Max Ton kN/m (T/m)	LX 8x100mm	SX 15	TX 12	X15 12x15mm	E L/R Ear
220 Height Family									
202262	86°	0.2 (.008)	255.91 (10.075)	300 (30)					
202662		0.6 (.024)	255.72 (10.68)						
202202	90°	0.2 (.008)	255.92 (10.076)						
202602		0.6 (.024)	255.75 (10.069)						
240 Height Family									
202264	86°	0.2 (.008)	275.91 (10.863)	300 (30)					
202664		0.6 (.024)	275.72 (10.855)						
202204	90°	0.2 (.008)	275.92 (10.863)						
202604		0.6 (.024)	275.75 (10.856)						

PUNCHES



203 – Straight/Sash Punches

Part # FEL	Angle	Radius mm (in.)	Height mm (in.)	Max Ton kN/m (T/m)	LX 8x100mm	SX 15	TX 12	X15 12x15mm	E L/R Ear
220 Height Family									
203262	86°	0.2 (.008)	255.91 (10.075)	1000 (100)					
203662		0.6 (.024)	255.72 (10.68)						
203202	90°	0.2 (.008)	255.92 (10.076)						
203602		0.6 (.024)	255.75 (10.069)						
240 Height Family									
203264	86°	0.2 (.008)	275.91 (10.863)	1000 (100)					
203664		0.6 (.024)	275.72 (10.855)						
203204	90°	0.2 (.008)	275.92 (10.863)						
203604		0.6 (.024)	275.75 (10.856)						



204 – Gooseneck Punches

Part # FEL	Angle	Radius mm (in.)	Height mm (in.)	Max Ton kN/m (T/m)	LX 8x100mm	SX 15	TX 12	X15 12x15mm	E L/R Ear
220 Height Family									
204262	86°	0.2 (.008)	255.91 (10.075)	350 (35)					
204662		0.6 (.024)	255.72 (10.68)						
204202	90°	0.2 (.008)	255.92 (10.076)						
204602		0.6 (.024)	255.75 (10.069)						
240 Height Family									
204264	86°	0.2 (.008)	275.91 (10.863)	350 (35)					
204664		0.6 (.024)	275.72 (10.855)						
204204	90°	0.2 (.008)	275.92 (10.863)						
204604		0.6 (.024)	275.75 (10.856)						

PUNCHES

PUNCHES



205 – Robot Punches

Part # FEL	Angle	Radius mm (in.)	Height mm (in.)	Max Ton kN/m (T/m)	LX 8x100mm	SX 15	TX 12	X15 12x15mm	E L/R Ear
220 Height Family									
205262	86°	0.2 (.008)	255.91 (10.075)	300 (30)					
205662		0.6 (.024)	255.72 (10.68)						
205202	90°	0.2 (.008)	255.92 (10.076)						
205602		0.6 (.024)	255.75 (10.069)						
240 Height Family									
205264	86°	0.2 (.008)	275.91 (10.863)	300 (30)					
205664		0.6 (.024)	275.72 (10.855)						
205204	90°	0.2 (.008)	275.92 (10.863)						
205604		0.6 (.024)	275.75 (10.856)						



206 – Acute Punches

Part # FEL	Angle	Radius mm (in.)	Staging Die	Height mm (in.)	Max Ton kN/m (T/m)	LX 8x100mm	SX 15	TX 12	X15 12x15mm	E L/R Ear
220 Height Family										
206262	30°	0.2 (.008)	86° Die	255.91 (10.075)	500 (50)					
206662		0.6 (.024)	86° Die	255.72 (10.068)						
206202		0.2 (.008)	90° Die	255.92 (10.076)						
206602		0.6 (.024)	90° Die	255.75 (10.069)						
240 Height Family										
206264	30°	0.2 (.008)	86° Die	275.91 (10.862)	500 (50)					
206664		0.6 (.024)	86° Die	275.72 (10.855)						
206204		0.2 (.008)	90° Die	275.92 (10.863)						
206604		0.6 (.024)	90° Die	275.75 (10.856)						

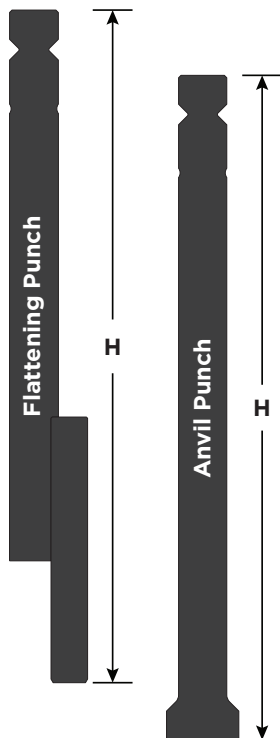
PUNCHES



208 – Straight Punches

Part # FEL	Angle	Radius mm (in.)	Height mm (in.)	Max Ton kN/m (T/m)	LX 8x100mm	SX 15	TX 12	X15 12x15mm	E L/R Ear
220 Height Family									
208342	84°	3.0 (.118)	254.51 (10.02)	1000 (100)					
208262	86°	0.2 (.008)	255.91 (10.075)						
208662		0.6 (.024)	255.72 (10.68)						
208202	90°	0.2 (.008)	255.92 (10.076)						
208602		0.6 (.024)	255.75 (10.069)						
240 Height Family									
208344	84°	3.0 (.118)	274.52 (10.807)	1000 (100)					
208264	86°	0.2 (.008)	275.91 (10.863)						
208664		0.6 (.024)	275.72 (10.855)						
208204	90°	0.2 (.008)	275.92 (10.863)						
208604		0.6 (.024)	275.75 (10.856)						

PUNCHES



209 – Flattening Punches

Part # FEL	Height mm (in.)	Max Ton kN/m (T/m)	LX 8x100mm	SX 15	TX 12	X15 12x15mm	E L/R Ear
220 Height Family							
209942	222.9 (8.776)	1000 (100)			n/a	n/a	n/a
240 Height Family							
209944	242.9 (9.564)	1000 (100)			n/a	n/a	n/a

Anvil Punches

Part # FEL	Height mm (in.)	Max Ton kN/m (T/m)	LX 8x100mm	SX 15	TX 12	X15 12x15mm	E L/R Ear
220 Height Family							
209992	256 (10.079)	1000 (100)			n/a	n/a	n/a
240 Height Family							
209994	276 (10.866)	1000 (100)			n/a	n/a	n/a

The anvil punches are a Wilson Tool design that has been optimized in height to reduce delays in production.

DIES

V4 Dies

Part #/ FEL	V mm (in.)	SR mm (in.)	Height mm (in.)	Description	Max Ton kN/m (T/m)	LX 8x100mm	SX 15	TX 12	X15 12x15mm
30° Angle									
887439	4 (.157)	1.0 (.984)	129.87 (5.113)	Staging Punch 86°/.2 Rad	200 (20)				
897439			128.91 (5.075)	Staging Punch 86°/.6 Rad					
887479			129.87 (5.113)	Staging Punch 90°/.2 Rad					
897479			128.89 (5.074)	Staging Punch 90°/.6 Rad					
86° Angle									
887469	4 (.157)	0.4 (.016)	125.03 (4.922)	Full Body	400 (40)				
897469		1.0 (.984)							
90° Angle									
887409	4 (.157)	0.4 (.016)	124.89 (4.917)	Narrow Body	400 (40)				
897409		1.0 (.984)							
887419		0.4 (.016)		Full Body	1000 (100)				
897419		1.0 (.984)							



V5 Dies

Part #/ FEL	V mm (in.)	SR mm (in.)	Height mm (in.)	Description	Max Ton kN/m (T/m)	LX 8x100mm	SX 15	TX 12	X15 12x15mm
30° Angle									
887539	5 (.197)	1.0 (.984)	131.74 (5.187)	Staging Punch 86°/.2 Rad	190 (19)				
897539			130.78 (5.149)	Staging Punch 86°/.6 Rad					
887579			131.73 (5.186)	Staging Punch 90°/.2 Rad					
897579			130.75 (5.148)	Staging Punch 90°/.6 Rad					
86° Angle									
887569	5 (.197)	0.4 (.016)	125.57 (4.944)	Full Body	500 (50)				
897569		1.0 (.984)							
90° Angle									
887509	5 (.197)	0.4 (.016)	125.39 (4.937)	Narrow Body	500 (50)				
897509		1.0 (.984)							
887519		0.4 (.016)		Full Body	1000 (100)				
897519		1.0 (.984)							



DIES

DIES

V6 Dies



Part #/ FEL	V mm (in.)	SR mm (in.)	Height mm (in.)	Description	Max Ton kN/m (T/m)	LX 8x100mm	SX 15	TX 12	X15 12x15mm	
30° Angle										
887639	6 (.236)	1.0 (.984)	133.61 (5.260)	Staging Punch 86°/.2 Rad	180 (18)					
897639			132.65 (5.222)	Staging Punch 86°/.6 Rad						
887679			133.6 (5.260)	Staging Punch 90°/.2 Rad						
897679			132.62 (5.221)	Staging Punch 90°/.6 Rad						
86° Angle										
887669	6 (.236)	0.4 (.016)	126.11 (4.965)	Full Body	500 (50)					
897669		1.5 (.060)								
90° Angle										
887609	6 (.236)	0.4 (.016)	125.89 (4.956)	Narrow Body	550 (55)					
897609		1.5 (.060)								
887619		0.4 (.016)		Full Body	1000 (100)					
897619		1.5 (.060)								

V7 Dies



Part #/ FEL	V mm (in.)	SR mm (in.)	Height mm (in.)	Description	Max Ton kN/m (T/m)	LX 8x100mm	SX 15	TX 12	X15 12x15mm	
30° Angle										
887739	7 (.276)	1.0 (.984)	135.47 (5.333)	Staging Punch 86°/.2 Rad	200 (20)					
897739			134.51 (5.296)	Staging Punch 86°/.6 Rad						
887779			135.47 (5.333)	Staging Punch 90°/.2 Rad						
897779			134.49 (5.295)	Staging Punch 90°/.6 Rad						
86° Angle										
887769	7 (.276)	0.5 (.020)	126.64 (4.986)	Full Body	600 (60)					
897769		1.5 (.060)								
90° Angle										
887709	7 (.276)	0.5 (.020)	126.39 (4.976)	Narrow Body	600 (60)					
897709		1.5 (.060)								
887719		0.5 (.020)		Full Body	1000 (100)					
897719		1.5 (.060)								

DIES

V8 Dies



Part #/ FEL	V mm (in.)	SR mm (in.)	Height mm (in.)	Description	Max Ton kN/m (T/m)	LX 8x100mm	SX 15	TX 12	X15 12x15mm
30° Angle									
887839	8 (.315)	1.0 (.984)	137.39 (5.409)	Staging Punch 86°/.2 Rad	200 (20)				
897839			136.38 (5.369)	Staging Punch 86°/.6 Rad					
887879			137.33 (5.407)	Staging Punch 90°/.2 Rad					
897879			136.35 (5.368)	Staging Punch 90°/.6 Rad					
86° Angle									
887869	8 (.315)	0.5 (.020)	127.18 (5.007)	Full Body	650 (65)				
897869		1.5 (.060)							
90° Angle									
887809	8 (.315)	0.5 (.020)	126.89 (4.996)	Narrow Body	650 (65)				
897809		1.5 (.060)							
887819		0.5 (.020)		Full Body	1000 (100)				
897819		1.5 (.060)							

V10 Dies



Part #/ FEL	V mm (in.)	SR mm (in.)	Height mm (in.)	Description	Max Ton kN/m (T/m)	LX 8x100mm	SX 15	TX 12	X15 12x15mm
30° Angle									
888039	10 (.394)	1.0 (.984)	141.07 (5.554)	Staging Punch 86°/.2 Rad	260 (26)				
898039			140.11 (5.516)	Staging Punch 86°/.6 Rad					
888079			141.06 (5.554)	Staging Punch 90°/.2 Rad					
898079			140.08 (5.515)	Staging Punch 90°/.6 Rad					
86° Angle									
888069	10 (.394)	0.6 (.024)	128.25 (5.049)	Full Body	900 (90)				
898069		2.0 (.079)							
90° Angle									
888009	10 (.394)	0.6 (.024)	127.89 (5.035)	Narrow Body	900 (90)				
898009		2.0 (.079)							
888019		0.6 (.024)		Full Body	1000 (100)				
898019		2.0 (.079)							

DIES

V12 Dies



Part #/ FEL	V mm (in.)	SR mm (in.)	Height mm (in.)	Description	Max Ton kN/m (T/m)	LX 8x100mm	SX 15	TX 12	X15 12x15mm
30° Angle									
881239	12 (.472)	1.0 (.984)	144.8 (5.701)	Staging Punch 86°/.2 Rad	250 (25)				
891239			143.84 (5.663)	Staging Punch 86°/.6 Rad					
881279			144.8 (5.701)	Staging Punch 90°/.2 Rad					
891279			143.82 (5.662)	Staging Punch 90°/.6 Rad					
86° Angle									
888269	12 (.472)	0.8 (.032)	129.32 (5.091)	Full Body	1000 (100)				
898269		2.5 (.098)							
90° Angle									
888209	12 (.472)	0.8 (.032)	128.89 (5.074)	Full Body	1000 (100)				
898209		2.5 (.098)							

V14 Dies



Part #/ FEL	V mm (in.)	SR mm (in.)	Height mm (in.)	Description	Max Ton kN/m (T/m)	LX 8x100mm	SX 15	TX 12	X15 12x15mm
30° Angle									
881439	14 (.551)	1.0 (.984)	148.53 (5.848)	Staging Punch 86°/.2 Rad	200 (20)				
891439			147.57 (5.810)	Staging Punch 86°/.6 Rad					
881479			148.53 (5.848)	Staging Punch 90°/.2 Rad					
891479			147.55 (5.809)	Staging Punch 90°/.6 Rad					
86° Angle									
888469	14 (.551)	0.8 (.032)	130.4 (5.134)	Full Body	1000 (100)				
898469		2.5 (.098)							
90° Angle									
888409	14 (.551)	0.8 (.032)	129.89 (5.114)	Full Body	1000 (100)				
898409		2.5 (.098)							

DIES

DIES



V16 Dies

Part #/ FEL	V mm (in.)	SR mm (in.)	Height mm (in.)	Description	Max Ton kN/m (T/m)	LX 8x100mm	SX 15	TX 12	X15 12x15mm
30° Angle									
831849	16 (.630)	1.0 (.984)	145.64 (95.734)	Staging Punch 84°/.3 Rad	180 (18)				
861869			151.31 (5.957)	Staging Punch 86°/.6 Rad					
86° Angle									
881669	16 (.630)	0.8 (.032)	131.47 (5.176)	Full Body	1000 (100)				
891669		2.5 (.098)							
90° Angle									
881609	16 (.630)	0.8 (.032)	130.89 (5.153)	Full Body	1000 (100)				
891609		2.5 (.098)							



V18 Dies

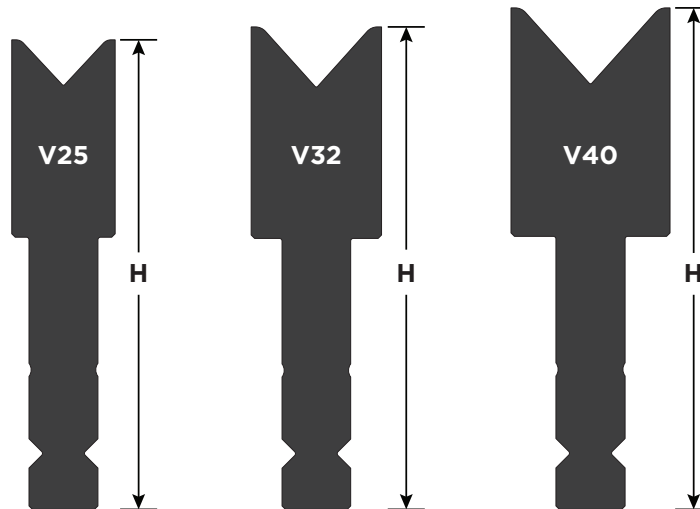
Part #/ FEL	V mm (in.)	SR mm (in.)	Height mm (in.)	Description	Max Ton kN/m (T/m)	LX 8x100mm	SX 15	TX 12	X15 12x15mm
86° Angle									
881869	18 (.709)	1.0 (.984)	132.54 (5.218)	Full Body	1000 (100)				
891869		2.5 (.098)							
90° Angle									
881809	18 (.709)	1.0 (.984)	131.89 (5.193)	Full Body	1000 (100)				
891809		2.5 (.098)							



V20 Dies

Part #/ FEL	V mm (in.)	SR mm (in.)	Height mm (in.)	Description	Max Ton kN/m (T/m)	LX 8x100mm	SX 15	TX 12	X15 12x15mm
86° Angle									
882069	20 (.787)	1.0 (.984)	133.61 (5.260)	Full Body	1000 (100)				
892069		3.0 (.118)							
90° Angle									
882009	20 (.787)	1.0 (.984)	132.89 (5.232)	Full Body	1000 (100)				
892009		3.0 (.118)							

DIES



V25 Die

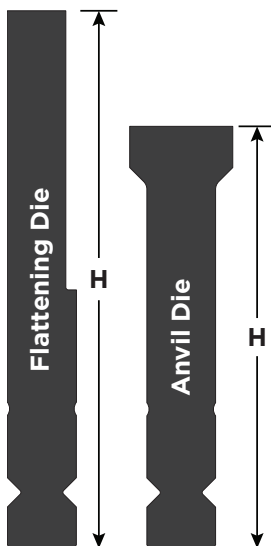
Part #/ FEL	V mm (in.)	SR mm (in.)	Height mm (in.)	Description	Max Ton kN/m (T/m)	LX 8x100mm	SX 15	TX 12	X15 12x15mm
86° Angle									
892569	25 (.984)	3.0 (.118)	136.29 (5.366)	Full Body	1000 (100)				

V32 Die

Part #/ FEL	V mm (in.)	SR mm (in.)	Height mm (in.)	Description	Max Ton kN/m (T/m)	LX 8x100mm	SX 15	TX 12	X15 12x15mm
84° Angle									
893249	32 (1.260)	4.0 (.157)	140.66 (5.538)	Full Body	1000 (100)				

V40 Die

Part #/ FEL	V mm (in.)	SR mm (in.)	Height mm (in.)	Description	Max Ton kN/m (T/m)	LX 8x100mm	SX 15	TX 12	X15 12x15mm
84° Angle									
884049	40 (1.575)	4.0 (.157)	145.1 (5.713)	Full Body	1000 (100)				



Flattening Die

Part #/ FEL	Height mm (in.)	Description	Max Ton kN/m (T/m)	LX 8x100mm	SX 15	TX 12	X15 12x15mm
889969	156 (6.142)	Full Body	1000 (100)			n/a	n/a

Anvil Die

Part #/ FEL	Height mm (in.)	Description	Max Ton kN/m (T/m)	LX 8x100mm	SX 15	TX 12	X15 12x15mm
889999	122.9 (4.838)	Full Body	1000 (100)			n/a	n/a

The anvil dies are a Wilson Tool design that has been optimized in height to reduce delays in production.

STAGED OFFSET

STAGED OFFSET

Offset - Metric Solid Body

Punch & Die Assembly Part #	Angle	Size mm (in.)	Max Ton kN/m (T/m)	Approximate Gross Weight lbs.			LX 8x100mm	SX 15	X15 12x15mm
				LX	SX	X15			
220 Height Family									
441902157	90°	4 (.157)	1000 (100)	102	56	23			
441902236		6 (.236)		102	56	23			
441902315		8 (.315)		109	59	25			
441902394		10 (.394)		109	59	25			
441902472		12 (.472)		115	62	26			
240 Height Family									
441904157	90°	4 (.157)	1000 (100)	108	58	24			
441904236		6 (.236)		108	58	24			
441904315		8 (.315)		115	62	26			
441904394		10 (.394)		115	62	26			
441904472		12 (.472)		122	66	27			

These are exclusive Wilson Tool designs that are not offered by Amada.



ACCESSORIES

TOOL STORAGE CABINET	DESCRIPTION
 <p>90021</p>  <p>Extended wheel base prevents the cabinet from tipping.</p>	<ul style="list-style-type: none"> • Ten drawer Tool storage cabinet • Lay down storage allows visibility of laser marking for easy tool identification • Solid steel construction • Mobile base with heavy duty casters - extended wheel base prevents tipping • Rated capacity of 3,600 lbs. • Drawers lined with industrial strength rubber mat • Total weight capacity: 400 lbs. per drawer • Retainer top with rubber mat





Cat. No.	Lead Time	Dimensions H x W x D	Drawers Included		
			2" [50mm]	3" [76mm]	4" [101mm]
90021	5-15 Days	51.5" x 48" x 27"	2	6	2

Custom Color Options

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

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


Ships via truck freight. Additional tooling cabinets available.


XTREME STORAGE CABINETS	DESCRIPTION
 <p>55130 3 Drawers</p>    <p>55131 5 Drawers</p>	<ul style="list-style-type: none"> • Vertical cabinet drawers are easily accessible from either side • Each drawer contains three 7-inch wide shelves that hold up to 265 lbs. (120kg) each • Each drawer contains a shallow top tray with adjustable dividers for storage of measurement devices, hand tools, etc. • Flexible, adjustable trays and inserts can accommodate various tooling sizes and styles • Punches are held securely in tip-up position • Small footprint allows for easy placement of tools close to machines


Cat. No.	Number of Drawers	Cabinet Height (outside dim.)	Width - Left to Right (outside dim.)	Depth - Front to Back (inside dim.)	Number of Tool Trays	Total Length* of Tooling	
						1 Tool/Tray (inside dim.)	2 Tools/Tray (inside dim.)
55130 (XSC312)	3	48.8" (1.24m)	26.0" (0.66m)	51.2" (1.3m)	9	Up to 31 ft. (9.44m)	Up to 62 ft. (18.9m)
55131 (XSC512)	5	48.8" (1.24m)	40.9" (1.04m)	51.2" (1.3m)	15	Up to 51.5 ft. (15.7m)	Up to 103 ft. (31.4m)

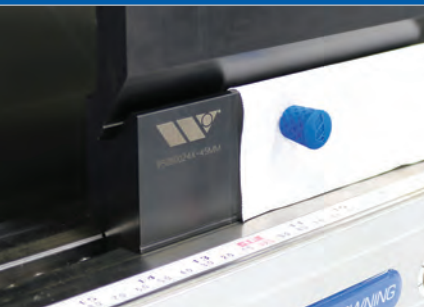
*Total length does not include available storage in the top most tray in each drawer.

ACCESSORIES

MAGNET SQUARE	CAT. NO.	DESCRIPTION
	974150	<ul style="list-style-type: none"> • ON/OFF work holding magnet • 150 lbs. [70kg] of hold force • Size: 30mm Square

MAGNETIC SQUARING ARM	CAT. NO.	DESCRIPTION
 <p>42750</p>	42750L	Magnetic Squaring Arm LEFT
	42750R	Magnetic Squaring Arm RIGHT
	42750A	Adapter required for use with Wilson Tool American Precision 30° Arrow Style Dies

URETHANE DRAPE - 100 FT.	DESCRIPTION	CAT. NO.	SIZE	DUROMETER
	Forms a protective barrier between the sheet metal and the die shoulders during the bending process to eliminate sheet marking.	42530	.015" x 6" [.4 x 152mm]	85A
		42531	.030" x 6" [.8 x 152mm]	85A
		42532	.022" x 6" [.56 x 152mm]	95A

PROTECTIVE FABRIC DRAPE	DESCRIPTION	CAT. NO.	SIZE
	Forms a protective barrier between the sheet metal and the die shoulders during the bending process to eliminate sheet marking. Lasts 5-8 times longer than a urethane drape.	55335	12.5m [41 ft.] length x 120mm [4.7"] width x .3mm [.012"] thick
		987041	3/8" x 1/2" Cylinder Magnet

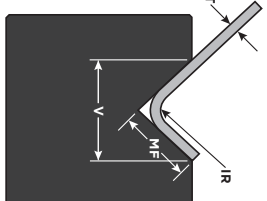
AIR BENDING FORCE CHART

IMPERIAL TONNAGE • METRIC V-OPENINGS

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

NOTE: Formulas and chart are for reference only.

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



GAUGE	DEC. Inch [mm]	TONS PER FOOT																								
		V (mm)	4	6	7	8	10	12	14	16	18	20	25	32	40	50	63	80	100	125	160	200	250			
20	0.036 [.91]	V (in.)	0.157	0.236	0.276	0.315	0.394	0.472	0.551	0.630	0.709	0.787	0.984	1.260	1.575	1.969	2.480	3.150	3.937	4.921	6.299	7.874	9.843			
		MF	0.110	0.165	0.193	0.220	0.276	0.331	0.397	0.454	0.510	0.567	0.709	0.945	1.181	1.476	1.860	2.362	2.933	3.789	4.850	6.063	7.579			
18	0.048 [1.2]	IR	0.026	0.039	0.046	0.052	0.066	0.079	0.092	0.105	0.118	0.131	0.164	0.210	0.262	0.328	0.413	0.525	0.656	0.820	1.050	1.312	1.640			
		V (in.)	4	6	7	8	10	12	14	16	18	20	25	32	40	50	63	80	100	125	160	200	250			
16	0.060 [1.5]	IR	5.4	3.6	3.0	2.5	2.0	1.7																		
		V (in.)	6	7	8	10	12	14	16	18	20	25	32	40	50	63	80	100	125	160	200	250				
14	0.075 [1.9]	IR	7.2	5.8	4.8	3.7	2.7	2.4	2.0																	
		V (in.)	7	8	10	12	14	16	18	20	25	32	40	50	63	80	100	125	160	200	250					
13	0.090 [2.3]	IR	7.8	6.0	5.0	4.2	3.5	3.1	2.7																	
		V (in.)	8	10	12	14	16	18	20	25	32	40	50	63	80	100	125	160	200	250						
12	0.105 [2.7]	IR	11.3	7.5	7.1	5.6	4.8	4.1	3.2																	
		V (in.)	10	12	14	16	18	20	25	32	40	50	63	80	100	125	160	200	250							
11	0.120 [3]	IR	12.5	10.1	8.2	7.2	5.4	3.7																		
		V (in.)	12	14	16	18	20	25	32	40	50	63	80	100	125	160	200	250								
10	0.135 [3.4]	IR	15.8	13.0	10.5	9.5	7.5	5.6	4.0																	
		V (in.)	14	16	18	20	25	32	40	50	63	80	100	125	160	200	250									
9	0.150 [3.8]	IR	16.1	13.1	10.1	12.0	8.1	6.2	4.7																	
		V (in.)	16	18	20	25	32	40	50	63	80	100	125	160	200	250										
3/16"	0.188 [4.8]	IR	24.1	15.0	11.3	7.5	5.8																			
		V (in.)	18	20	25	32	40	50	63	80	100	125	160	200	250											
1/4"	0.250 [6.35]	IR	30.0	20.0	15.0	10.5	8.5																			
		V (in.)	20	25	32	40	50	63	80	100	125	160	200	250												
5/16"	0.313 [8]	IR	37.6	25.0	18.8	13.1	10.0																			
		V (in.)	25	32	40	50	63	80	100	125	160	200	250													
3/8"	0.375 [9.5]	IR	38.3	28.1	22.5	15.0	11.3																			
		V (in.)	32	40	50	63	80	100	125	160	200	250														
1/2"	0.500 [12.7]	IR	52.0	39.0	30.0	22.0	16.0																			
		V (in.)	40	50	63	80	100	125	160	200	250															
5/8"	0.625 [16]	IR	70.0	52.5	37.5	27.5	20.0																			
		V (in.)	50	63	80	100	125	160	200	250																
3/4"	0.750 [19]	IR	66.0	45.0	32.3	22.5	15.0																			
		V (in.)	63	80	100	125	160	200	250																	
1"	1.000 [25.4]	IR	90.0	60.0	44.0	32.3	22.5																			
		V (in.)	80	100	125	160	200	250																		
1-1/4"	1.250 [32]	IR	102.5	75.0																						
		V (in.)	100	125	160	200	250																			

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

Larger v-openings generate less tonnage.

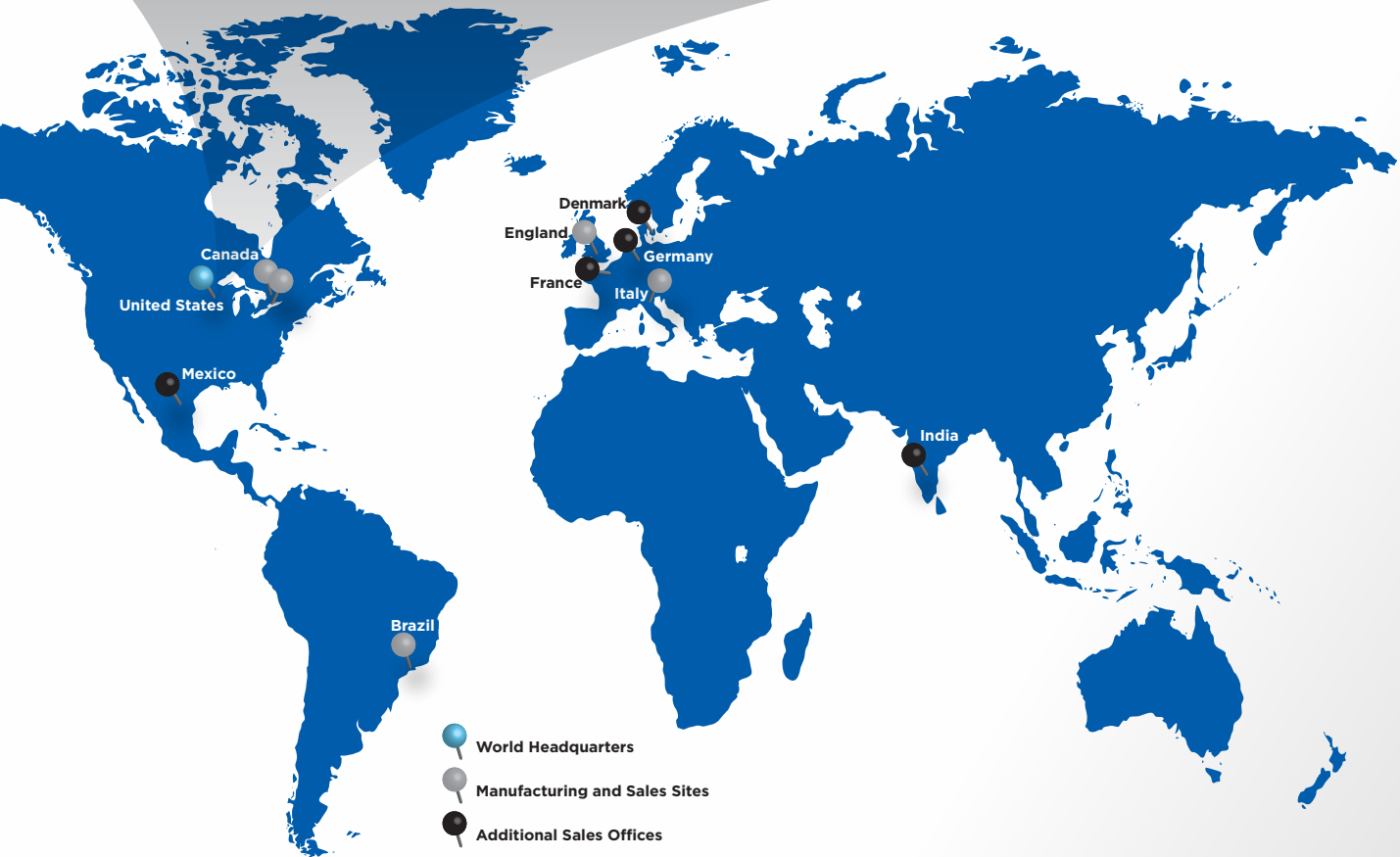
NOTE: The chart above is based on mild steel (tensile strength of 60,000 PSI) formed to an included angle of 88°. See chart to the right for other materials. Forming to other angles will change the Minimum Flange (MF), Inside Radius (IR) and tonnage.

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

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