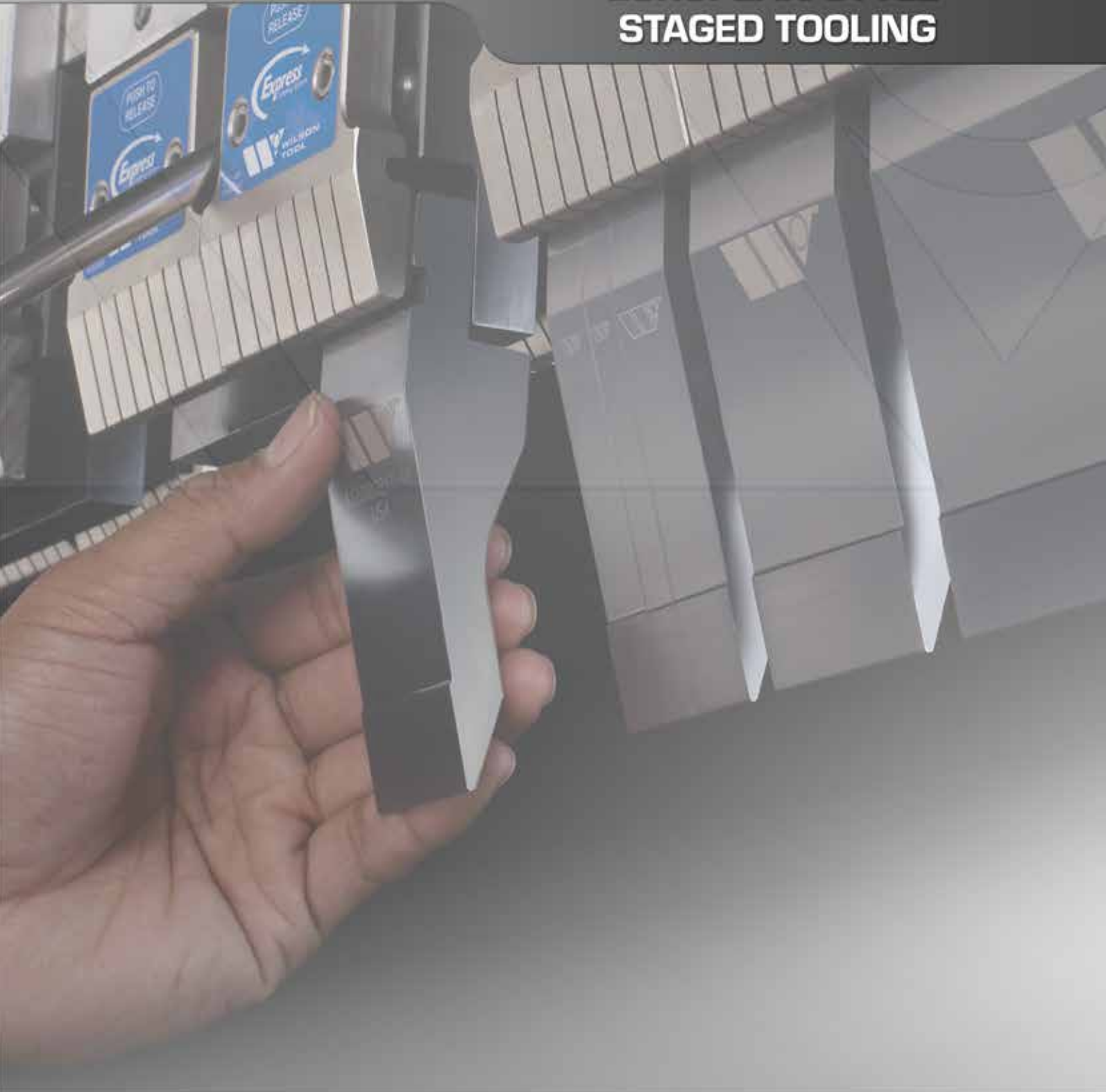


## EUROPEAN STYLE STAGED TOOLING



**SOLUTIONS FOR PRESS BRAKE TOOLING**

### Standard Common Shut Height.

Typically, completing multiple bends in a single press brake setup would require a skilled press brake operator to use special risers and shims to achieve a common shut height across all punches and dies. With the new staged bending tools for European Style press brakes, Wilson Tool provides an easier way to achieve common shut heights. Our staged bending tools have common shut heights built in, allowing machine operators to carry out a series of bends in one setup without the complicated preparation process. Thirty-degree, offset, flattening, gooseneck and other tools are set up progressively in one press brake without the fear of punches and dies colliding. See page 11 for more detail.



### The Strength is in the Steel.

Every Wilson European Style press brake tool is manufactured using only the hardest steels for increased strength and a longer tool life. We manufacture each and every press brake tool at our state-of-the-art manufacturing facility to ensure total quality control and quick delivery.

### Precision Ground for Less Scrap.

Wilson European Press Brake Tooling is precision ground to a tolerance of  $\pm .0008''$  (.02mm) on all critical dimensions for increased reliability. Common centerlines on all punches eliminate costly time spent locating the back gauge origin position and subsequent scrap.

### Nitrex™ Extends Tool Life.

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

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



<b>Staged Punches 90mm</b> . . . . .	4-5
Sash Puches - 411 Series	
Gooseneck Punches - 410 Series	
Thin Tip Gooseneck Punches - 413 Series	
Acute Punches - 412 Series	
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Goodseneck Punches - 400 Series	
Acute Punches - 402 Series	
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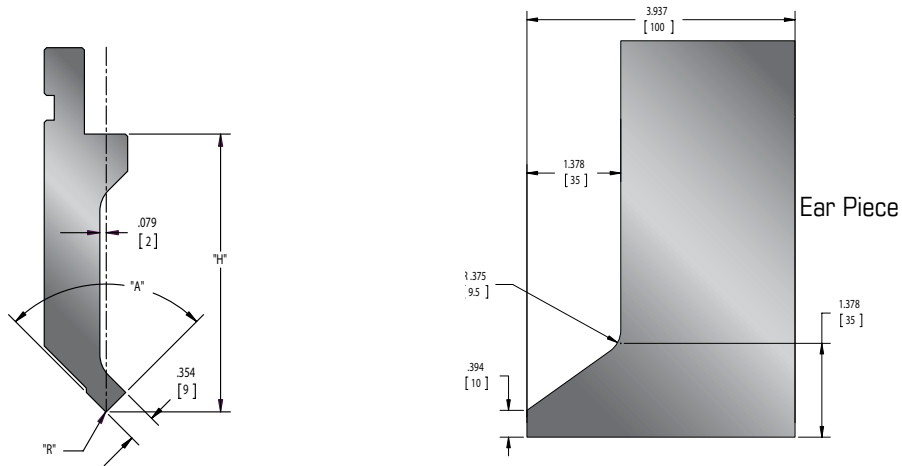
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## Terms and Conditions

<b>CREDIT REQUIREMENTS</b>	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.
<b>PAYMENT TERMS</b>	Terms are net 10 days. Catalog prices are subject to change without notice.
<b>FREIGHT</b>	Orders are shipped F.O.B. from our manufacturing facility. (International Shipments are Incoterms: Ex Works).
<b>ORDER CANCELLATION</b>	In the event an order is cancelled, an additional charge will be assessed to cover the cost of labor and material.
<b>RETURNED MATERIAL</b>	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.
<b>CLAIMS</b>	All claims or product shortages must be made within 30 days of the invoice date.

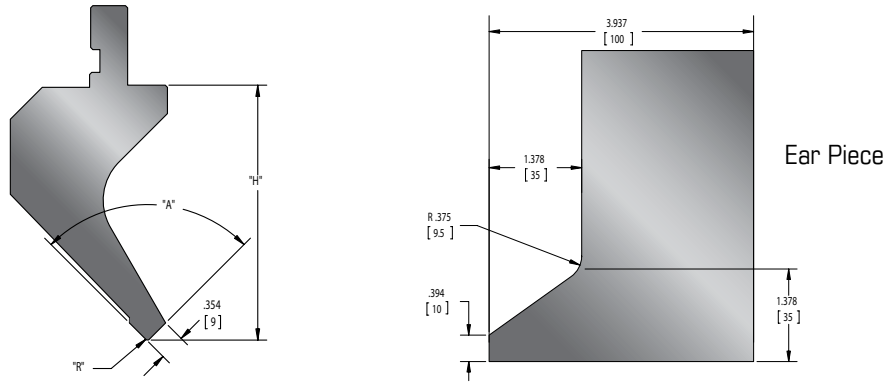
# STAGED PUNCHES

## 90MM



**SASH PUNCHES - 411 SERIES**

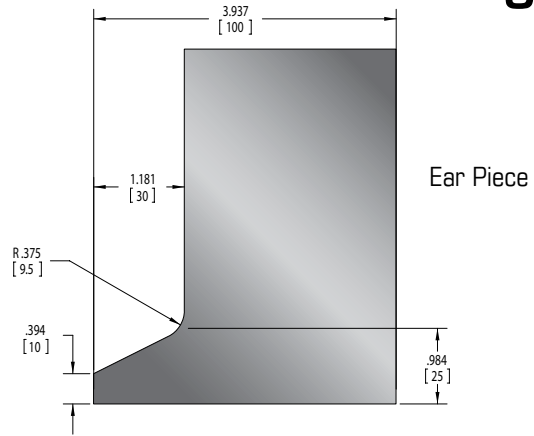
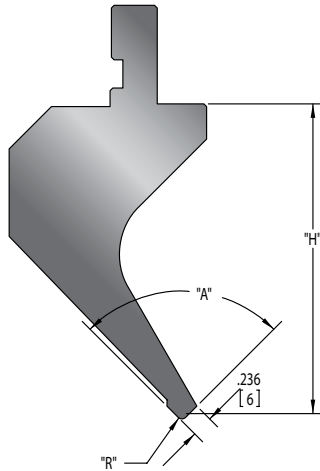
CAT. NO.	R TIP RADIUS INCH [MM]	A ANGLE	H HEIGHT INCH [MM]	LT & ST MAX TON FEET [METER]	XT MAX TON FEET [METER]	LT 32.87 [835MM]	ST 16.34 [415MM]	XT SECTIONALIZED
41190002	.008 [0.2]	90°	3.540 [89.9]	30 [100]	12 [40]			
41190008	.030 [0.8]	90°	3.530 [89.7]	30 [100]	12 [40]			
411c	.060 [1.5]	90°	3.519 [89.4]	30 [100]	12 [40]			
	.090 [2.3]	90°	3.506 [89.0]	30 [100]	12 [40]			
	.120 [3.0]	90°	3.494 [88.8]	30 [100]	12 [40]			
41188002	.008 [0.2]	88°	3.540 [89.9]	30 [100]	12 [40]			
41188008	.030 [0.8]	88°	3.529 [89.6]	30 [100]	12 [40]			
411c	.060 [1.5]	88°	3.517 [89.3]	30 [100]	12 [40]			
	.090 [2.3]	88°	3.504 [89.0]	30 [100]	12 [40]			
	.120 [3.0]	88°	3.491 [88.7]	30 [100]	12 [40]			



**GOOSENECK PUNCHES - 410 SERIES**

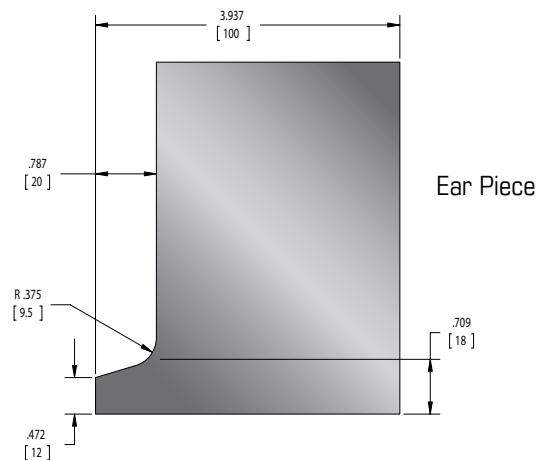
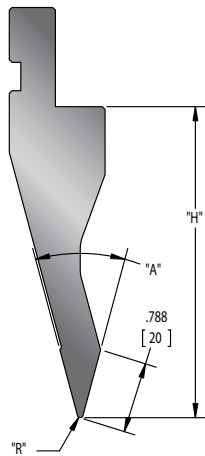
CAT. NO.	R TIP RADIUS INCH [MM]	A ANGLE	H HEIGHT INCH [MM]	LT & ST MAX TON FEET [METER]	XT MAX TON FEET [METER]	LT 32.87 [835MM]	ST 16.34 [415MM]	XT SECTIONALIZED
41090002	.008 [0.2]	90°	3.540 [89.9]	21 [70]	14 [47]			
41090008	.030 [0.8]	90°	3.530 [89.7]	21 [70]	14 [47]			
41090015	.060 [1.5]	90°	3.519 [89.4]	21 [70]	14 [47]			
410c	.090 [2.3]	90°	3.506 [89.0]	21 [70]	14 [47]			
	.120 [3.0]	90°	3.494 [88.8]	21 [70]	14 [47]			
40602	.008 [0.2]	88°	3.540 [89.9]	21 [70]	14 [47]			
40608	.030 [0.8]	88°	3.529 [89.6]	21 [70]	14 [47]			
40615	.060 [1.5]	88°	3.517 [89.3]	21 [70]	14 [47]			
410c	.090 [2.3]	88°	3.504 [89.0]	21 [70]	14 [47]			
40630	.120 [3.0]	88°	3.491 [88.7]	21 [70]	14 [47]			

## 90MM



### THIN TIP GOOSENECK PUNCHES - 413 SERIES

CAT. NO	R TIP RADIUS INCH [MM]	A ANGLE	H HEIGHT INCH [MM]	LT & ST MAX TON FEET [METER]	XT MAX TON FEET [METER]	LT 32.87 [835MM]	ST 16.34 [415MM]	XT SECTIONALIZED
40712	.008 [0.2]	90°	3.540 [89.9]	15 [50]	9 [30]			
40718	.030 [0.8]	90°	3.530 [89.7]	15 [50]	9 [30]			
413c	.060 [1.5]	90°	3.519 [89.4]	15 [50]	9 [30]			
	.090 [2.3]	90°	3.506 [89.0]	15 [50]	9 [30]			
413c	.120 [3.0]	90°	3.494 [88.8]	15 [50]	9 [30]			
	.090 [2.3]	88°	3.540 [89.9]	15 [50]	9 [30]			
40702	.030 [0.8]	88°	3.529 [89.6]	15 [50]	9 [30]			
40708	.090 [2.3]	88°	3.504 [89.0]	15 [50]	9 [30]			
413c	.120 [3.0]	88°	3.491 [88.7]	15 [50]	9 [30]			

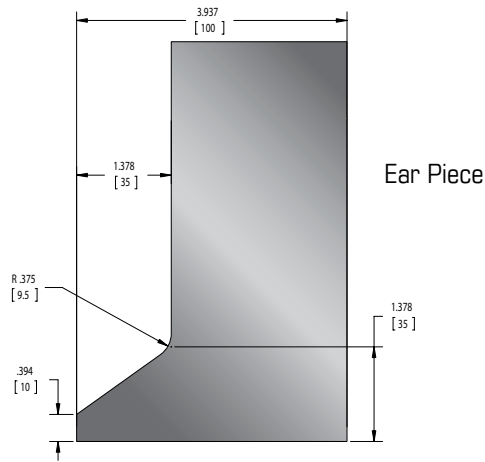
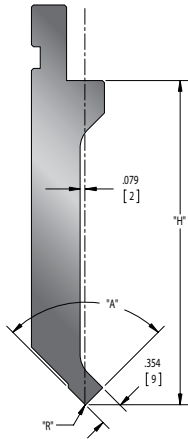


### ACUTE PUNCHES - 412 SERIES

CAT. NO	R TIP RADIUS INCH [MM]	A ANGLE	H HEIGHT INCH [MM]	LT & ST MAX TON FEET [METER]	XT MAX TON FEET [METER]	LT 32.87 [835MM]	ST 16.34 [415MM]	XT SECTIONALIZED
41230008	.030 [0.8]	30°	3.453 [87.7]	30 [100]	6 [20]			

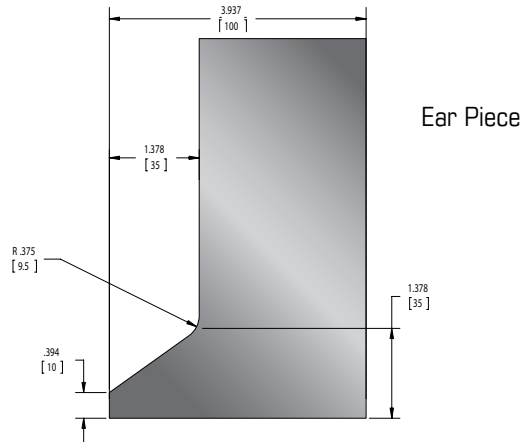
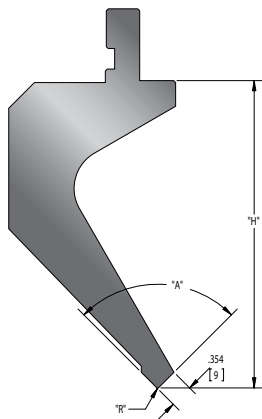
# STAGED PUNCHES

## 120MM



### SASH PUNCHES - 401 SERIES

CAT. NO	R TIP RADIUS INCH [MM]	A ANGLE	H HEIGHT INCH [MM]	MAX TON		LT 32.87 [835MM]	ST 16.34 [415MM]	XT SECTIONALIZED
				LT & ST FEET [METER]	XT FEET [METER]			
401c	.008 [0.2]	90°	4.721 [119.9]	30 [100]	12 [40]			
	.030 [0.8]	90°	4.711 [119.7]	30 [100]	12 [40]			
	.060 [1.5]	90°	4.700 [119.4]	30 [100]	12 [40]			
	.090 [2.3]	90°	4.687 [119.0]	30 [100]	12 [40]			
	.120 [3.0]	90°	4.675 [118.8]	30 [100]	12 [40]			
	.008 [0.2]	88°	4.721 [119.9]	30 [100]	12 [40]			
	.030 [0.8]	88°	4.711 [119.6]	30 [100]	12 [40]			
	.060 [1.5]	88°	4.698 [119.3]	30 [100]	12 [40]			
	.090 [2.3]	88°	4.685 [119.0]	30 [100]	12 [40]			
	.120 [3.0]	88°	4.672 [118.7]	30 [100]	12 [40]			

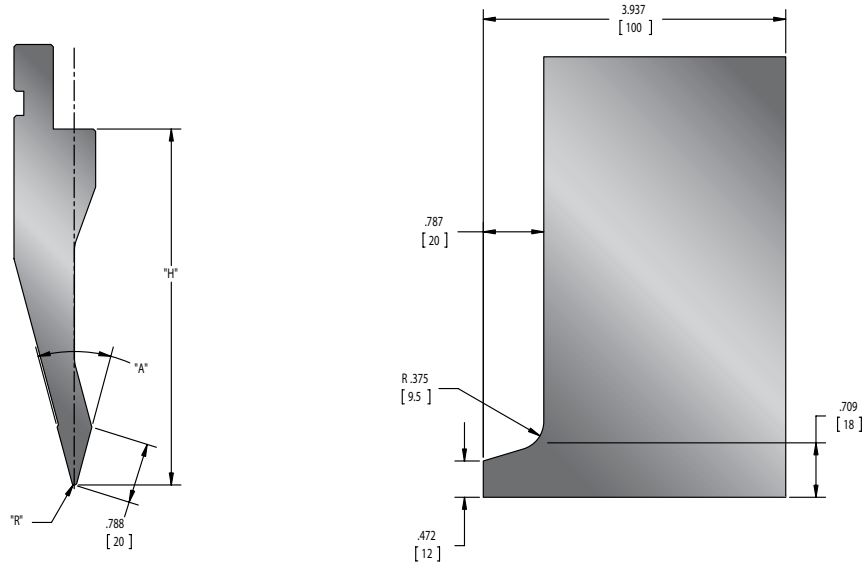


### GOOSENECK PUNCHES - 400 SERIES

CAT. NO	R TIP RADIUS INCH [MM]	A ANGLE	H HEIGHT INCH [MM]	MAX TON		LT 32.87 [835MM]	ST 16.34 [415MM]	XT SECTIONALIZED
				LT & ST FEET [METER]	XT FEET [METER]			
400c	.008 [0.2]	90°	4.721 [119.9]	15 [50]	9 [30]			
	.030 [0.8]	90°	4.711 [119.7]	15 [50]	9 [30]			
	.060 [1.5]	90°	4.700 [119.4]	15 [50]	9 [30]			
	.090 [2.3]	90°	4.687 [119.0]	15 [50]	9 [30]			
	.120 [3.0]	90°	4.675 [118.8]	15 [50]	9 [30]			
40302	.008 [0.2]	88°	4.721 [119.9]	15 [50]	9 [30]			
40308	.030 [0.8]	88°	4.711 [119.6]	15 [50]	9 [30]			
400c	.060 [1.5]	88°	4.698 [119.3]	15 [50]	9 [30]			
	.090 [2.3]	88°	4.685 [119.0]	15 [50]	9 [30]			
	.120 [3.0]	88°	4.672 [118.7]	15 [50]	9 [30]			



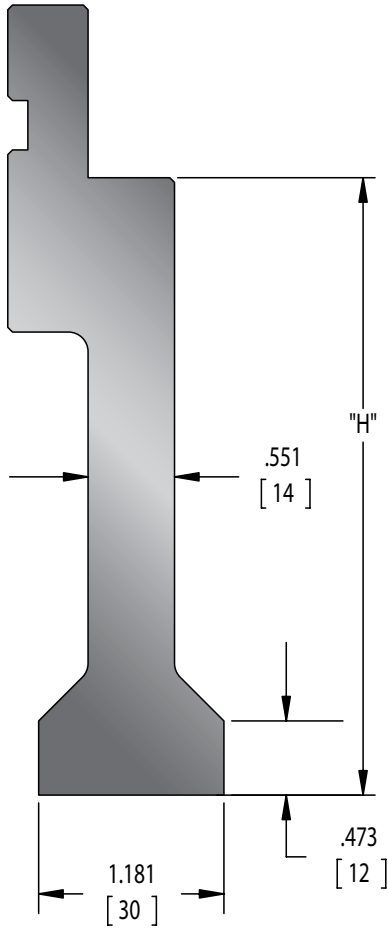
**U.S.A.** Tel: 800.445.4518 | Fax: 800.539.4590 | [pressbrake@wilsontool.com](mailto:pressbrake@wilsontool.com)  
**Canada** Tel: 800.268.4180 | Fax: 905.840.1032 | [bending@wilsontoolcanada.com](mailto:bending@wilsontoolcanada.com)  
**Mexico** Tel: 001.800.741.2510 | Fax: 001.800.544.2096 | [americalatina@wilsontool.com](mailto:americalatina@wilsontool.com)



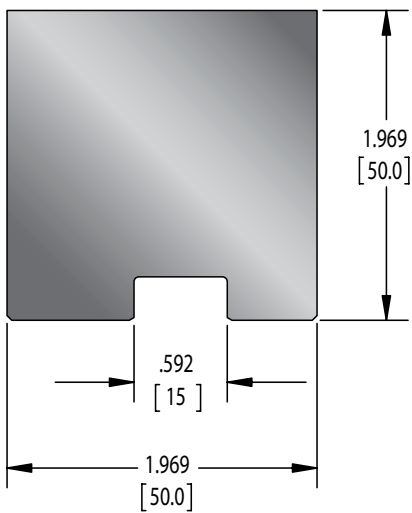
### ACUTE PUNCHES - 402 SERIES

CAT. NO	R TIP RADIUS INCH [MM]	A ANGLE	H HEIGHT INCH [MM]	LT & ST MAX TON FEET [METER]	XT MAX TON FEET [METER]	LT 32.87 [835MM]	ST 16.34 [415MM]	XT SECTIONALIZED
402c	.030 [0.8]	30°	4.634 [117.7]	30 [100]	6 [20]			

# STAGED FLATTENING PUNCH & DIE



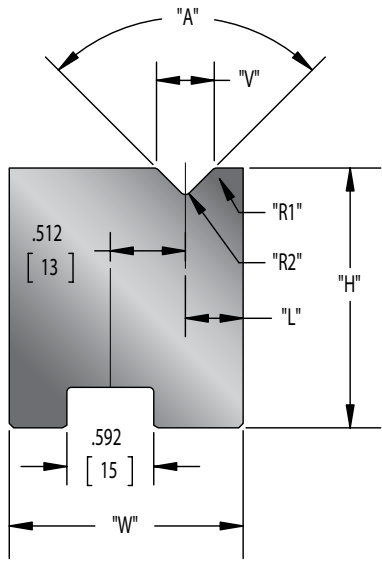
FLATTENING PUNCH						
CAT. NO	STAGING FAMILY	H HEIGHT INCH [MM]	MAX TON FEET [METER]	LT 32.87 [835MM]	ST 16.34 [415MM]	XT SECTIONALIZED
41400000	90mm	3.150 [80.0]	30 [100]			
40400001	120mm	3.937 [110.0]	30 [100]			



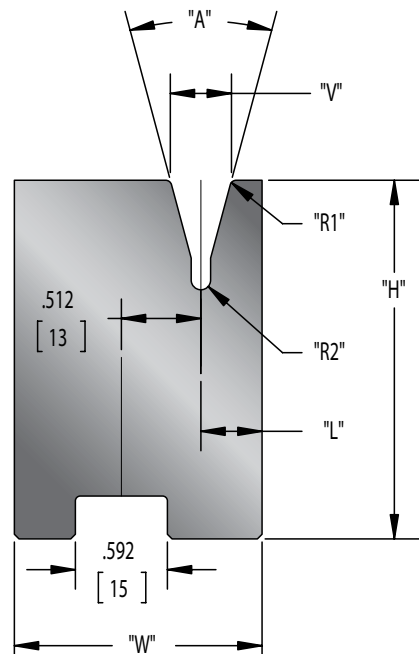
FLATTENING DIE				
CAT. NO	MAX TON FEET [METER]	LT 32.87 [835MM]	ST 16.34 [415MM]	XT SECTIONALIZED
42312	30 [100]			



## 88° & 90°



## 30°



QC STAGED 88° & 90° DIES

CAT. NO	V V OPENING INCH [MM]	A ANGLE	R1 SH. RADIUS INCH [MM]	R2 V RADIUS INCH [MM]	L OPENING INCH [MM]	W WIDTH INCH [MM]	H HEIGHT INCH [MM]	MAX TONS FEET [METER]	LT 32.87 [835MM]	ST 16.34 [415MM]	XT SECTIONALIZED
45090006	.236 [6.0]	90°	.024 [0.6]	.008 [0.2]	.394 [10.0]	1.594 [40.5]	1.693 [43.0]	30 [100]			
45090008	.315 [8.0]	90°	.031 [0.8]	.008 [0.2]	.394 [10.0]	1.594 [40.5]	1.732 [44.0]	30 [100]			
45090010	.394 [10.0]	90°	.039 [1.0]	.008 [0.2]	.394 [10.0]	1.594 [40.5]	1.772 [45.0]	30 [100]			
45090012	.472 [12.0]	90°	.039 [1.0]	.008 [0.2]	.492 [12.5]	1.693 [43.0]	1.811 [46.0]	30 [100]			
45088006	.236 [6.0]	88°	.024 [0.6]	.008 [0.2]	.394 [10.0]	1.594 [40.5]	1.697 [43.1]	30 [100]			
45088008	.315 [8.0]	88°	.031 [0.8]	.008 [0.2]	.394 [10.0]	1.594 [40.5]	1.738 [44.1]	30 [100]			
45088010	.394 [10.0]	88°	.039 [1.0]	.008 [0.2]	.394 [10.0]	1.594 [40.5]	1.779 [45.2]	30 [100]			
45088012	.472 [12.0]	88°	.039 [1.0]	.008 [0.2]	.394 [10.0]	1.693 [43.0]	1.819 [46.2]	30 [100]			
45088016	.630 [16.0]	88°	.059 [1.5]	.008 [0.2]	.492 [12.5]	1.791 [45.5]	1.901 [48.3]	30 [100]			
45088020	.787 [20.0]	88°	.079 [2.0]	.008 [0.2]	.591 [15.0]	1.791 [45.5]	1.983 [50.4]	30 [100]			
45088024	.945 [24.0]	88°	.098 [2.5]	.008 [0.2]	.689 [17.5]	1.890 [48.0]	2.064 [52.4]	30 [100]			
45088030	1.181 [30.0]	88°	.118 [3.0]	.008 [0.2]	.886 [22.5]	2.087 [53.0]	2.186 [55.5]	30 [100]			

QC STAGED 30° DIES

CAT. NO	V V OPENING INCH [MM]	A ANGLE	R1 SH. RADIUS INCH [MM]	R2 V RADIUS INCH [MM]	L OPENING INCH [MM]	W WIDTH INCH [MM]	H HEIGHT INCH [MM]	MAX TONS FEET [METER]	LT 32.87 [835MM]	ST 16.34 [415MM]	XT SECTIONALIZED
45030006	.236 [6.0]	30°	.024 [0.6]	.063 [1.6]	.394 [10.0]	1.594 [40.5]	2.016 [51.2]	30 [100]			
45030008	.315 [8.0]	30°	.039 [1.0]	.063 [1.6]	.394 [10.0]	1.594 [40.5]	2.163 [54.9]	30 [100]			
45030010	.394 [10.0]	30°	.039 [1.0]	.063 [1.6]	.394 [10.0]	1.594 [40.5]	2.310 [58.7]	23 [77]			
45030012	.472 [12.0]	30°	.039 [1.0]	.063 [1.6]	.492 [12.5]	1.693 [43.0]	2.456 [62.4]	20 [67]			
45030016	.630 [16.0]	30°	.063 [1.6]	.094 [2.4]	.591 [15.0]	1.791 [45.5]	2.750 [69.9]	18 [60]			
45030020	.787 [20.0]	30°	.079 [2.0]	.094 [2.4]	.689 [17.5]	1.890 [48.0]	3.044 [77.3]	15 [50]			
45030024	.945 [24.0]	30°	.098 [2.5]	.094 [2.4]	.787 [20.0]	1.988 [50.5]	3.338 [84.8]	15 [50]			

# WILSON EXPRESS CLAMPING SYSTEM™



Conventional Press Brakes With Wedge		PRICE
43815-2	2 Front Clamp Plates	
43815	2 Front & 2 Back Clamp Plates	



Z1 Series With Wedge		PRICE
43817I-2	2 Front Clamp Plates	
43817I	2 Front & 2 Back Clamp Plates	



Z2 Series With Wedge		PRICE
43818I-2	2 Front Clamp Plates	
43818I	2 Front & 2 Back Clamp Plates	



Trumpf Press Brakes With Wedge		PRICE
43819-2	2 Front Clamp Plates	
43819	2 Front & 2 Back Clamp Plates	

## EXPRESS CLAMP TORQUE WRENCH KIT

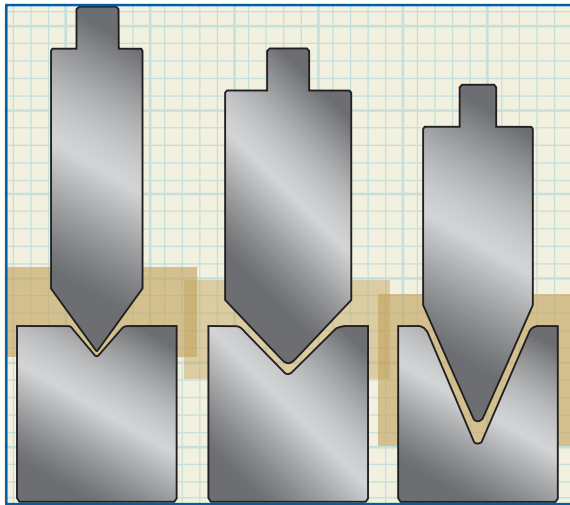


CAT. No.	COMPONENT	PRICE
8002	Complete Kit	

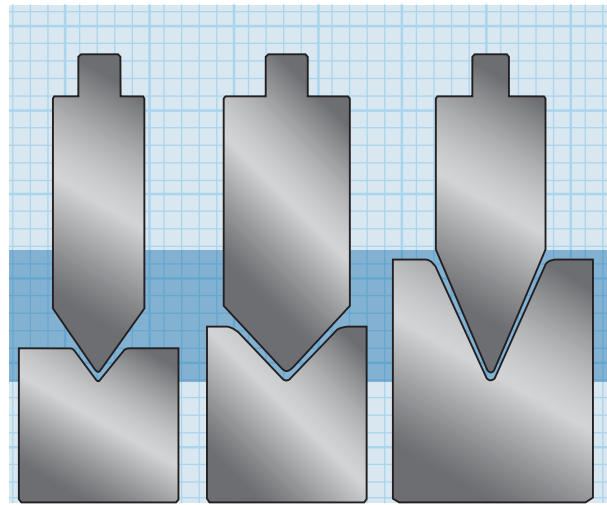
Kit includes: Case, 2 Pivots, Wrench & 2 Hex Tips

CAT. No.	COMPONENT	PRICE
8003	Case	
43726	Pivot	
6793	Wrench	
6795	Hex Tip	

# STAGE BENDING



**TRADITIONAL NON-STAGE BENDING**  
3 Different Shut Heights



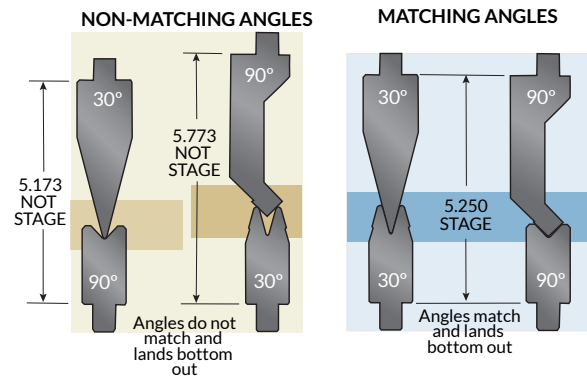
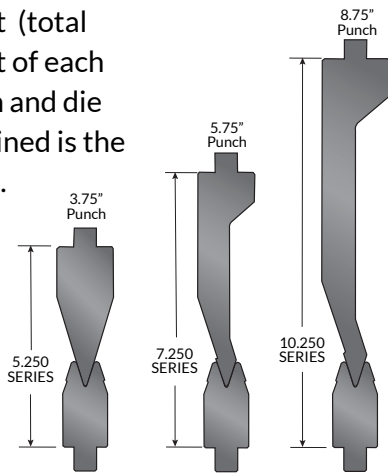
**STAGE BENDING**  
1 Common Shut Height

## WHAT IS STAGE BENDING?

In a press brake, stage bending is the process of developing multiple tooling setups that have a common shut height or 'Stage Bending'. This enables press brake operators to carry out multiple bends with a single setup. Groups of tools are set up progressively along the press brake, then all bends on a single part are performed in succession.

To successfully accomplish stage tooling, each tool in a set must share:

A common shut height (total height of each punch and die combined is the same).



See this tool in action on the [Wilson Tool YouTube Channel](#)

Stage bending simplifies complex jobs by eliminating unproductive repetitive tasks - significantly reducing setup time, part handling and work-in-progress.

# WILSON TOOL INTERNATIONAL

## WORLD HEADQUARTERS

### Wilson Tool International - United States

Tel (Free): 800-445-4518  
Fax (Free): 800-539-4590  
Email: [pressbrake@wilsonstool.com](mailto:pressbrake@wilsonstool.com)

## NORTH AMERICA

### Wilson Tool - Canada

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Tel: 800-268-5573 | Fax: 800-668-9314  
Email: [punching@wilsonstoolcanada.com](mailto:punching@wilsonstoolcanada.com)

### Wilson Tool - Canada

Press Brake Division  
Tel: 800-268-4180 | Fax: 905-840-1032  
Email: [bending@wilsonstoolcanada.com](mailto:bending@wilsonstoolcanada.com)

### Wilson Tool - Mexico

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Email: [americalatina@wilsonstool.com](mailto:americalatina@wilsonstool.com)

## SOUTH AMERICA

### Wilson Tool - Argentina

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Email: [ventassudamerica@wilsonstool.com](mailto:ventassudamerica@wilsonstool.com)

### Milling Ferramentas - Brazil

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Fax (Free): 0800-373758 | Fax: +44 1793 831945 or 46  
Email: [sales@wilsonstool.eu.com](mailto:sales@wilsonstool.eu.com)

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Email: [verkauf@wilsonstool.eu.com](mailto:verkauf@wilsonstool.eu.com)

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