



THICK TURRET SPECIAL TOOLING

Innovation by
Design.

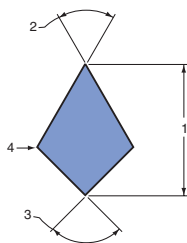


Strength. Performance. Innovation.

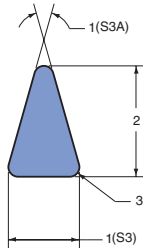


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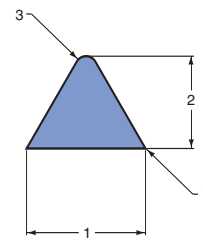
Note: Special Considerations May Alter Price and Lead Time



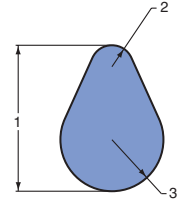
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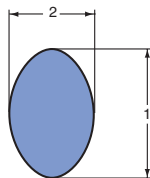
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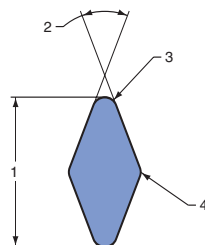
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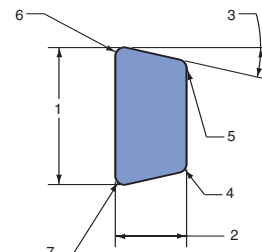
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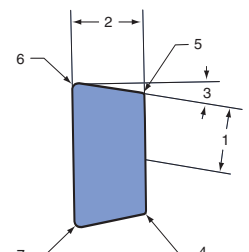
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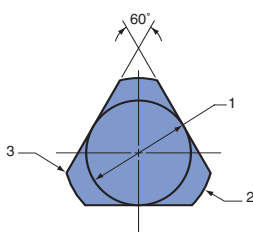
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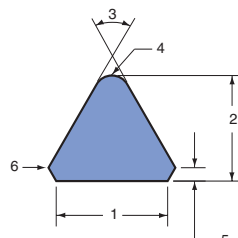
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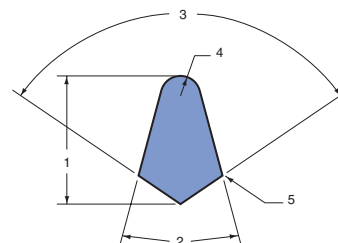
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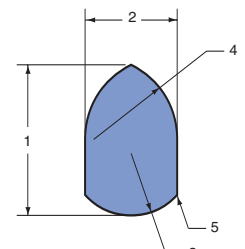
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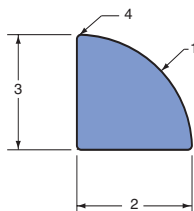
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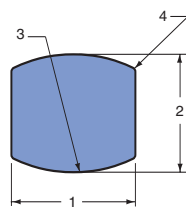
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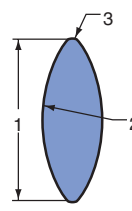
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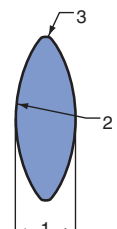
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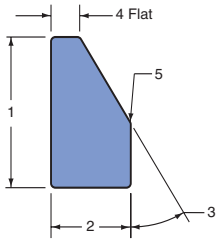


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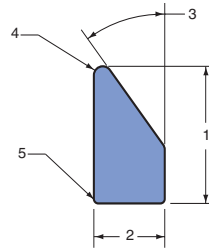


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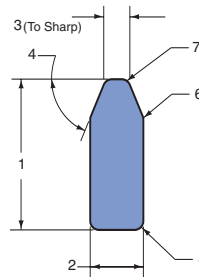
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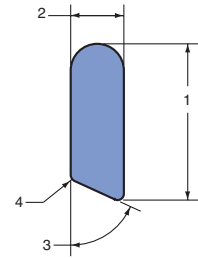
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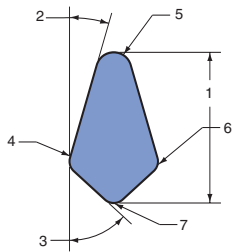
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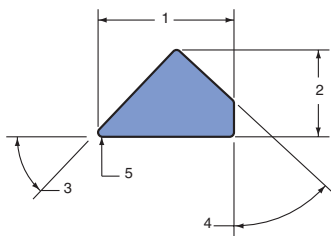
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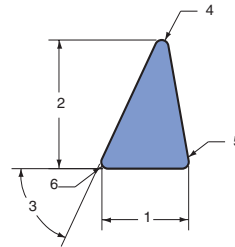
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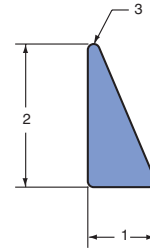
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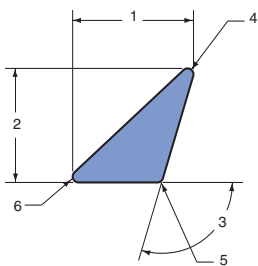
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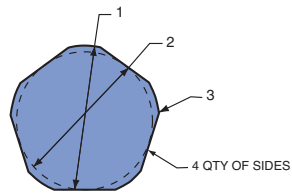
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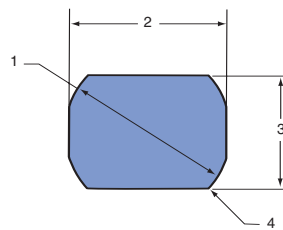
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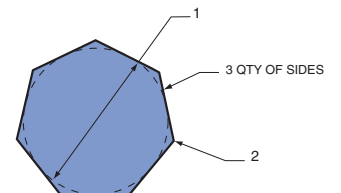
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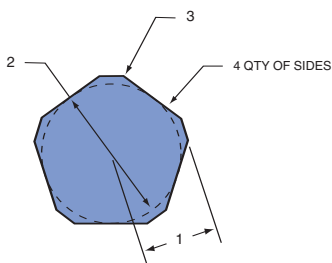
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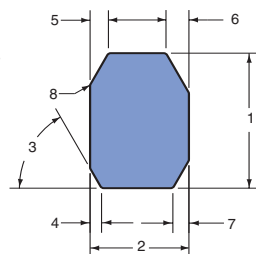
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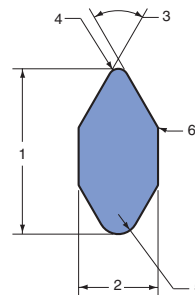
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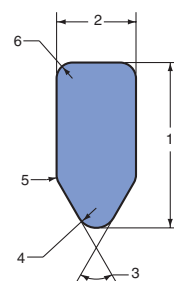
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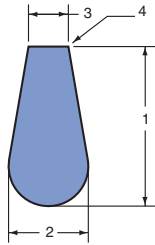
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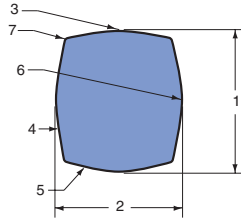
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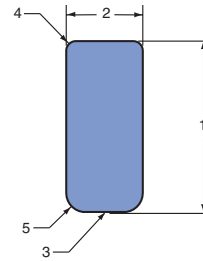
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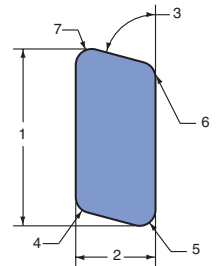
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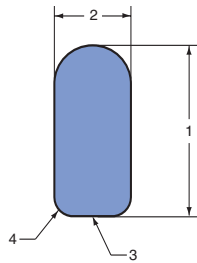
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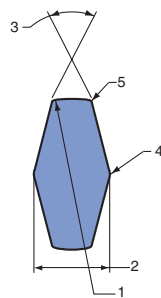
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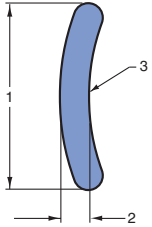
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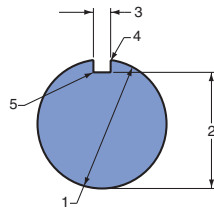
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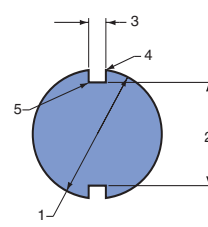
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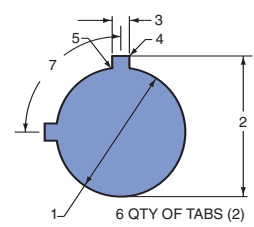
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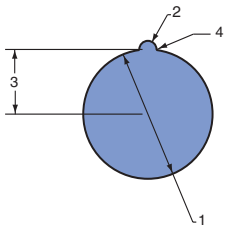
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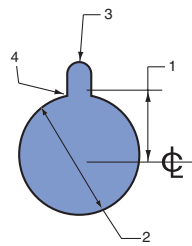
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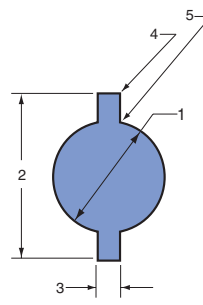
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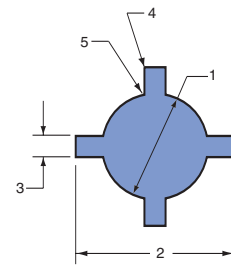
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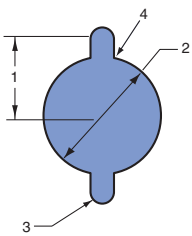
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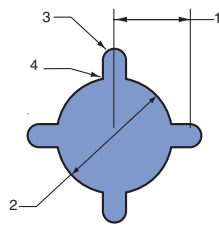
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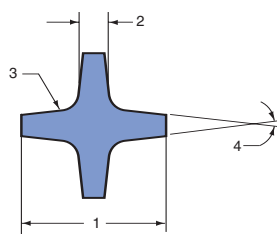
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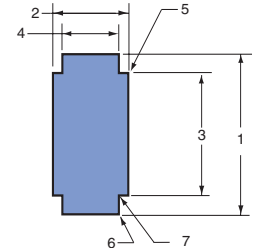
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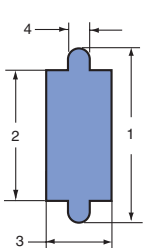
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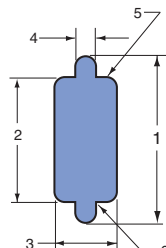
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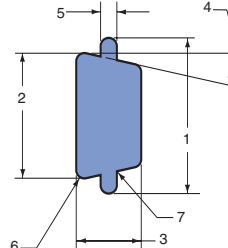
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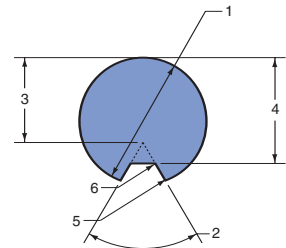
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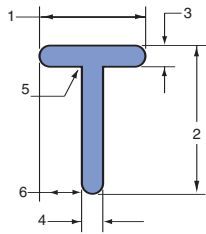
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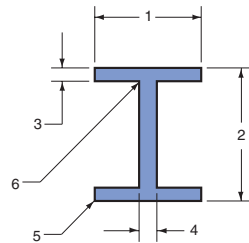
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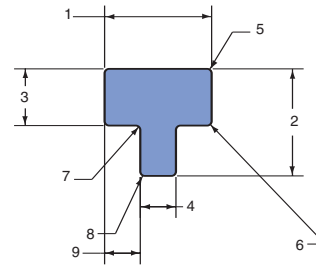
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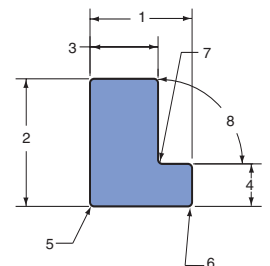
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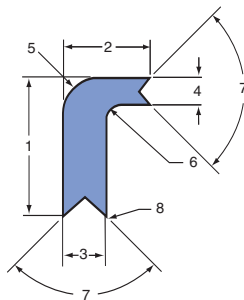
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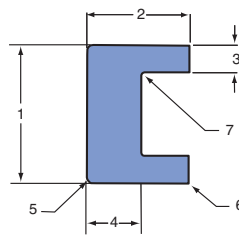
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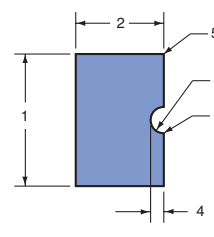
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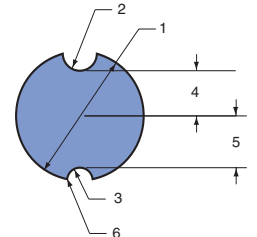
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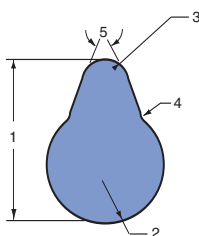
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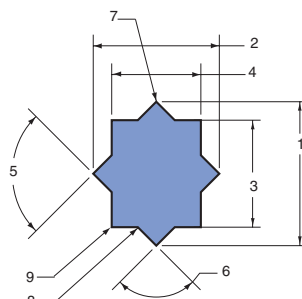
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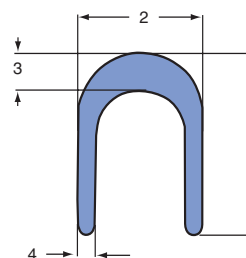
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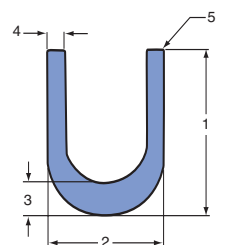
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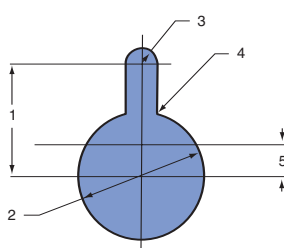
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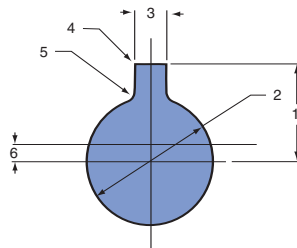
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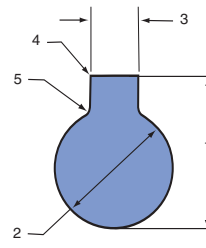
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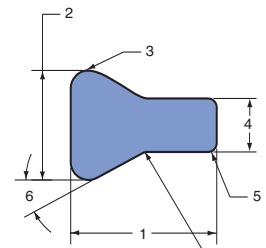
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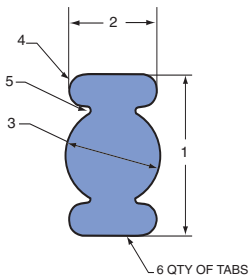
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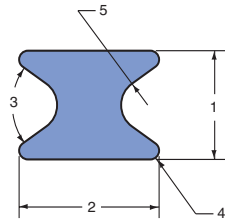
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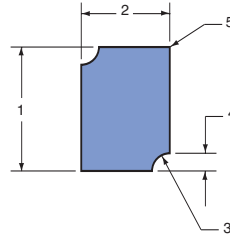
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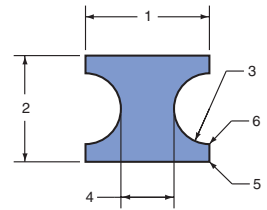
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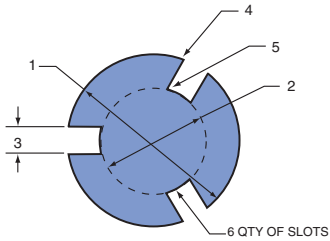
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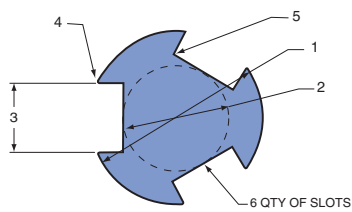
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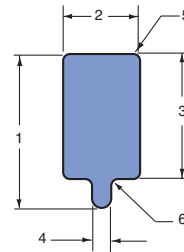
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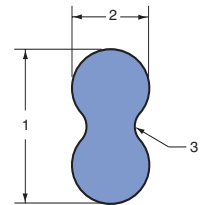
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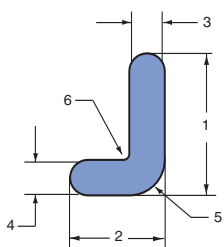
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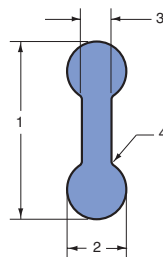
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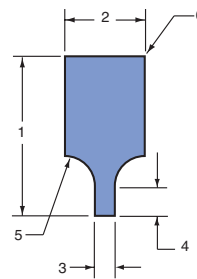
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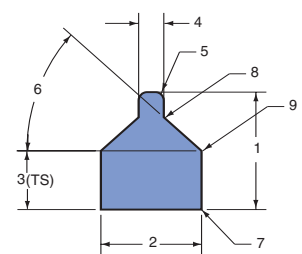
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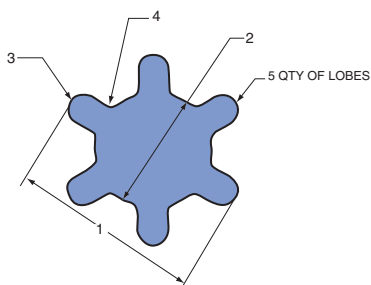
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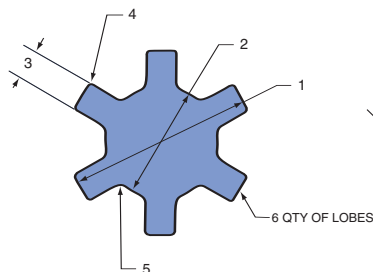
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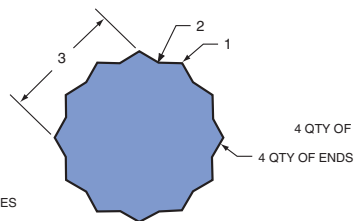
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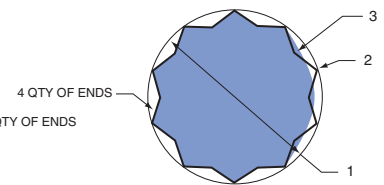
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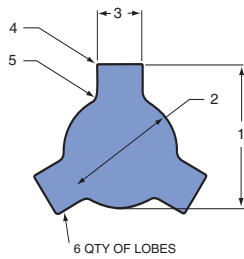
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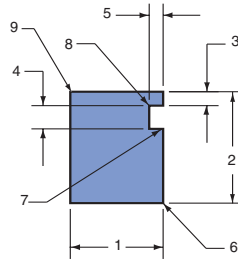
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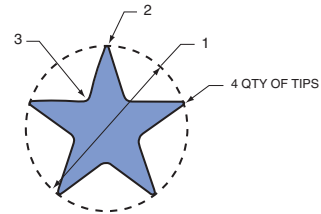
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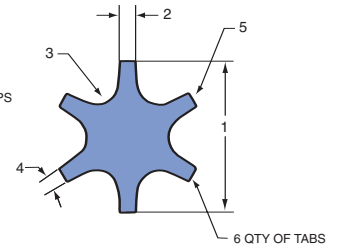
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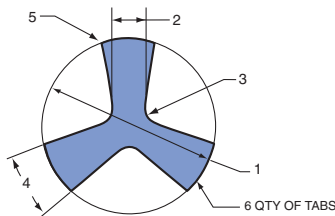
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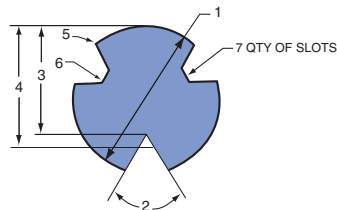
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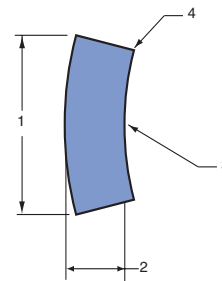
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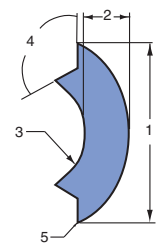
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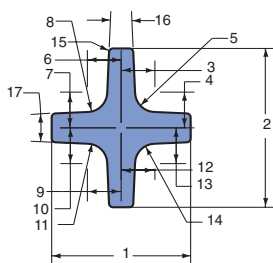
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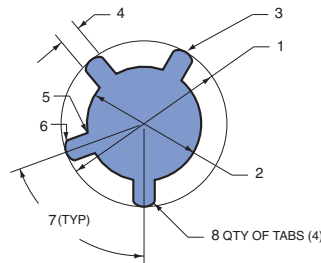
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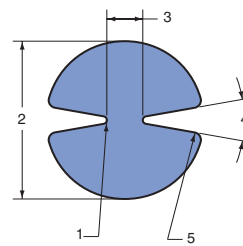
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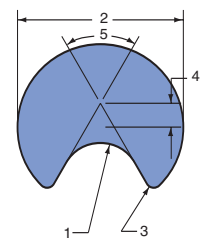
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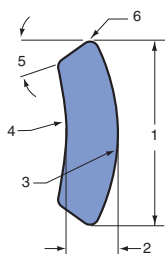
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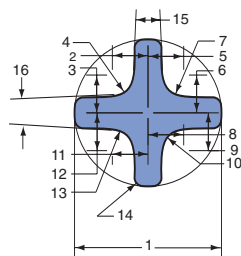
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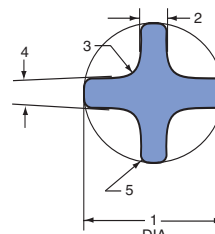
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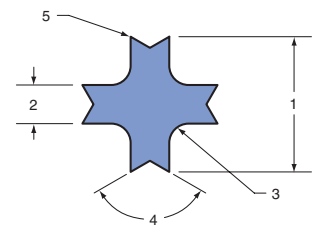
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S176

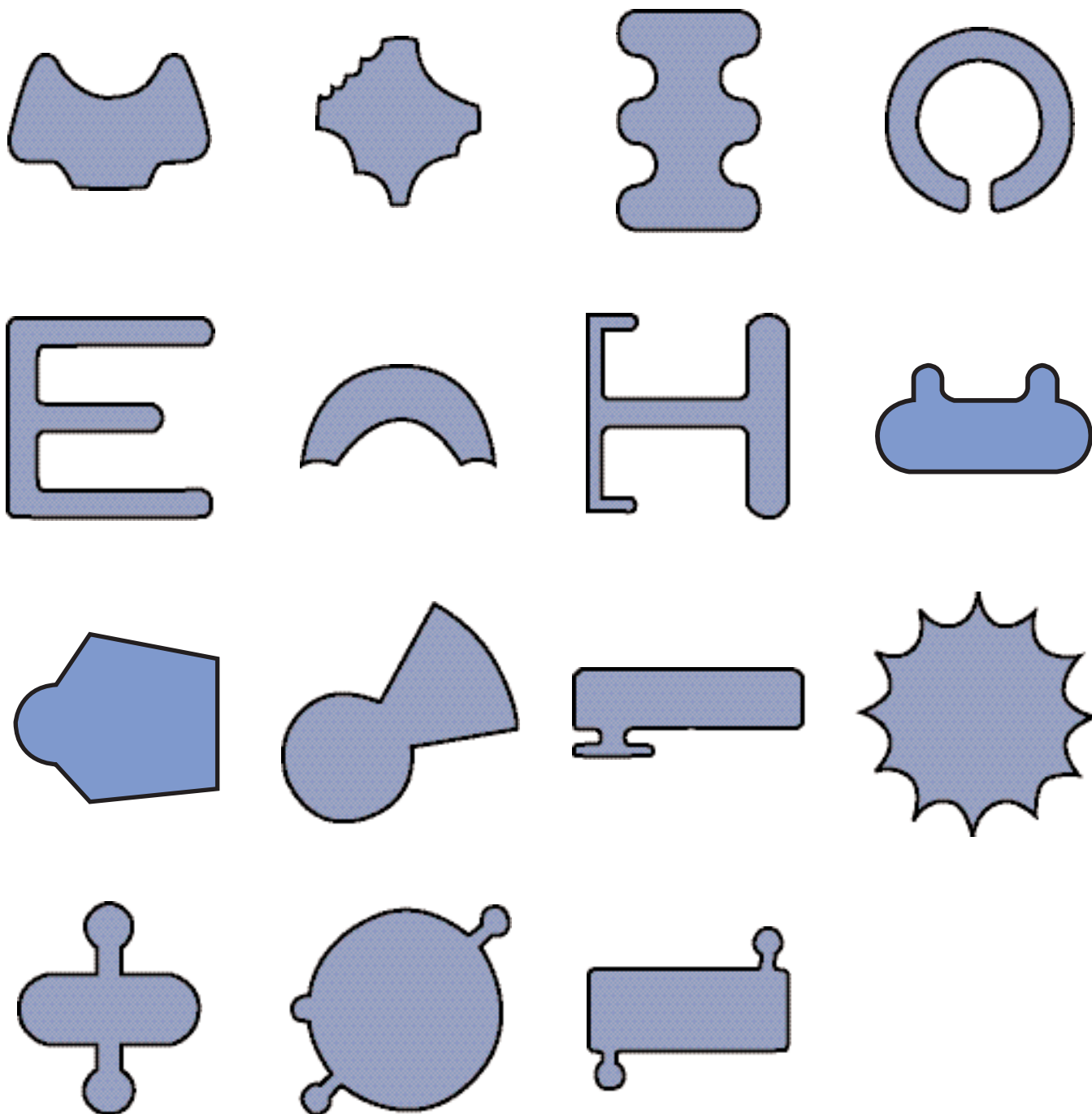


S177



S179

GROUP "C"





THICK TURRET



Shown with optional E-Z set™ punch head.



BENEFITS

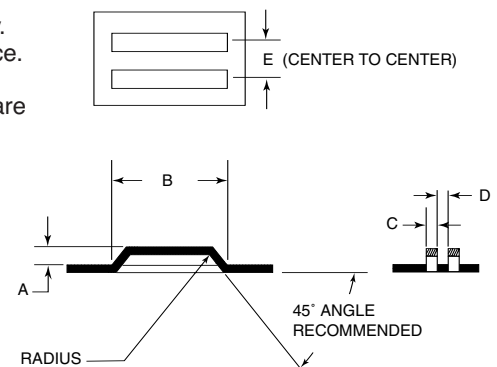
- The Bridge Type Lance and Form can be used for:
 - Shear stops
 - Card guides
 - Locators
 - Dividers
 - Ventilation
 - Wire tie downs
- When the Bridge Type Lance and Form is used as a shear stop, its higher form makes it easier to pick up gauging.
- The Wilson design gives a positive form, which ensures a high quality part.
- Tools can be designed for form-down operations upon request.
- Optional lead-in available on Double Bridge. Consult sales desk for pricing.
- Holder assembly design provides cost saving replaceable punch tip and ejector.
- E-Z set™ punch head is recommended for fast and easy adjustments (No shims needed). See E-Z set™ punch head page for further details.

CONSIDERATIONS

- Bridge Lance and Forms are made for one specific material thickness. Thinner material may be used, but the form will change. Never punch material thicker than what the tool was designed for.
- Bridge width should be 1.5 times the material thickness in mild steel and aluminium and 2 times the material thickness in stainless steel to warranty.
- Widths less than 1.78mm will alter price. Consult sales desk.
- Form-down Bridge Lance and Forms are not recommended in N.C. machines.

INFORMATION NEEDED

- Machine model
- Material thickness and type
- Length, width, height and center to center
- Drawing of pattern for relief
- Top, side and end views



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THICK TURRET



BENEFITS

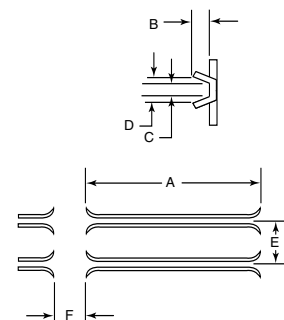
- This unique universal holder design offers fast and easy length adjustments with the spring loaded adjusting plunger.
- The form is internally stripped for best results.
- Lower costs with replaceable inserts that can be converted to different size Card Guides.
- To change Card Guide size, only the punch tip, ejectors and die assembly are required.
- Wilson Tool will estimate the web of material to be formed on all Card Guides.
- Special lead-ins available. Consult the sales desk for pricing.
- Wilson Tool can develop the prepunch shape and size on special Card Guides at an additional charge. Consult the sales desk for pricing.
- Tooling is WLS ready, minimizing wear and maintenance.

CONSIDERATIONS

- Form heights of less than two times the material thickness are not recommended because the web may twist (one side will form higher than the other).
- For proper design, closest center-to-center and narrowest pre-punch are required.
- Special applications may affect pricing.

INFORMATION NEEDED

- Machine model
- Material thickness and type
- Drawing of card guide desired, center-to-center location and narrowest pre-punch
- Pre-punch shape: Rectangle, obround, or rectangle with radius corners
- Length of prepunch if material is less than 1.27mm

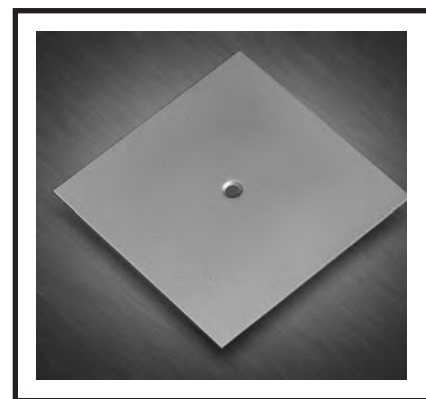




THICK TURRET



Shown with optional E-Z set™ punch head.



BENEFITS

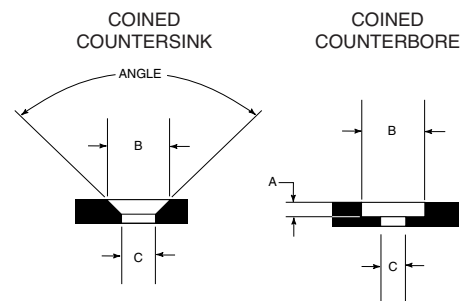
- Coining operations on the punch press eliminate the costly and time consuming secondary operation of drilling countersinks.
- The interchangeable tip design allows you to change the size of your coin easily and inexpensively.
- The replaceable insert design also lowers tooling costs and inventory.
- In many cases, you can pierce and coin in one hit. However, a pre-punched hole will help reduce the burr for a cleaner looking part.
- General guidelines for prepunching material (before coining):
 - Aluminium—3.17mm thick or greater
 - Mild steel—2.28mm thick or greater
 - Stainless steel—1.52mm thick or greater
- E-Z set™ punch head is recommended for fast and easy length adjustments (no shims needed).
See E-Z set™ punch head page for further details.

CONSIDERATIONS

- A pre-punched hole is necessary on all form-up coins and strongly recommended on form-down counterbores.
- Consult the sales desk for size and tonnage restrictions.
- Special applications may affect pricing.

INFORMATION NEEDED

- Machine model
- Material thickness and type
- Angle, coin diameter, thru-hole
- With or without pilot



Estimated pre-punch formula:
 $B - [(B - C) \times .75] = \text{Pre-punch}$

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THICK TURRET



BENEFITS

- The most cost effective method to manufacture perforations or other repetitive applications.
- Saves on machine punching time and tool maintenance time.
- The best choice when punching a pattern of holes that require extremely close center to center tolerances.
- Different design styles are available to suit your specific cost and manufacturing needs.
- The replaceable insert design (Style B) provides additional cost savings with a replaceable punch tip.
- Finished parts produced with each hit when your cluster tool is made to progressively pierce and blank, or pierce, form and blank.
- Optima™ coating is available for extending tool life on widths or diameters exceeding 2.5 mm.
- Slug Huggers® are available for most applications.

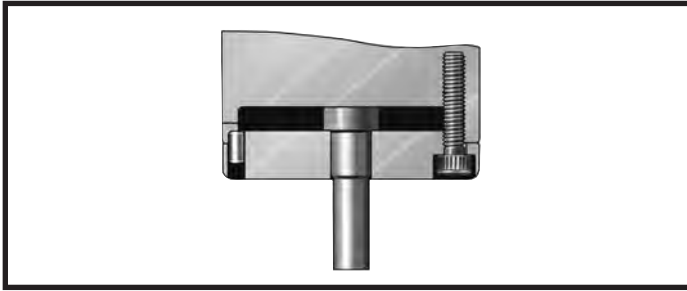
CONSIDERATIONS

- To warranty the die, round holes must have a web between holes of 3.17mm or two (2) times the material thickness, whichever is greater.
- Long and narrow shapes must have a web between holes:
Up to 12.7mm length
3.17mm minimum
12.7-25.4mm length
4.75mm minimum
25.42-50.8mm length
6.35mm minimum
50.82mm & up length
7.92mm minimum
Material thickness, type and pattern may alter minimum web requirements. Consult the sales desk.
- Because of the variety of hole patterns, number and size of holes, and styles of tools, contact the sales desk for pricing information.
- Special applications may affect pricing.

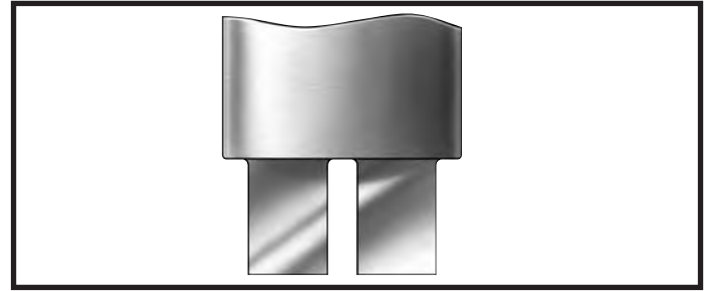
INFORMATION NEEDED

- Machine model
- Material type and thickness or range
- Number of hole clusters
- Straight or staggered pattern
- Center to center dimensions
- B or C style desired (see next page)
- Style of guide assembly being used

THICK TURRET



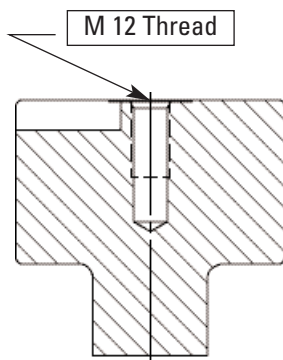
STYLE "B": This design provides economy and flexibility, particularly on long run jobs. The ability to replace the punch tip and inserts make this the "style of choice" of most manufacturers. The added benefit is the ability to change the cluster pattern and insert size and shape by purchasing only the punch tip and inserts.



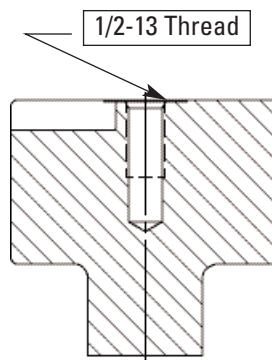
STYLE "C": The cluster pattern is precision machined and ground from a solid punch. This design tends to be less expensive for short run jobs. However, if damage does occur to this punch, an entirely new punch must be ordered, rather than an inexpensive insert as in style "B".

THICK TURRET PUNCHES

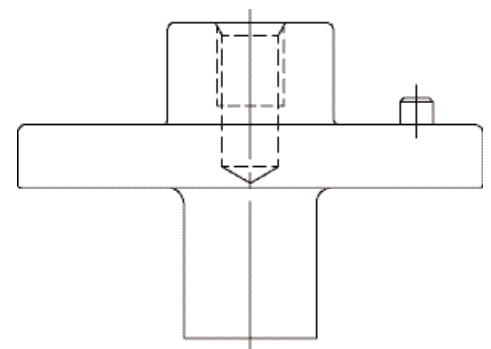
When ordering a cluster tool, it is important to specify to the sales desk the style punch for which you want the cluster made. The three (3) punch styles are shown below.



Old Style



Old Style



High Performance® (HP)

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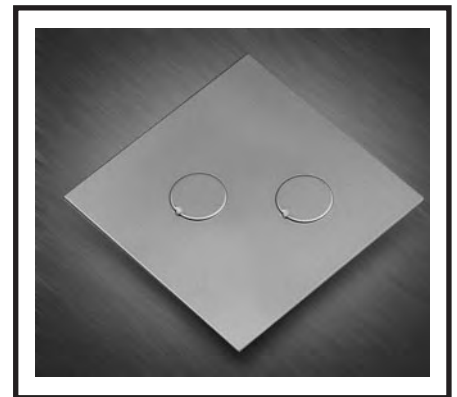
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THICK TURRET



Shown with optional E-Z set™ punch head.



BENEFITS

- Interchangeable design provides economy and flexibility.
- Purchase only punch tip(s), ejector, and die assembly when changing sizes.
- Most EKO's can be used in a small range of material thicknesses (example: 16-14 gauge/1.5-2mm).
- Available in rounds, standard shapes and special shapes.
- E-Z set™ punch head is recommended for fast and easy length adjustments on the 31.75mm station. (No shims needed.) See E-Z set™ punch head page for further details.
- Available stock sizes are:
Single EKO 22.22mm diameter
Single EKO 28.57mm diameter
Double EKO 22.22 x 28.57mm diameter

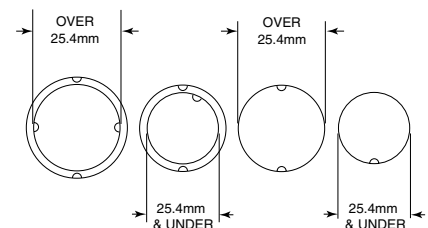
Note: Stock dies have 0.25mm clearance for 16 (1.5mm) and 14 (2mm) gauge mild steel

CONSIDERATIONS

- Slow machine speed or program in post delay to give the tool time to strip.
- Consult the sales desk for material thickness range when exceeding 14 gauge (2mm).
- Special applications may affect pricing.

INFORMATION NEEDED

- Machine model
- Material thickness & type
- Actual diameter
- Specify STD. or SPL. tab location & size
- Specify center-to-center if more than one knockout exists on the sheet





THICK TURRET



BENEFITS

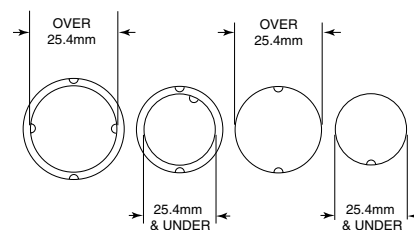
- Interchangeable design provides economy and flexibility.
- Purchase only punch tip(s), ejector, and die assembly when changing sizes.
- Use the same holder to interchange single and double EKO's.
- Fast and easy length adjustments can be made with the adjusting spring plunger, saving you costly set-up time.
- Most EKO's can be used in a small range of material thicknesses (example: 16-14 gauge/1.5-2mm).
- Available in rounds, standard shapes and special shapes.
- Universal holder design gives you the flexibility of using the same upper unit holder for other applications.
- Tooling is WLS ready, minimizing wear and maintenance.

CONSIDERATIONS

- Slow machine speed or program in post delay to give the tool time to strip.
- Consult the sales desk for material thickness range when exceeding 12 gauge (2.7mm).
- Special applications may affect pricing.

INFORMATION NEEDED

- Machine model
- Material thickness & type
- Actual diameter
- Specify STD. or SPL. tab location & size
- Specify center-to-center if more than one knockout exists on the sheet



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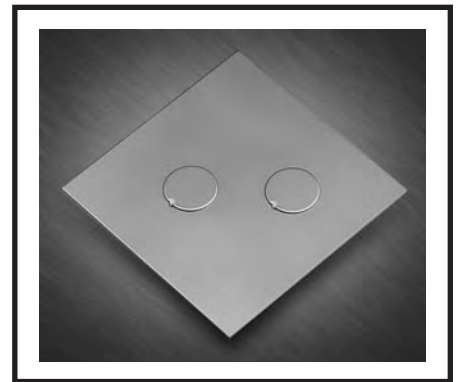
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THICK TURRET



Shown with optional E-Z set™ punch head.



BENEFITS

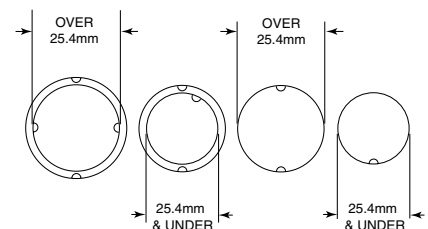
- Provides for fast machine set-up and trouble-free operation.
- Most EKO's can be used in a small range of material thicknesses (example: 16-14 gauge/1.5-2mm).
- Available in rounds, standard shapes and special shapes.
- Self-stripping design is standard on all form-down EKO's.
- E-Z set™ punch head is recommended for fast and easy length adjustments. (No shims needed.) See E-Z set™ punch head page for further details.

CONSIDERATIONS

- Slow machine speed or program in post delay to give the tool time to strip.
- Consult the sales desk for material thickness range when exceeding 14 gauge (2mm).
- Special applications may affect pricing.

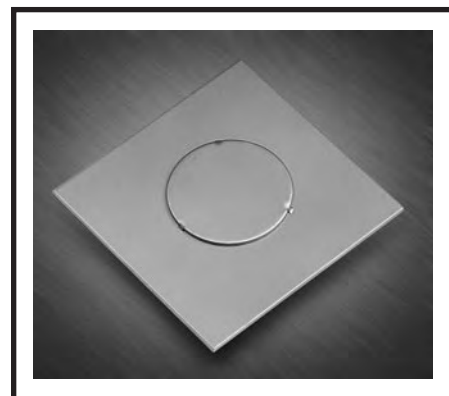
INFORMATION NEEDED

- Machine model
- Material thickness & type
- Actual diameter
- Specify STD. or SPL. tab location & size
- Specify center-to-center if more than one knockout exists on the sheet





THICK TURRET



BENEFITS

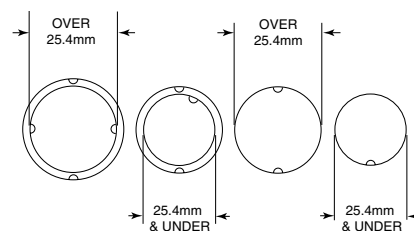
- Provides for fast machine set-up and trouble-free operation.
- Set-up time is reduced to a minimum with a Series 90® holder.
- Most EKO's can be used in a small range of material thicknesses (example: 16-14 gauge/1.5-2mm).
- Available in rounds, standard shapes and special shapes.
- Self-stripping design is standard on all form-down EKO's.

CONSIDERATIONS

- Slow machine speed or program in post delay to give the tool time to strip.
- Consult the sales desk for material thickness range when exceeding 12 gauge (2.7mm).
- Special applications may affect pricing.

INFORMATION NEEDED

- Machine model
- Material thickness & type
- Actual diameter
- Specify STD. or SPL. tab location & size
- Specify center-to-center if more than one knockout exists on the sheet



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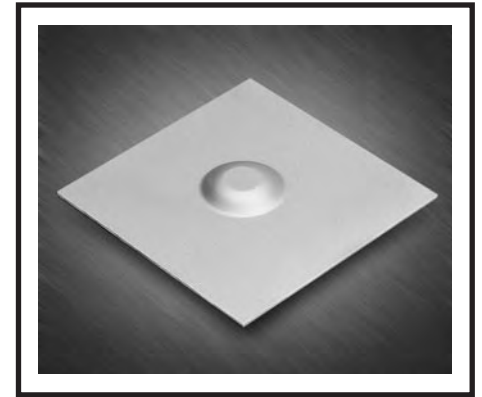
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THICK TURRET



Shown with optional E-Z set™ punch head.



BENEFITS

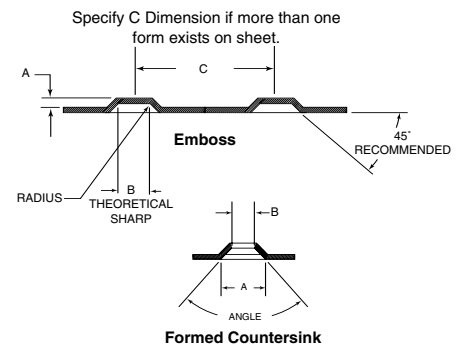
- Emboss style forming tools are useful for the following applications:
Stand-offs
Spacers
Large countersinks
Locks for nuts
- 0° and 90° standard keying on shape forms.
- 31.75mm (B) Station is a full body design to give maximum bearing area to sheet.
- Series 80® Plus and Series 90® holders make length adjustments fast and easy, reducing expensive down time.
- The correct tool can be tailored for your application.
- E-Z set™ punch head is recommended for fast and easy length adjustments on the 31.75mm (B) station. (No shims needed.) See E-Z set™ punch head page for further details.

CONSIDERATIONS

- Large station forming tools must be run with a light spring in the upper unit.
- Keep forming tools as far from clamps and pierced holes as possible.
- A ring mark around the form indicates there is too much spring pressure in the upper unit or the tool is stroking too deep.
- A post delay should be programmed in to give the tool time to strip.
- For maximum size in different stations, please contact the sales desk.
- Never punch thicker material than what the tool was designed for.
- Sheet distortion is common in forming operations.
- Special applications may affect pricing.

INFORMATION NEEDED

- Machine model
- Material thickness and type
- Full dimensioning (height, dia. or shape, angle, radius, thru-hole, etc.)
- Drawing (if possible)
- Dimensions preferred to a theoretical sharp





THICK TURRET



BENEFITS

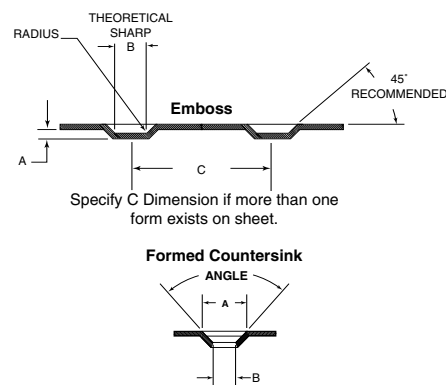
- Emboss style forming tools are useful for the following applications:
Stand-offs
Spacers
Large countersinks
Locks for nuts
- 0° and 90° standard keying on shape forms.
- Other keying options available upon request.
- The correct tool can be tailored for your application.
- E-Z set™ punch head is recommended for fast and easy length adjustments on the 31.75mm (B) station. (No shims needed.)
See E-Z set™ punch head page for further details.

CONSIDERATIONS

- For manual machines.
- May be used on N/C machines with special programming.
- Sheet distortion is common in forming operations.
- Special applications may affect pricing.

INFORMATION NEEDED

- Machine model
- Material thickness and type
- Full dimensioning (height, dia. or shape, angle, radius, thru hole, etc.)
- Drawing (if possible)
- Dimensions preferred to a theoretical sharp



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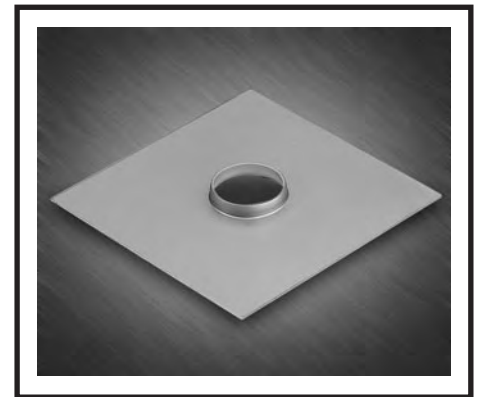
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31.75mm (B) STATION THICK TURRET



Shown with optional E-Z set™ punch head.



BENEFITS

- Extrusions can be used in a broad spectrum of applications, such as self-tapping screws, cooling tube holders, air flow applications and tread plate.
- Extrusion diameters 6.35mm I.D. and less are made insert style for fast, easy and economical replacement.
- Optima™ coating provided on all Extrusions greater than 2.5mm for durability, longer life and ease of stripping.
- Form-down extrusions made self-stripping for use in NC and CNC punch presses.
- E-Z set™ punch head available for fast and easy length adjustments. See E-Z set™ punch head for further details.

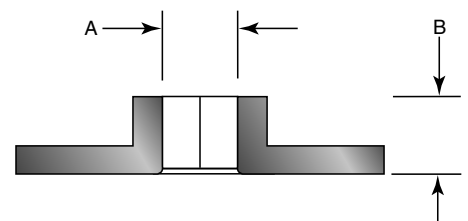
CONSIDERATIONS

- Slow machine speed or program in a post delay to give the tool time to strip.
- Form-up and form-down extrusions must be pre-punched.
- Extrusions are made for a specific material thickness and type.
- Consult the sales desk when extruding stainless steel.
- Special applications may affect pricing.

STD	Sizes
.106	(6-32)
.136	(8-32)
.150	(10-24)
.159	(10-32)
.203	(1/4-20)
.098	M-3
.130	M-4
.165	M-5
.197	M-6

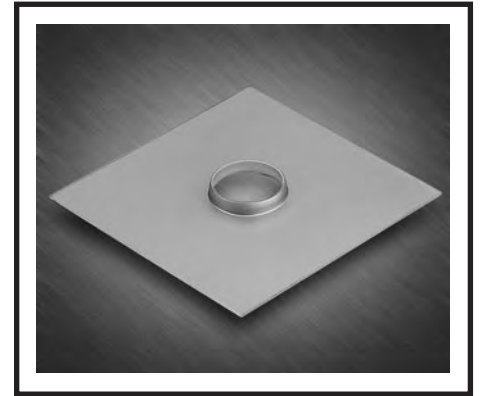
INFORMATION NEEDED

- Machine model
- Material thickness and type
- I.D. and height or screw size and type
- Tolerance of I.D.
- Form-up or form-down
- Specify center-to-center if more than one extrusion exists on the sheet





LARGE STATION THICK TURRET



BENEFITS

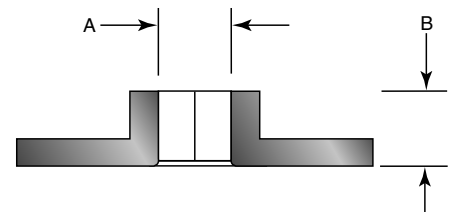
- Extrusions can be used in a broad spectrum of applications, such as self-tapping screws, cooling tube holders, air flow applications and tread plate.
- Interchangeable design on Extrusions greater than 12.7mm I.D. provides economy and flexibility. Purchase only punch tip, ejector and die assembly when changing size.
- Internal self-stripping design for consistent, trouble-free operation.
- Universal holder design gives you the flexibility of using the same upper unit holder for other applications, such as electrical knockouts and lance and forms.
- Fast and easy length adjustments can be made with the adjusting spring plunger, thereby saving you costly set-up time.
- A coated lower unit provides durability, longer life and easier stripping.
- WLS ready.

CONSIDERATIONS

- Slow machine speed or program in post delay to give the tool time to strip.
- Form-up Extrusions must be pre-punched.
- Extrusions are made for a specific material type and thickness.
- Consult the sales desk when extruding stainless steel.
- Punch, stripper and die assembly designs on Extrusions less than 12.7mm I.D. require reduced spring pressure in upper unit.
- Special applications may affect pricing.

INFORMATION NEEDED

- Machine model
- Material thickness and type
- I.D. and height or screw size and type
- Tolerance of I.D.
- Form-up or Form-down
- Specify center-to-center if more than one Extrusion exists on the sheet



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31.75mm (B) STATION THICK TURRET

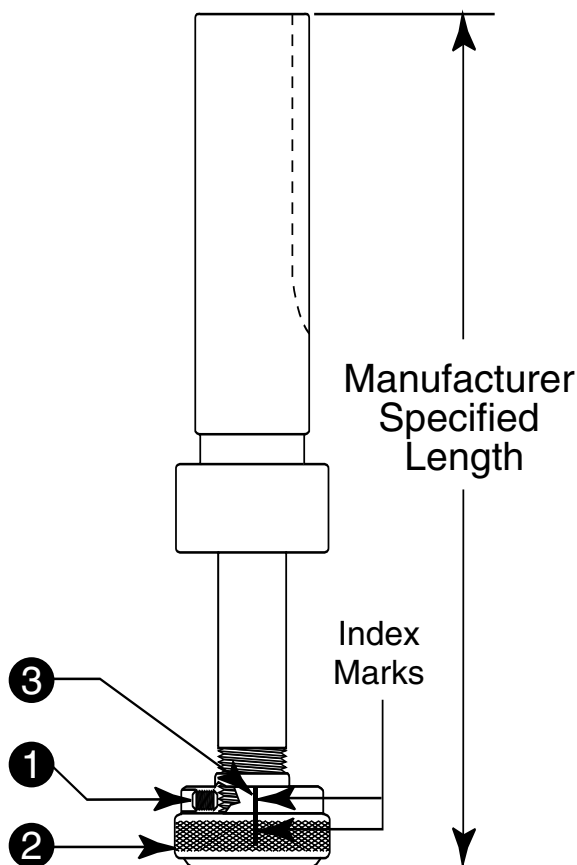


The E-Z set™ punch head provides quick turn-of-the-wrist adjustment. You can achieve just the right mark or form when using the E-Z set™ punch head on 12.7mm (A) or 31.75mm (B) station stamping and forming tools. Trial and error is streamlined by the E-Z set™ punch head. Costly machine down time for tool adjustment is converted into productive machine up time.

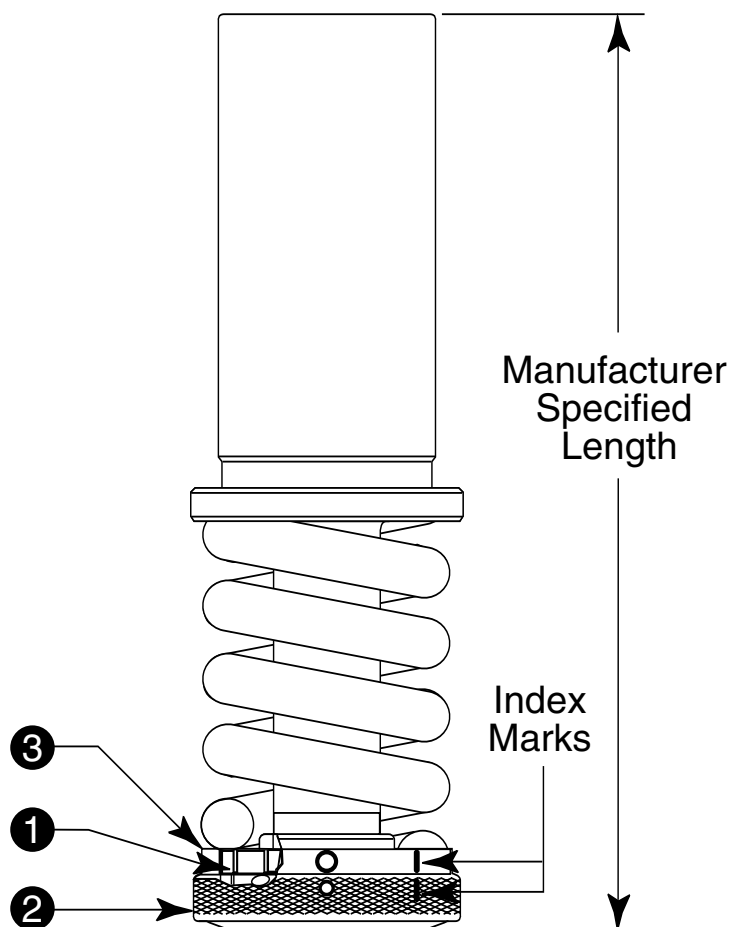
Each adjustment click provides a 0.09mm incremental change in the tool length. The maximum adjustment is approximately 3.18mm. A simple lift and turn of the adjustable head is all that is required. Fine length adjustments can now be made without removing the tool from the turret. You will see **instant** payback based on reduced machine down time.



THICK TURRET



12.7mm STATION



31.75mm STATION

- Align the index marks on the two pieces of the E-Z set™ punch head (Details #2 and #3).
- Holding the two pieces together, install the E-Z set™ punch head onto the punch shank by turning the head clockwise to the manufacturer's specified length.
- Tighten the two 5mm set screws (Detail #1).
- To increase the length (DO NOT loosen the set screws), just lift the outer ring (Detail #2) and turn counter clockwise.
- Each click is a 0.09mm adjustment.
- The maximum adjustment is approximately 3.18mm. When the limit is reached, the head will rotate freely for approximately one quarter turn.
- On forming tools made for more than one material thickness, set the manufacturer's specified length to the thicker material and adjust for the thinner material.
- Resetting the head for further adjustment is NOT RECOMMENDED because of reduced thread engagement. DAMAGE MAY OCCUR.

- Align the index marks on the two pieces of the E-Z set™ punch head (Details #2 and #3).
- Holding the two pieces together, install the E-Z set™ punch head onto the punch shank with a spring or urethane.
- Use a spanner wrench in one of the two set screw holes in the lower part (Detail #3) and turn the head clockwise to the manufacturer's specified length.
- Tighten the two 5mm set screws (Detail #1).
- To increase the length (DO NOT loosen the set screws), just lift the outer ring (Detail #2) and turn counter clockwise.
- Each click is a 0.09mm adjustment.
- The maximum adjustment is approximately 3.18mm. When the limit is reached, the head will rotate freely for approximately one quarter turn.
- On forming tools made for more than one material thickness, set the manufacturer's specified length to the thicker material and adjust for the thinner material.
- Resetting the head for further adjustment is NOT RECOMMENDED because of reduced thread engagement. DAMAGE MAY OCCUR.

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THICK TURRET



Shown with optional E-Z set™ punch head.



BENEFITS

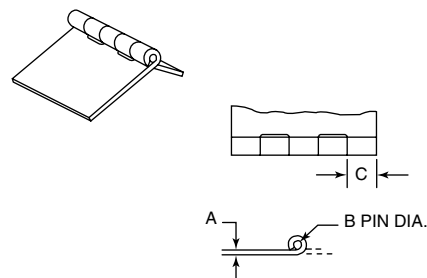
- Hinge Tools eliminate costly hardware, fitting and line-up assembly.
- The tooling allows you to fabricate complete panels with their own integrated hinges.
- A fully curled knuckle is achieved with two sets of tools. The first tool takes two hits and the second tool one hit.
- Hinges can be produced on the edge or in the middle of the sheet. Simply pre-punch the knuckle size and run the hinge tools as instructed.
- Tested on our turret prior to shipping to ensure proper functioning.
- Operating instructions with developed dimensions for easy programming are included with tool.
- E-Z set™ punch head is recommended for fast and easy adjustments.

CONSIDERATIONS

- Design parameters change when using stainless steel. Consult the sales desk.
- Maximum material and pin size may vary according to machine.
- Maximum material thickness is 18 gauge (1.2mm) stainless steel, 14 gauge (2mm) in mild steel, and 2mm in aluminium.
- Offset hinge tools are available. Consult the sales desk.
- Special applications may affect pricing.

INFORMATION NEEDED

- Machine model
- Material thickness and type
- Drawing of application required
- Hole ID and tolerance
- Knuckle size
- Location of hinge on sheet required (edge or middle)

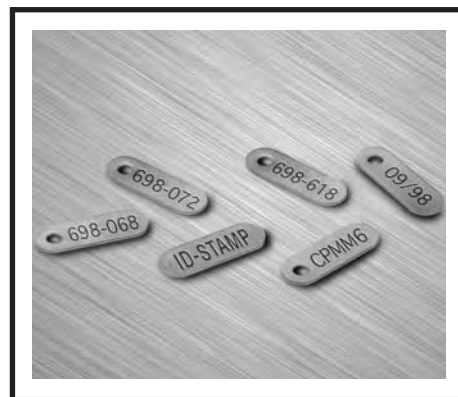




THICK TURRET



88.9mm (D) and 31.75mm (B) Stations Shown



BENEFITS

- Reduces the number of tools needed to mark parts.
- Eliminates secondary stamping operations.
- Interchangeable characters for maximum flexibility.
- Adjustable material range of 3.2mm for most machines.
Consult sales desk.
- Fast and easy length adjustments can be made with the adjusting spring plunger, saving you costly set-up time.
- E-Z set punch head is recommended for fast and easy adjustments (no shims needed).
- Tool can be used in adapters for large station auto index in most machines.
Consult sales desk.
- Tooling is WLS ready, minimizing wear and maintenance.

CONSIDERATIONS

- Characters are sold separately.
- Designed for 3mm characters only.
- Consult sales desk for required tooling, restrictions, and pricing.

INFORMATION NEEDED

- Machine model
- Material thickness range and type

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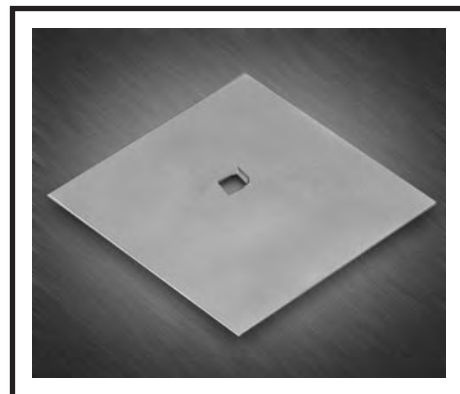
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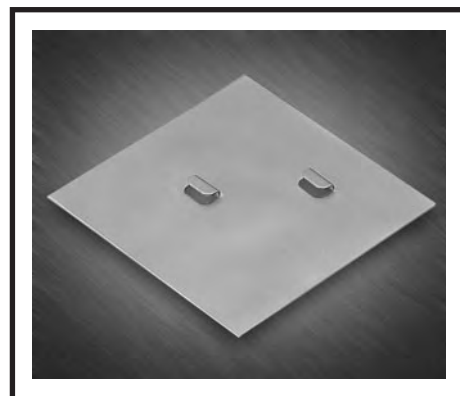
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31.75mm STATION THICK TURRET



Shown with optional E-Z set™ punch head.



BENEFITS

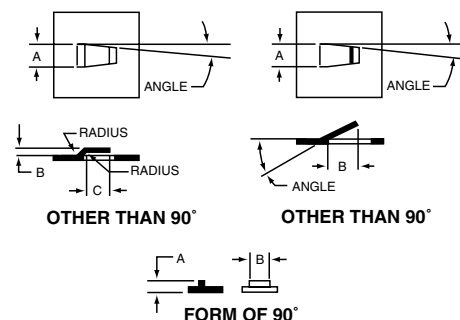
- Lance and forms are used in various applications, including air flow, decoration, card guides, location markers, shear tabs, wire harnesses and clip attachments.
- High-quality lance and forms other than 90° are assured with Wilson's positive form and self-stripping design.
- Replaceable tip and ejector design provides cost savings and flexibility.
- Optima™ coating is available for extending tool life.
- E-Z set™ punch head is recommended for fast and easy length adjustments. (No shims needed.) See E-Z set™ punch head page for further details.

CONSIDERATIONS

- Lance and forms of 90° must form a minimum of two material thicknesses overall.
- Forms of 90° may need to be pre-punched around tab when punching aluminium or thin material.
- Lance and forms are made for a particular material thickness. Never run thicker material or damage will occur.
- Variations to line drawings will change pricing. Consult the sales desk.
- Special applications may affect pricing.

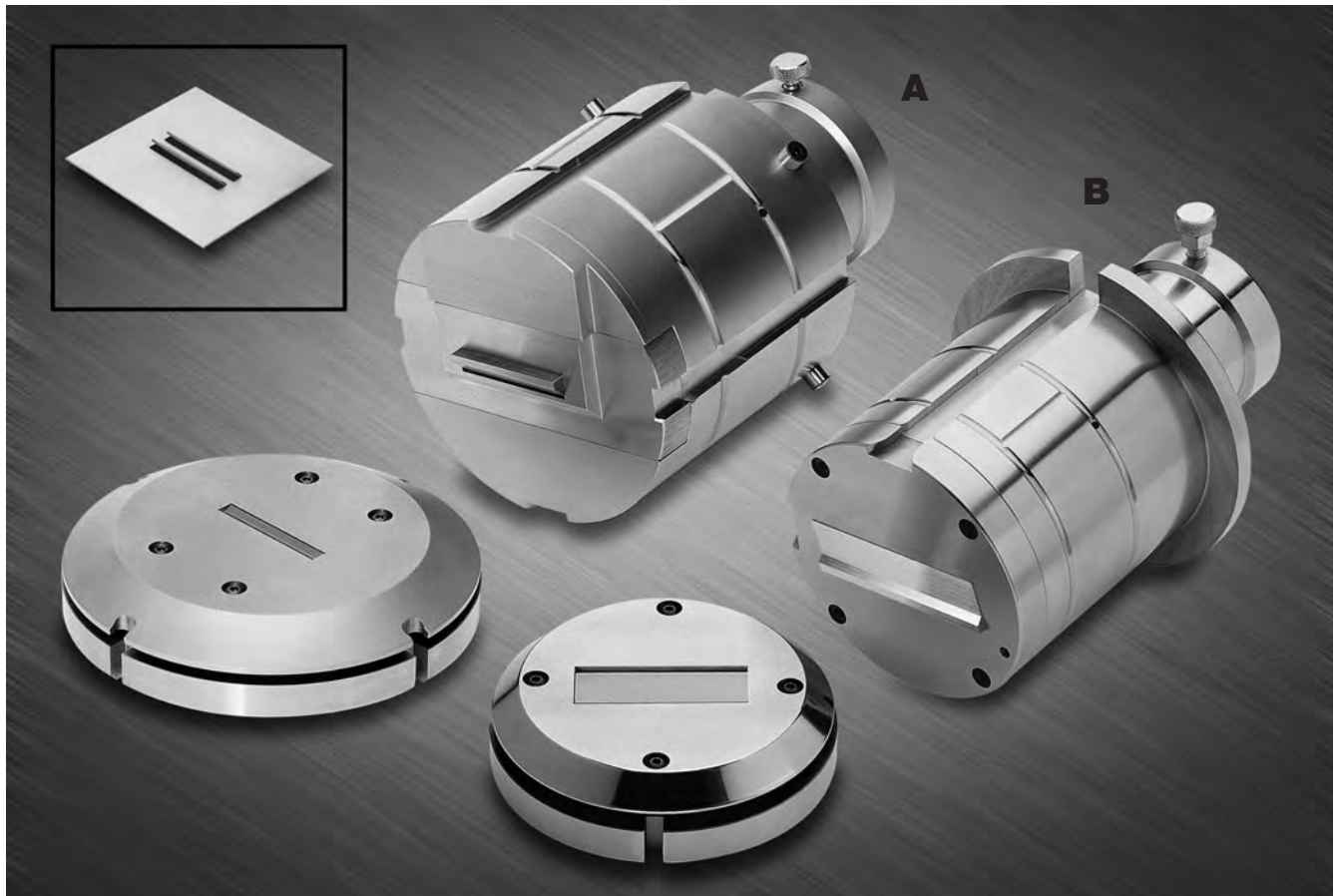
INFORMATION NEEDED

- Machine model
- Material thickness and type
- Complete drawings of the lance and form showing length, width, height, angles, and other forms (if any) near lance so proper relief can be built into the tool





LARGE STATIONS THICK TURRET



Universal holder designs A (louvre) and B (EKO) shown above, (WLS ready).

BENEFITS

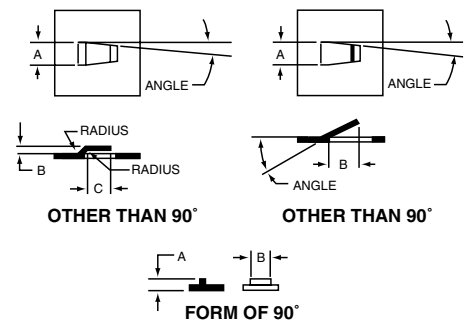
- Lance and forms are used in various applications, including air flow, decoration, card guides, location markers, shear tabs, wire harnesses and clip attachments.
- Most lance and forms are made from our complete holder design, eliminating the need for spring changes, assembly and disassembly.
- Fast and easy length adjustments can be made with our adjusting spring plunger, saving you costly set-up time. (No shims needed.)
- The self-stripping design on lance and forms less than 90° assures consistent, trouble-free operation.
- Replaceable punch tip, ejector and inserts for added cost savings.
- Both universal holder designs give you the flexibility of using the same upper unit holder for other applications, such as: Extrusions, EKO's, progressive ribs, edge forms and louvres, as well as various size lance and forms.

CONSIDERATIONS

- Lance and forms of 90° must form a minimum of two material thicknesses overall.
- Forms of 90° may need to be pre-punched around the tab when punching aluminium or thin material.
- Lance and forms are made for a particular material thickness. Never run thicker material or damage will occur.
- A taper of 5° per side should be added to aid in stripping large station lance and forms other than 90°.
- Variations to line drawings will change pricing. Consult the sales desk.
- Special applications may affect pricing.

INFORMATION NEEDED

- Machine model
- Material thickness and type
- Complete drawings of the lance and form showing length, width, height, angles, and other forms (if any) near lance so proper relief can be built into the tool
- Style of guide assembly - for lance and forms of 90° only (e.g. Series 80/90, Old Style, etc.)



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THICK TURRET



Shown with optional E-Z set™ punch head.



BENEFITS

- Stamping while in the machine eliminates secondary handling costs, and ensures consistent marking.
- Cost saving replaceable insert design allows for versatility as well as quick and easy replacement.
- Letter stamp tools give you the flexibility to change character size and number of rows simply by changing the punch tip and characters.
- All letter stamp tools are adjustable to stamp a 3mm range of material.
- Form-down logos available in coined or embossed styles. Consult the sales desk for price and availability.
- 31.75mm (B) station single and double row letter stamp tools are in stock for 3.17mm characters, with maximum characters per row (3.17mm maximum material).
- E-Z set™ punch head is recommended for fast and easy length adjustments on the 31.75mm (B) station. (No shims needed.)

CONSIDERATIONS

- Characters not included in set price.
- Special applications may affect pricing.
- Consult sales desk for maximum number of characters with multiple rows.

INFORMATION NEEDED

- Machine model
- Material thickness and type
- Size character, number of rows, number of characters per row
- Station size and style of tooling
- Thread type if "Old Style"

MAXIMUM NUMBER OF CHARACTERS PER ROW FOR SINGLE ROW STAMP

SIZE	31.75mm (B) STN	50.8mm (C) STN	88.9mm (D) STN	114.3mm (E) STN	152.4mm (F) STN
1.57mm	22	24	48	64	88
2.36mm	14	16	32	43	59
3.17mm	10	12	24	32	44
4.75mm	7	8	16	21	29
6.35mm	5	6	12	16	22
9.52mm	3	4	8	10	14



THICK TURRET



Shown with optional E-Z set™ punch head.



BENEFITS

- Stamping while in the machine eliminates secondary handling costs, and ensures consistent marking.
- The self-stripping design reduces character wear and sheet marking.
- Interchangeable character design allows for versatility as well as quick and easy replacement.
- All letter stamp tools are adjustable to stamp a 3mm range of material.
- Form-up logos available in coined or embossed styles. Consult the sales desk for price and availability.
- Self-stripping 31.75mm (B) station single and double row letter stamp tools are in stock for 3.17mm characters, with maximum characters per row (3.17mm maximum material).
- E-Z set™ punch head is recommended for fast and easy length adjustments on the 31.75mm (B) station. (No shims needed.)

CONSIDERATIONS

- Characters not included in set price.
- Faster character wear will occur in stainless steel and more sheet marking will occur in aluminium if the die is not made self-stripping. Consult the sales desk for pricing of non-self-stripping letter stamps.
- Special applications may affect pricing.

INFORMATION NEEDED

- Machine model
- Material thickness and type
- Character size, number of rows, number of characters per row
- Station size and style of tooling
- Thread type if "Old Style"

MAXIMUM NUMBER OF CHARACTERS PER ROW

SIZE	31.75mm (B) STN		50.8mm (C) STN		88.9mm (D) STN		114.3mm (E) STN	
	1	2	1	2	1	2	1	2
	Row	Rows	Row	Rows	Row	Rows	Row	Rows
1.57mm	20	20	31	31	53	53	64	64
2.36mm	14	14	21	20	35	35	43	43
3.17mm	10	10	15	15	26	26	32	32
4.75mm	7	N/A	10	9	17	17	24	24
6.35mm	5	N/A	7	7	13	13	16	16
9.52mm	3	N/A	5	N/A	8	N/A	10	N/A

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THICK TURRET



BENEFITS

- Helps reduce sheet and form distortion.
- Fast and easy assembly and disassembly with Series 80®, Series 80 Plus®, Series 90® and High Performance® (HP). Simply spin off the existing spring unit and spin on the partial light spring unit.
- Helps reduce sheet marking in piercing operations. (Consult the sales desk.)
- Sold in partial or complete spring units.
- Assembly instructions included.

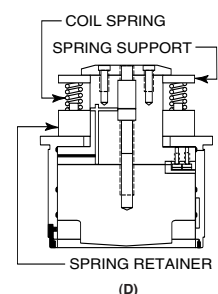
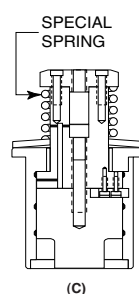
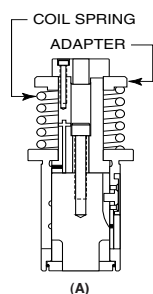
CONSIDERATIONS

- Series 80 Plus® and Series 90® spring units are not interchangeable with Series 80® holders.
- Spring units are used with 31.75mm (B) and 88.9mm (D) station form-up form only, form-up embosses, form-up lance and forms of 90°, form-up letter stamps, and the 88.9mm (D) station scrapless shear tool.

INFORMATION NEEDED

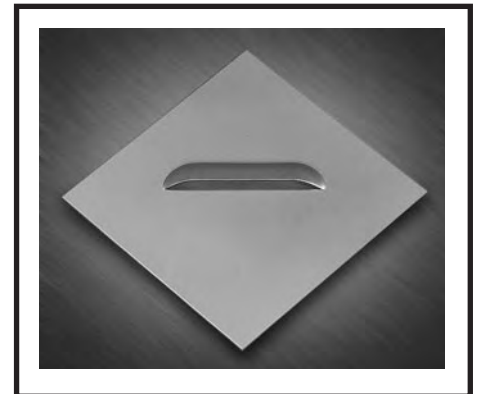
- Type of holder

NON WILSON TOOL ASSEMBLY DESIGNS





THICK TURRET



BENEFITS

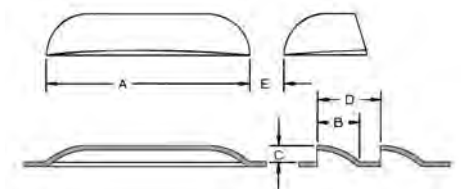
- Universal holder design includes spring loaded adjusting plunger for quick and easy length adjustments. No shims needed!
- Lower costs with replaceable inserts that can be converted to different size Louvres.
- The universal holder allows you to use the same upper unit for other applications, such as progressive louvres and a wide range of lance and forms (new inserts and die assembly needed).
- Optima™ coating provided on inserts for longer life.
- Single hit Louvres can be placed back to back (no web between Louvres).
- Keying at 0°, 90°, 180°, 270° is standard.
- Sharpening instructions sent with the tools or factory sharpening is available.
- Tooling is WLS ready minimizing wear and maintenance.

CONSIDERATIONS

- Maximum width Louvre on our standard design is 19mm (special wide Louvres are available).
- The higher the form the more noticeable the "drawing back" of material.
- Maximum material thickness for our standard design is 3.17mm mild steel. Consult sales desk for Louvres in thicker material.
- A specially designed forming insert is required when using stainless steel.
- Consult the sales desk for pricing on non-standard sizes, 31.75mm (B) and 50.8mm (C) station Louvres.

INFORMATION NEEDED

- Machine model
- Material thickness and type
- A, B, C, D, and E dimensions



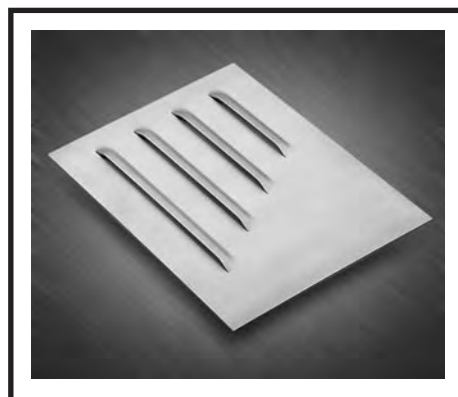
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BENEFITS

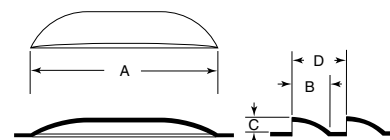
- Universal holder design includes spring loaded adjusting plunger for quick and easy length adjustments. No shims needed!
- Lower costs with replaceable inserts that can be converted to different size louvers.
- The universal holder allows you to use the same upper unit for other applications, such as single hit louvers and a wide range of lance and forms (New inserts and die assembly needed).
- Optima™ coating provided on inserts for longer life.
- No restrictions on the length of the louver. Simply program in any length.
- Keying at 0°, 90°, 180°, 270° is standard.
- Sharpening instructions sent with the tools or factory sharpening is available.
- Do's and don'ts information provided on reverse page.
- WLS ready.

CONSIDERATIONS

- Maximum width louver on our standard design is 19mm (special wide louvers are available).
- The higher the form the more noticeable the "drawing back" of material.
- Maximum material thickness in mild steel and aluminium is 3.17mm and 2.3mm for stainless steel.
- A specially designed forming insert is required when using stainless steel.
- Progressive louvers are made for a specific material thickness. A separate pocket insert is required for each material thickness.
- Consult sales desk for pricing on non-standard sizes.

INFORMATION NEEDED

- Machine model
- Material thickness and type
- B, C and D dimensions



"A" dimension is programmable to any length.
Form length on first full hit is approximately 57mm long.



THICK TURRET



Shown with optional E-Z set™ punch head.



BENEFITS

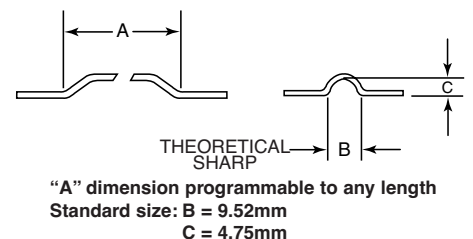
- Produces quality stiffening ribs on your turret.
- Programmable to any length.
- Rib quality can be increased by decreasing the increment moves to 0.5-2mm.
- When changing material thicknesses, only the upper punch or punch tip is required.
- Large station universal holder design gives you the flexibility of using the same upper unit holder for other applications, such as extrusions, EKO's and edge forms, as well as various size lance and forms.
- Fast and easy length adjustments can be made with our E-Z set™ punch head or adjusting spring plunger, saving you costly set-up time (no shims needed).

CONSIDERATIONS

- For best results, inside radius should be equal to or greater than the height.
- Slight deformation will occur on first hit.
- Maximum material thickness:
Mild steel & aluminium—2.7mm.
Stainless steel—2.3mm.
- Ends of rib blend down to sheet (not a distinct radius).
- Maximum recommended "C" dimension is three-and-one-half times the material thickness.
- Special applications may affect pricing.

INFORMATION NEEDED

- Machine model
- Material thickness and type
- B and C dimensions



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BENEFITS

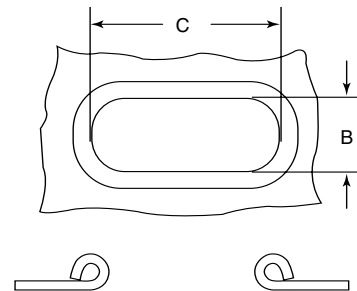
- The Rollover or curling tool can be used in many applications:
 - Hand holds
 - Wire feeds
 - Grommets
- Reduces costly secondary operations and handling.
- Three operations to achieve finished rollover:
 1. Pre-punch
 2. Form-up extrusion
 3. Rollover
- Pre-punch hole developed by Wilson Tool free of charge.
- E-Z set™ punch head is recommended for fast and easy length adjustments on the 31.75mm (B) station. (No shims needed.)
- See E-Z set™ punch head page for further details.

CONSIDERATIONS

- Consult the sales desk for size and material thickness limitations.
- Tearing may occur in widths or diameters less than 16mm.
- See form-up extrusion catalogue page for pricing of operation 2.
- Height in the extruding operation controls how much curl can be achieved.
- Standard tolerance $\pm 0.8\text{mm}$.
- Special tolerance – price on application.

INFORMATION NEEDED

- Machine model
- Material thickness and type
- Diameter or length and width (opening)
- Tolerance of opening
- Application (hand hold, wire feed, etc.)
- Style of guide assembly

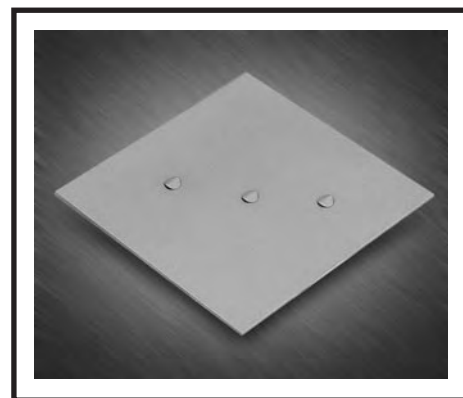




HALF SHEAR THICK TURRET



Shown with optional E-Z set™ punch head.



BENEFITS

- This handy, easy-to-use tool allows you to put in shear buttons and spot welding locators to the accuracy of your punch press.
- Round half shears make excellent locators for angular shearing.
- Replaceable insert design up to 6.35mm diameter in lower unit of 31.75mm (B) station half shear.
- Form-up half shears are available in stock sizes.
- Half shears can be used on a 3.17mm range of material.
- Form-down and large station half shears are available. Consult the sales desk for pricing.
- Rooftop half shear gives you greater height protrusion from the metal which aids in picking up the locator on the sheet.
- E-Z set™ punch head recommended for fast and easy length adjustments.

CONSIDERATIONS

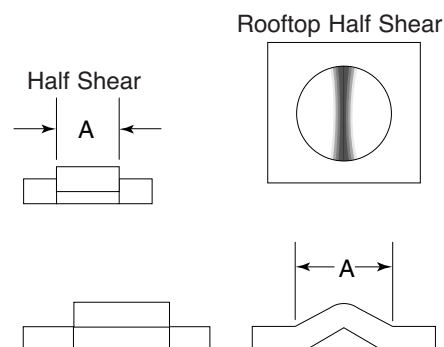
- Half shears work best in thicker material.
- A holding tab similar to an electrical knockout may be required on thin material.
- Rooftop half shears have approximately a 3 gauge material thickness range.
- Minimum recommended rooftop half shear is 6.35mm diameter. The most common size is 10.1mm diameter.
- Never punch material thicker than what either tool was designed for.
- Special applications may affect pricing.

INFORMATION NEEDED

- Machine model
- Material thickness and type (or range)
- Diameter or shape (on top of sheet)

Stock Sizes

.125", .200", .250", 3mm, 4mm, 5mm and 6mm for up to 3.17mm maximum material thickness



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THICK TURRET



88.9mm (D) Station Scrapless Shear tool shown with a Series 90® Guide assembly with a light spring pack.

BENEFITS

- Eliminate the set-up time of a secondary shear operation by shearing material while on the turret.
- Benefits include improved product quality, reduced scrap and higher yield of finished products.
- The Scrapless Shear tool eliminates hit marks, slugs and curls when shearing edges.
- Reduce costs on all stations with replaceable inserts.
- Optima™ coating is included for extending the life of the tool.
- Maximum material range up to 11 gauge (3mm) mild steel for 88.9mm (D) and 114.3mm (E) stations; up to 14 gauge or 2mm mild steel for 31.75mm (B) and 50.8mm (C) stations.
- Increase flexibility of the tool when used in auto index stations.
- E-Z set™ punch head is recommended on 31.75mm (B) station Scrapless Shear tool for fast and easy length adjustments.

CONSIDERATIONS

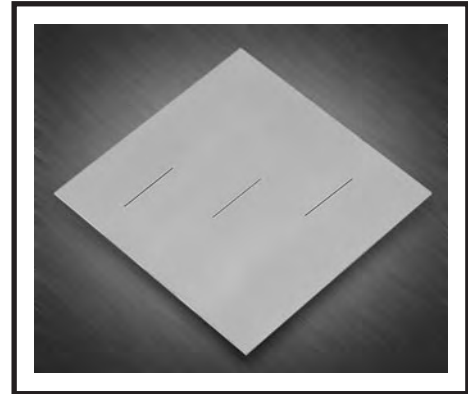
- Large station Scrapless Shear tools must be run with a Series 80®, Series 80 Plus® or Series 90® Guide assembly (assembled with light spring pack).
- Maximum slit length changes with different material thicknesses (Instructions sent with tools).
- Shearing must begin from a pre-punched hole or open edge.
- Machine alignment, keys, turret bores or bushings must be in good condition.
- Special precautions may be required to control sheet marking in aluminium.
- Special applications may affect pricing.

INFORMATION NEEDED

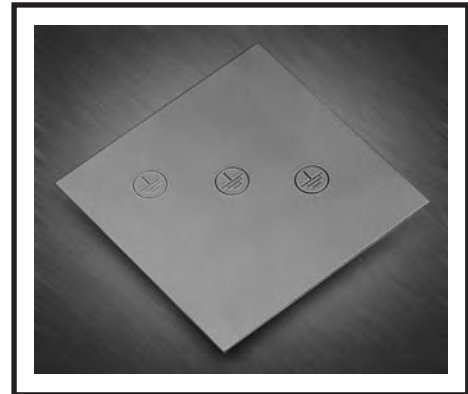
- Machine model
- Material type and thickness or range
- Station size



THICK TURRET



Shown with optional E-Z set™ punch head.



BENEFITS

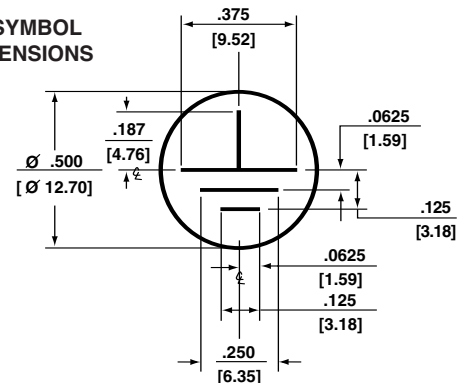
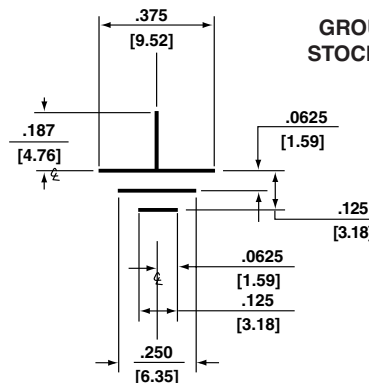
- Dash tools can be used in various applications, such as creating numbers or letters, coining a "V" groove on bend lines to aid in the bending of the sheet, and locators on a sheet.
- Ground symbols are widely used in the electrical industry. They are so popular that Wilson Tool has made them a stock item with or without the circle.
- Both dash tool and ground symbol available in form-up or form-down.
- Form-up is designed self-stripping to prevent sheet marking and tool wear on both dash tool and ground symbol.
- Logos and other special stamps also can be manufactured. Consult the sales desk for further details.
- E-Z set™ punch head is recommended for fast and easy adjustment. See E-Z set™ punch head page for further details.

CONSIDERATIONS

- Thin material may polish on back side of sheet when stamped.
- Dash tool must be run in the Auto Index station when creating numbers or letters.
- Special applications may affect pricing.

INFORMATION NEEDED

- Machine model
- Maximum material thickness and type
- Length of dash
- Size of ground symbol (stock or non-stock)
- Form-up or form-down
- For Auto Index station or standard



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THICK TURRET



Shown with optional E-Z set™ punch head.



BENEFITS

- A great solution for threading holes in thin material.
- The Thread Form tool allows for significant reduction in manufacturing time, supplemental hardware and assembly time.
- Pre-punch information provided.
- Optima™ coating available for extending the life of the tool.
- E-Z set™ punch head available for fast and easy length adjustment on the 31.75mm (B) station. (No shims needed.)
- The same tool can be used in material thinner than what the tool was designed for—simply adjust the length for the different material. (Never run material thicker than what the tool was designed for.)
- Non-standard Thread Forms available. Consult the sales desk.
- Sheet feed direction provided on form-down Thread Forms.

CONSIDERATIONS

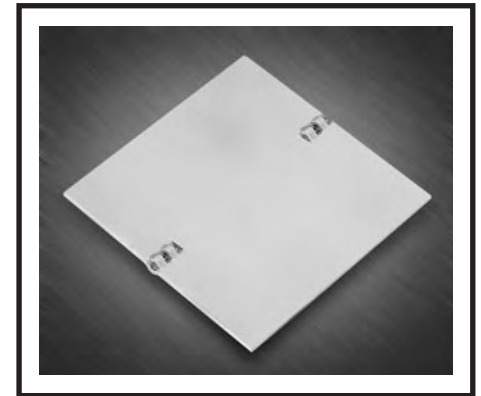
- Operations to produce a Thread Form: Pre-punch, coin*, and Thread Form. (*When exceeding recommended material thickness, coining is required to prevent screw threads from cutting into material.)
- Keyhole pre-punch recommended for stainless and for #10 and M-5 screw size or smaller for all materials. (Keyhole pre-punch provides the necessary clearance to engage screws, as well as to extend tool life.)
- Consult the sales desk for size and material thickness restrictions.
- To assure proper fit, a sample screw may be required on non-standard sizes.
- Special applications may affect pricing.

INFORMATION NEEDED

- Machine model
- Material thickness and type
- Thread size and type



Shown with optional E-Z set™ punch head.



BENEFITS

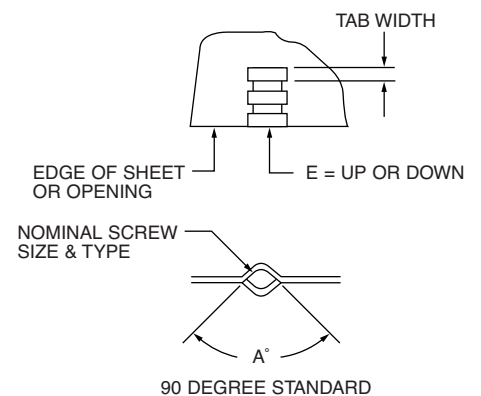
- The Thread Loop tool allows a significant reduction in manufacturing time, supplemental hardware and assembly time.
- Optima™ coating is available and recommended for extending the life of the tool (minimum tab width is 2.5mm).
- The Wilson design gives a positive form, which ensures a high quality part.
- E-Z set™ punch head available for fast and easy length adjustment on the 31.75mm (B) station. (No shims needed.) See E-Z set™ punch head page for further details.

CONSIDERATIONS

- The Thread Loop tool is made for one specific material thickness. Never punch material thicker than what the tool was designed for.
- Widths less than 1.78mm will alter price. Consult the sales desk.
- Special applications may affect pricing.

INFORMATION NEEDED

- Machine model
- Material thickness and type
- Number of threadloop tabs
- Width of tab
- Diameter of opening or screw size and type
- Drawing if possible



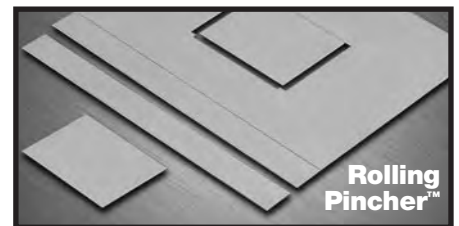
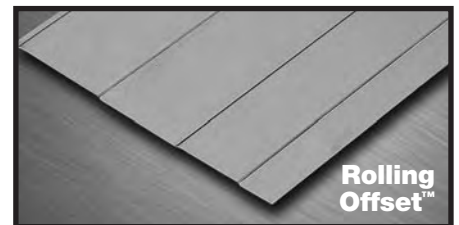
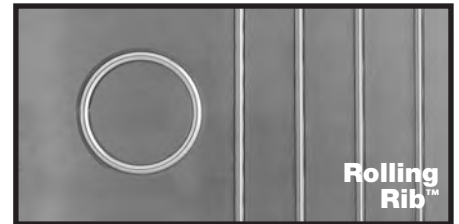
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THICK TURRET



BENEFITS

- High speed – equal to programmed table travel speed.
- Create curves, arcs and circles with your auto index station.
- Virtually no burrs or nibble marks on the sheet.
- Eliminate scrap with the rolling shear and pincher.
- Replacement forming wheels available.
- Available in Form-up or Form-down.
- Works on a wide range of material.
- Wheel tools can start or end anywhere on the sheet.
- Stock sizes available for fast delivery.
- A complete instruction manual sent with each tool.

CONSIDERATIONS

- A programmable hydraulic ram is required to use these wheel tools.
- Consult the sales desk for machine specific requirements.
- Consult sales desk for proper adapters when using tool in a large station.
- Consult sales desk for minimum radius of each tool.

INFORMATION NEEDED

- Machine model
- Material thickness and type



BENEFITS

- Use for sheet "scribing" or dot-matrix marking.
- Works on a range of materials.
- Variable scribe depth.
- Design allows for consistent mark depth.
- Long lasting diamond tip.
- Won't deform the material or mark the underside of the sheet.

CONSIDERATIONS

- Machines with a programmable hydraulic ram can use both the "scribe" feature and the "dot matrix" feature of this tool.
- Machines with a mechanical ram can only use the "dot matrix" feature.

INFORMATION NEEDED

- Machine model
- Material thickness and type

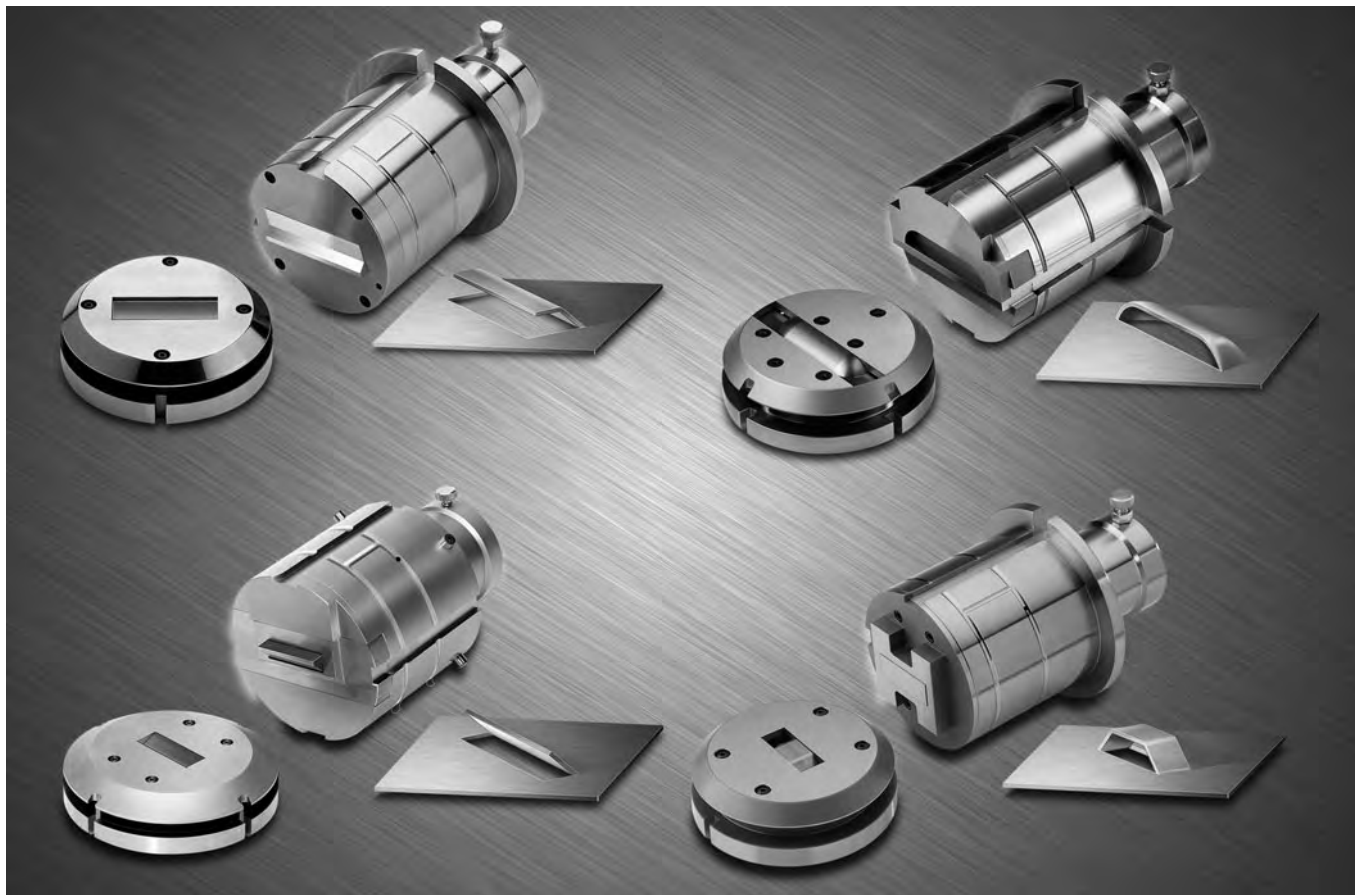
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THICK TURRET



FOR MACHINES WITH FORMING STATION(S) ONLY

BENEFITS

- Ability to produce a wide range of forms in sheet metal up to 12mm high top of sheet to top of form. The only limiting factor is the material itself.
- Forms higher than 12mm may be possible. Consult the sales desk.
- Sheet distortion is minimized.
- Able to form closer to the clamps with less distortion of the sheet.
- Able to pierce holes in adjacent stations with less distortion.

CONSIDERATIONS

- Consult the sales desk for material and height restrictions.
- High form tooling can only be run in the high form station.

INFORMATION NEEDED

- Machine model (must be series 10 or higher)
- Material thickness and type
- Complete drawings with full dimensioning and relief requirements
- Dimensions preferred to the theoretical sharp
- See specific Specials catalogue page for information needed



BENEFITS

- Eliminates the need for expensive and time-consuming fastening methods to join metal parts together such as those of welding and grinding operations, spot welding etc.
- The metal sheets are connected tightly so are very difficult to pull apart.
- Able to join pre-finished or dissimilar metals (the latter as long as they are the same thickness of material).
- Eliminates the release of toxic gases such as those produced during the welding together of coated materials.

CONSIDERATIONS

- The application is patented by Zip-Tech LLC.
- Consult the sales desk for material and height restrictions.
- Two special tools are required. One is a simple T shape to punch around the full radius tabs, and the second is a lance and form (form-up) with a form-down half shear. Both tools should be run in the Auto Index station.
- A standard round tool of 2.04mm is also required.
- As the lance and form tool is material specific, a separate tool is needed for each material thickness.

INFORMATION NEEDED

- Machine model
- Material thickness and type

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PRECISION TOOLING. UNBEATABLE PERFORMANCE.

For more than 40 years, Wilson Tool International® has provided industry-leading tooling solutions that enhance the performance of sheet metal fabricators.

The three divisions of Wilson Tool – Punch Press, Press Brake and Xtra – represent the most comprehensive line of tooling systems and accessories available. Our ability to consistently provide innovative, high quality products that outlast and outperform the competition is why the world's most successful fabricators rely upon Wilson Tool tooling systems.

A knowledgeable global sales force, multilingual customer support staff, same-day shipping and extensive distribution network are just a few of the benefits that keep our customers coming back time and again.

Wilson Tool International (Europe) Ltd – October 2009



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