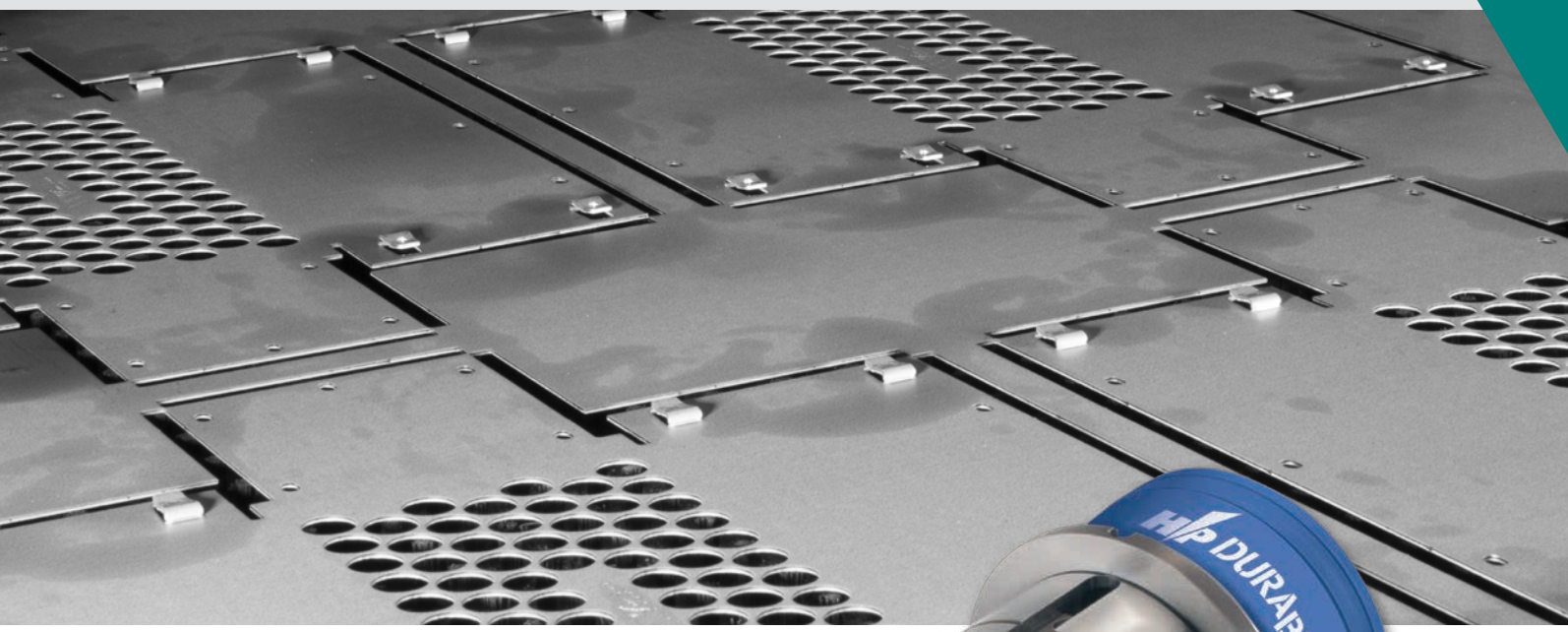
PARTING TOOLS



Parting and slitting are common practices in sheet metal fabrication. Whether you are parting nested parts or straightening the edge of the sheet, you need a product that is rigid and delivers a long tool life.

Wilson Tool developed the Dura-Blade™ and Dura-Die parting products specifically to maximize your productivity for these applications.

Dura-Blade™ features a simple push button adjustment and replaceable cutting blade insert made from Ultima® premium tool steel to significantly increase grind life. The punch blades are supplied with rooftop shear as a standard to reduce punching force and noise.

The **Dura-Die parting tool** completes Wilson Tool's ultimate parting solution. If a new die is necessary, simply replace the removable insert and you are quickly back up and running. When combined with our Dura-Blade product, you are able to greatly increase the life of your parting tools and to help minimize material waste, both products are available with a one or two-sided relieved strippers for use in close-to-clamp. Dura-Dies are also made from Ultima® premium tool steel to significantly increase grind life.

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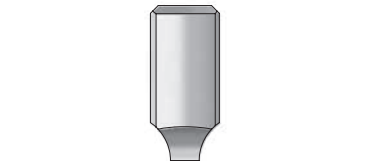
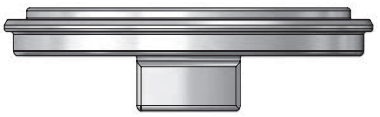
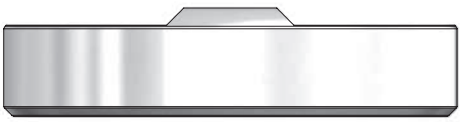
GUIDE ASSEMBLY



PUNCH



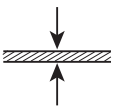
STRIPPER

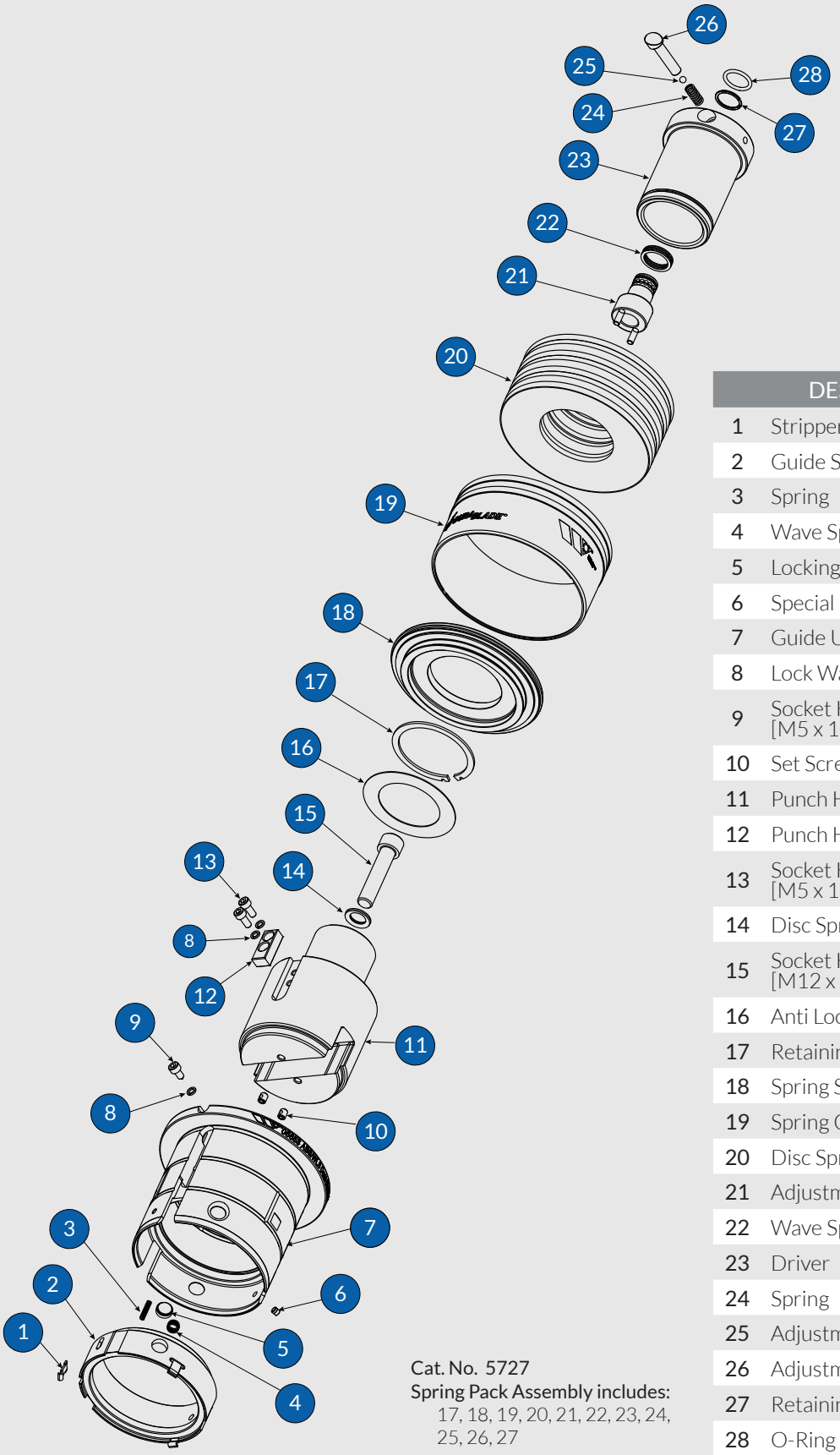


DIE

SHIM

GUIDE ASSEMBLY	CAT. NO.	PRICE
Assembly	5663	
Assembly ABS /WLS	5653	
PUNCH	**CAT. NO**	**PRICE**
Insert	5657	
Optima® Coating		
STRIPPER	**CAT. NO.**	**PRICE**
One Sided Relief	5665	
One Sided Relief ABS	5666	
Two Sided Relief Dégagé des deux côtés	5656	
Two Sided Relief ABS	5664	
DIE	**CAT. NO.**	**PRICE**
Slug Hugger® 2* (relief 2 sides, shape at 90°)	5499	
Slug Hugger® 2* (relief 2 sides, shape at 0°-90°)	5500	
Slug Hugger® 2* (relief 1 side, shape at 90°)	12966	
Slug Hugger® 2* (relief 1 side, shape at 0°-90°)	5501	
Positive (relief 2 sides, shape at 90°)	5101	
Positive (relief 2 sides, shape at 0°-90°)	5328	
Positive (relief 1 side, shape at 90°)	2462	
Positive (relief 1 side, shape at 0°-90°)	5331	
Negative (relief 2 sides, shape at 90°)	5156	
Negative (relief 2 sides, shape at 0°-90°)	5329	
Negative (relief 1 side, shape at 90°)	2463	
Negative (relief 1 side, shape at 0°-90°)	5332	
** Slug Hugger dies must be ordered punch size plus clearance. Size restrictions apply.*		
DIE SHIM	**CAT. NO.**	**PRICE**
0.25 mm single	2081	
0.76 mm single	2727	
1.5 mm single	2084	
0.25 mm pack of 5	2211	
0.76 mm pack of 5	2728	
1.5 mm pack of 5	2175	

DESCRIPTION	MAX WIDTH FOR BLADE INSERT	MAX. MATERIAL THICKNESS	NOTES
Dura Blade guide assemblies are keyed for shapes at 0º, 45º, and 90º. Punch blades are Ultima Premium tool steel.	19.05 mm	6.35 mm 	Ultima® Premium tool steel is available on dies.



Cat. No. 5727
Spring Pack Assembly includes:
17, 18, 19, 20, 21, 22, 23, 24, 25, 26, 27

	DESCRIPTION	CAT. NO.
1	Stripper Clip	5521
2	Guide Stripper Ring	5528
3	Spring	971694
4	Wave Spring	8155
5	Locking Button	5519
6	Special PinGoupille	5522
7	Guide Unit Only	5659
8	Lock Washer	2112
9	Socket Head Cap Screw [M5 x 10.87 mm]	5197
10	Set Screw [M6 x 8 mm]	6298
11	Punch Holder with Bushing	5655
12	Punch Holder Key	1862
13	Socket Head Cap Screw [M5 x 12 mm]	6110
14	Disc Spring	971690
15	Socket Head Cap Screw [M12 x 55 mm]	6026
16	Anti Lock Shim	5413
17	Retaining Ring	5747
18	Spring Support	5738
19	Spring Cover	5679
20	Disc Spring	5449
21	Adjustment Shaft	5739
22	Wave Spring	971692
23	Driver	5740
24	Spring	972396
25	Adjustment Locking Ball	972420
26	Adjustment Button	5737
27	Retaining Ring	972441
28	O-Ring	972430

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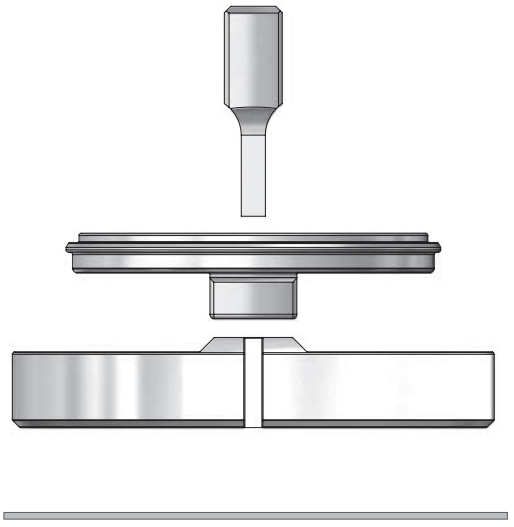
GUIDE ASSEMBLY



PUNCH

STRIPPER

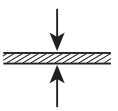
DIE

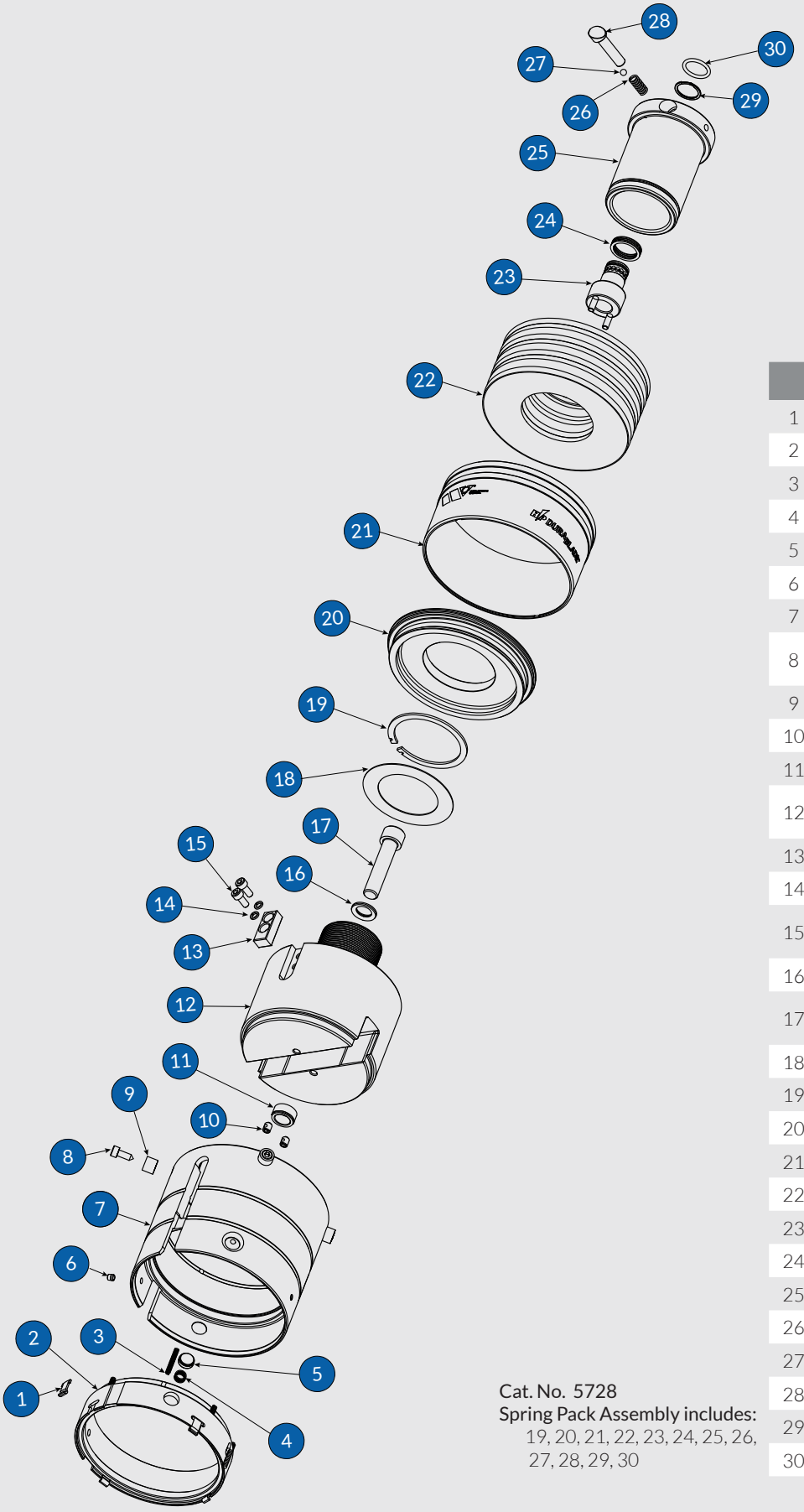
SHIM

GUIDE ASSEMBLY	CAT. NO.	PRICE
Assembly	5639	
Assembly ABS/WLS	5626	
PUNCH	**CAT. NO**	**PRICE**
Insert	5630	
Optima® Coating		
STRIPPER	**CAT. NO**	**PRICE**
One Sided Relief	5641	
One Sided Relief ABS	5642	
Two Sided Relief	5629	
Two Sided Relief ABS	5640	
DIE	**CAT. NO**	**PRICE**
Slug Hugger® 2* (relief 2 sides, shape at 90°)	5502	
Slug Hugger® 2* (relief 2 sides, shape at 0°-90°)	5503	
Slug Hugger® 2* (relief 1 side, shape at 90°)	12968	
Slug Hugger® 2* (relief 1 side, shape at 0°-90°)	5504	
Positive (relief 2 sides, shape at 90°)	5095	
Positive (relief 2 sides, shape at 0°-90°)	5338	
Positive (relief 1 side, shape at 90°)	2465	
Positive (relief 1 side, shape at 0°-90°)	5341	
Negative (relief 2 sides, shape at 90°)	5158	
Negative (relief 2 sides, shape at 0°-90°)	5339	
Negative (relief 1 side, shape at 90°)	2466	
Negative (relief 1 side, shape at 0°-90°)	5342	

** Slug Hugger dies must be ordered punch size plus clearance. Size restrictions apply.*

DIE SHIM		CAT. NO.	PRICE
0.25 mm	single	2073	
0.76 mm	single	2729	
1.5 mm	single	2076	
0.25 mm	pack of 5	2212	
0.76 mm	pack of 5	2730	
1.5 mm	pack of 5	2176	

DESCRIPTION	MAX WIDTH FOR BLADE INSERT	MAX. MATERIAL THICKNESS	NOTES
Dura Blade guide assemblies are keyed for shapes at 0°, 45°, and 90°. Punch blades are Ultima Premium tool steel.	19.05 mm	6.35 mm 	Ultima Premium tool steel is available on dies.



	DESCRIPTION	CAT. NO.
1	Stripper Clip	5521
2	Guide Stripper Ring	5538
3	Spring	971694
4	Wave Spring	8155
5	Locking Button	5519
6	Special Pin	5522
7	Guide Unit Only	5632
8	Socket Head Cap Screw [M5 x 13.39 mm]	5210
9	Lifter Button	5209
10	Set Screw [M6 x 8 mm]	6298
11	Bushing	5631
12	Punch Holder with Bushing	5628
13	Punch Holder Key	1862
14	Lock Washer	2112
15	Socket Head Cap Screw [M5 x 12 mm]	6110
16	Disc Spring	971690
17	Socket Head Cap Screw [M12 x 55 mm]	6026
18	Anti Lock Shim	5413
19	Retaining Ring	5747
20	Spring Support	5741
21	Spring Cover	5679
22	Disc Spring	5449
23	Adjustment Shaft	5739
24	Wave Spring	971692
25	Driver	5742
26	Spring	972396
27	Adjustment Locking Ball	972420
28	Adjustment Button	5737
29	Retaining Ring	972441
30	O-Ring	972430

Cat. No. 5728
Spring Pack Assembly includes:
19, 20, 21, 22, 23, 24, 25, 26, 27, 28, 29, 30

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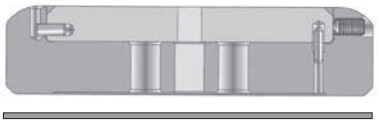
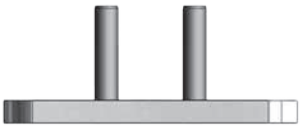


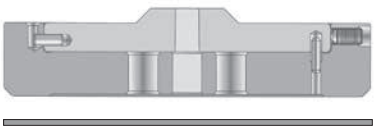
Blade Holder Assembly

Shim



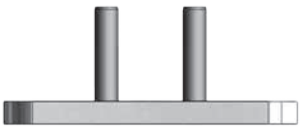
Knock Out Tool

SLITTING DURA-DIE	QTY.	'C' STATION		'D' STATION		'E' STATION	
		CAT. NO.	PRICE	CAT. NO	PRICE	CAT. NO	PRICE
Blade - PositiveInsert- Positif	1	12991		13008		13013	
Blade - Slug Hugger 2Insert - Anti Retour 2	1	12992		13009		13014	
*Blade Holder Assembly at 0° and 90°*Ensemble base matrice à 0°et 90°	1	12989		13006		13015	
Shim PackPaquet de cale	1	12995		13012		13017	
Knock Out ToolExtracteur		24310		24310		24313	
Maximum length		51 mm		86 mm		111.8 mm	
Maximum width		7 mm		6.35 mm		9.52 mm	
Maximum clearance for maximum length		0.51 mm		1.02 mm		0.76 mm	



Blade Holder Assembly

Shim



Knock Out Tool

CLOSE-TO-CLAMP SLITTING DURA-DIE	QTY.	'D' STATION		'E' STATION	
		CAT. NO.	PRICE	CAT. NO.	PRICE
Blade - Positive (relief 2 sides)	1	13281		13289	
Blade - SlugHugger 2 (relief 2 sides)	1	13282		13290	
Blade Holder Assembly at 0° and 90°	1	13276		13284	
Shim Pack	1	13012		13017	
Knock Out Tool		24310		24313	
Maximum length		81 mm		111.8 mm	
Maximum width		7 mm		9.52 mm	
Maximum clearance for maximum length		0.51 mm		0.76 mm	

NOTES

All die assemblies include blade holder, knock out tool, and shim pack.

Dura-Blades™ and Dura-Dies are made from Ultima Premium tool steel as standard.

Die blades ordered separately.