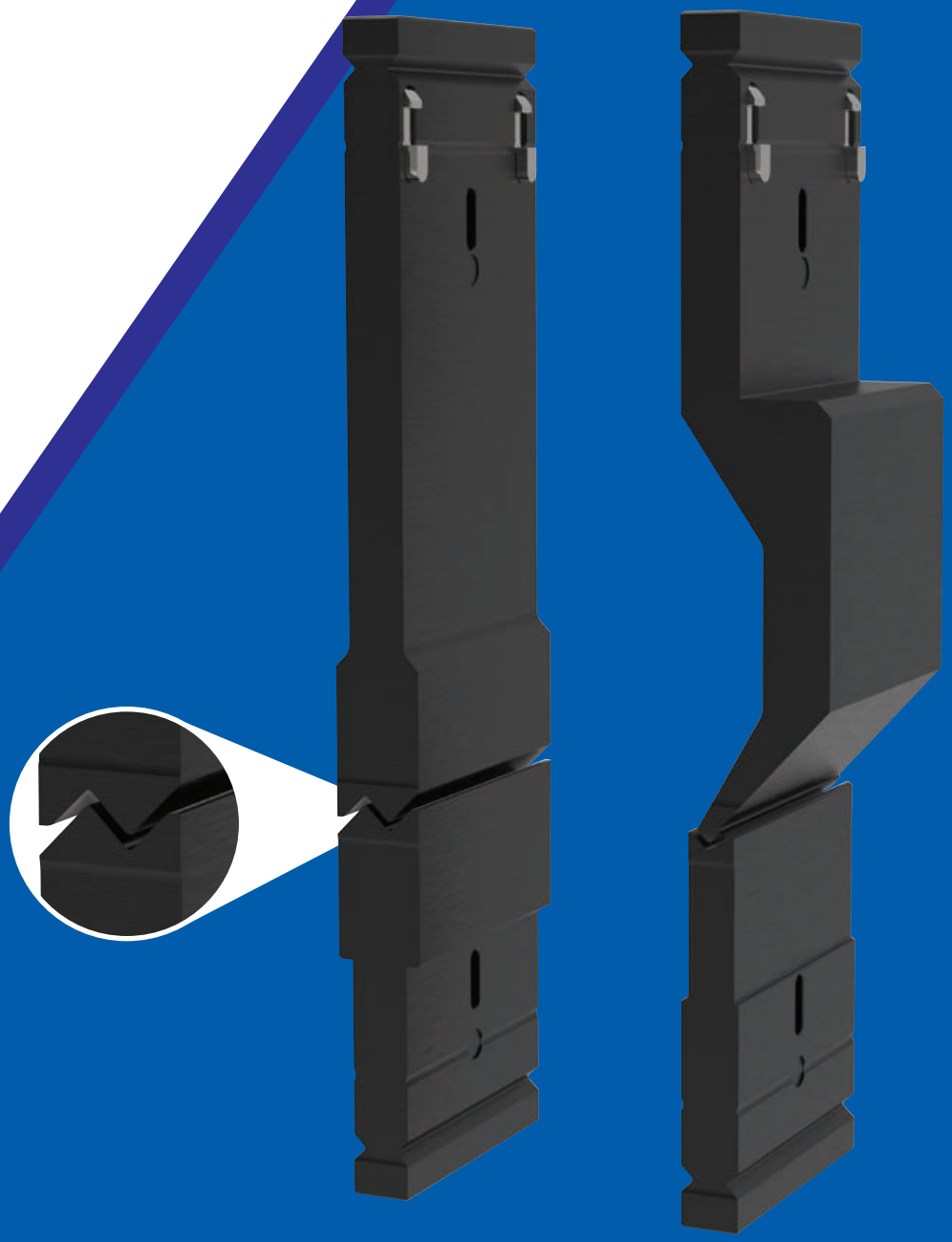
WILSON TOOL



ATC TOOLING

FOR AMADA® PRESS BRAKES

2025

ABOUT WILSON TOOL INTERNATIONAL

From humble beginnings in a small manufacturing facility in St. Paul, Minnesota, Wilson Tool International has added manufacturing facilities and sales channels around the world to better serve our thousands of global customers. Throughout our expansion, our mission has never wavered — we continue to offer products and services that help you be more successful. Every product you buy, every employee with whom you communicate, and every training event you attend, are designed to help customers just like you be more successful.

At Wilson Tool, we continue to invest in your success through constant innovation. Our tooling and solutions represent decades of knowledge and experience in assisting manufacturers resolve their most challenging fabrication issues. We understand that no two jobs are the same. Change is the only constant in manufacturing. So, working with a tooling supplier who's flexible, nimble, and knowledgeable is important.

"Our goal is to deliver exceptional **customer service** along with the most reliable and innovative products and solutions so that our **customers** can be more successful."

When you have a challenge, reach out to us. At Wilson Tool we are more than tools... we are solutions. Your local Sales Engineer is available in person, by phone and through e-mail. Let us put our many decades of expertise to the test. We will work with you to find the best possible solution to whatever challenge you may be facing. And every order comes with our guarantee to outperform your current tooling.

From all of us at Wilson Tool, thank you for the trust you have placed in us to provide products and services that are critical to your business. We look forward to your continued success as we head into the future.

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ATC TOOLING FOR AMADA® PRESS BRAKES

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Keep up with everything that's new at Wilson Tool International! Visit our website or find us on social media for the latest information, news, videos and product releases.

TERMS AND CONDITIONS

ORDER Minimum order is $50.00

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

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

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

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

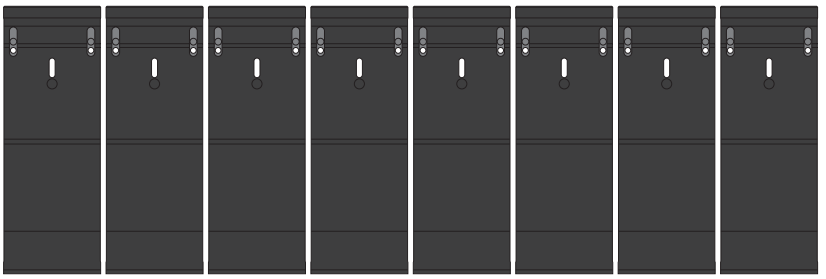
RETURNED MATERIAL A handling/restocking fee will be applied to all standard products returned for credit. A return authorization number and shipping instructions must be obtained in advance before an item can be returned.

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

Amada® is a registered trademark of Amada Co., Ltd. and is used by Amada America, Inc., Amada Capital Corporation and Amada Co., Ltd.

SECTIONALIZED LENGTHS

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

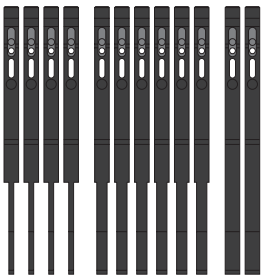


100mm (x 8)

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

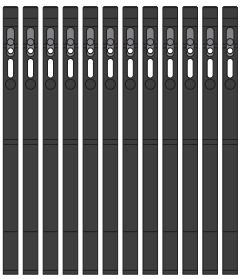
80mm **60mm** **50mm** **30mm** **25mm (x 3)** **20mm (x 4)** **15mm (x 4)**

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



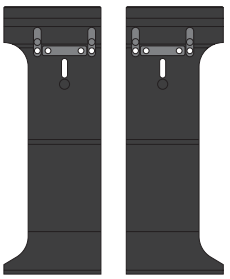
5mm (x 4) **10mm (x 6)** **15mm (x 2)**

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



15mm (x 12)

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



100mm (x 2)

Stocker Capacity by Machine

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

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FEATURES & OPTIONS

ATC tooling for Amada® machines is now available from Wilson Tool at a lower cost with quicker lead times. Our ATC tooling is dimensionally identical to, and bears the same part numbers as, their Amada counterparts to ensure seamless ordering and usage in the machine.

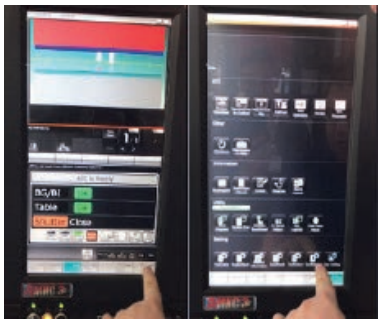
ATC Tooling from Wilson Tool is guaranteed to be 100% compatible with Amada ATC Machines and Amada ATC Tooling Profiles. All standard ATC part numbers will be recognized by the control requiring no additional programing. All special ATC tooling will have a .FEL file provided for entry into the control.

LASER MARKING

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

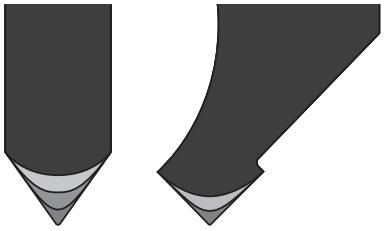
HEAT TREATMENTS

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



.FEL FILES

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



TIP MODIFICATIONS

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

PUNCHES

201 — Standard Punches

Part No. FEL	Angle	Radius mm (in.)	Height mm (in.)	Max Ton kN/m [T/m]	LX 8 x 100mm	SX 15	TX 12	X15 12 x 15mm	E L/R Ear
220 HEIGHT FAMILY									
201342	84°	3.0 (.118)	254.52 (10.020)	1000 [100]					
201262	86°	0.2 (.008)	255.91 (10.075)						
201662		0.6 (.024)	255.72 (10.68)						
201202	90°	0.2 (.008)	255.92 (10.076)						
201602		0.6 (.024)	255.75 (10.069)						
240 HEIGHT FAMILY									
201344	84°	3.0 (.118)	274.52 (10.808)	1000 [100]					
201264	86°	0.2 (.008)	275.91 (10.863)						
201664		0.6 (.024)	275.72 (10.855)						
201204	90°	0.2 (.008)	275.92 (10.863)						
201604		0.6 (.024)	275.75 (10.856)						

202 — Sash Punches

Part No. FEL	Angle	Radius mm (in.)	Height mm (in.)	Max Ton kN/m [T/m]	LX 8 x 100mm	SX 15	TX 12	X15 12 x 15mm	E L/R Ear
220 HEIGHT FAMILY									
202262	86°	0.2 (.008)	255.91 (10.075)	300 [30]					
202662		0.6 (.024)	255.72 (10.68)						
202202	90°	0.2 (.008)	255.92 (10.076)						
202602		0.6 (.024)	255.75 (10.069)						
240 HEIGHT FAMILY									
202264	86°	0.2 (.008)	275.91 (10.863)	300 [30]					
202664		0.6 (.024)	275.72 (10.855)						
202204	90°	0.2 (.008)	275.92 (10.863)						
202604		0.6 (.024)	275.75 (10.856)						

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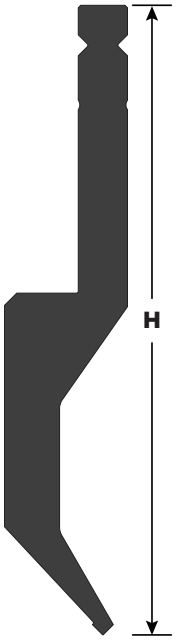
PUNCHES

203 — Straight/Sash Punches

Part No. FEL	Angle	Radius mm (in.)	Height mm (in.)	Max Ton kN/m [T/m]	LX 8 x 100mm	SX 15	TX 12	X15 12 x 15mm	E L/R Ear
220 HEIGHT FAMILY									
203262	86°	0.2 (.008)	255.91 (10.075)	1000 [100]					
203662		0.6 (.024)	255.72 (10.68)						
203202	90°	0.2 (.008)	255.92 (10.076)						
203602		0.6 (.024)	255.75 (10.069)						
240 HEIGHT FAMILY									
203264	86°	0.2 (.008)	275.91 (10.863)	1000 [100]					
203664		0.6 (.024)	275.72 (10.855)						
203204	90°	0.2 (.008)	275.92 (10.863)						
203604		0.6 (.024)	275.75 (10.856)						



204 — Gooseneck Punches

Part No. FEL	Angle	Radius mm (in.)	Height mm (in.)	Max Ton kN/m [T/m]	LX 8 x 100mm	SX 15	TX 12	X15 12 x 15mm	E L/R Ear
220 HEIGHT FAMILY									
204262	86°	0.2 (.008)	255.91 (10.075)	350 [35]					
204662		0.6 (.024)	255.72 (10.68)						
204202	90°	0.2 (.008)	255.92 (10.076)						
204602		0.6 (.024)	255.75 (10.069)						
240 HEIGHT FAMILY									
204264	86°	0.2 (.008)	275.91 (10.863)	350 [35]					
204664		0.6 (.024)	275.72 (10.855)						
204204	90°	0.2 (.008)	275.92 (10.863)						
204604		0.6 (.024)	275.75 (10.856)						

PUNCHES

205 — Robot Punches

Part No. FEL	Angle	Radius mm (in.)	Height mm (in.)	Max Ton kN/m [T/m]	LX 8 x 100mm	SX 15	TX 12	X15 12 x 15mm	E L/R Ear
220 HEIGHT FAMILY									
205262	86°	0.2 (.008)	255.91 (10.075)	300 [30]					
205662		0.6 (.024)	255.72 (10.68)						
205202	90°	0.2 (.008)	255.92 (10.076)						
205602		0.6 (.024)	255.75 (10.069)						
240 HEIGHT FAMILY									
205264	86°	0.2 (.008)	275.91 (10.863)	300 [30]					
205664		0.6 (.024)	275.72 (10.855)						
205204	90°	0.2 (.008)	275.92 (10.863)						
205604		0.6 (.024)	275.75 (10.856)						

206 — Acute Punches

Part No. FEL	Angle	Radius mm (in.)	Staging Die	Height mm (in.)	Max Ton kN/m [T/m]	LX 8 x 100mm	SX 15	TX 12	X15 12 x 15mm	E L/R Ear
220 HEIGHT FAMILY										
206262	30°	0.2 (.008)	86° Die	255.91 (10.075)	500 [50]					
206662		0.6 (.024)		255.72 (10.68)						
206202		0.2 (.008)	90° Die	255.92 (10.076)						
206602		0.6 (.024)		255.75 (10.069)						
240 HEIGHT FAMILY										
202264	30°	0.2 (.008)	86° Die	275.91 (10.863)	500 [50]					
206664		0.6 (.024)		275.72 (10.855)						
206204		0.2 (.008)	90° Die	275.92 (10.863)						
206604		0.6 (.024)		275.75 (10.856)						

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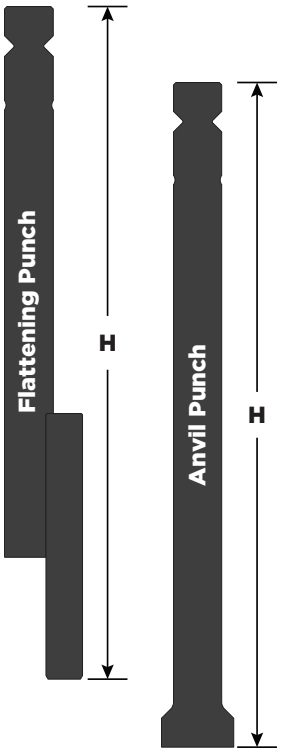
PUNCHES

208 — Straight Punches

Part No. FEL	Angle	Radius mm (in.)	Height mm (in.)	Max Ton kN/m [T/m]	LX 8 x 100mm	SX 15	TX 12	X15 12 x 15mm	E L/R Ear
220 HEIGHT FAMILY									
208342	84°	3.0 (.118)	254.52 (10.020)	1000 [100]					
208262	86°	0.2 (.008)	255.91 (10.075)						
208662		0.6 (.024)	255.72 (10.68)						
208202	90°	0.2 (.008)	255.92 (10.076)						
208602		0.6 (.024)	255.75 (10.069)						
240 HEIGHT FAMILY									
208344	84°	3.0 (.118)	274.52 (10.807)	1000 [100]					
208264	86°	0.2 (.008)	275.91 (10.863)						
208664		0.6 (.024)	275.72 (10.855)						
208204	90°	0.2 (.008)	275.92 (10.863)						
208604		0.6 (.024)	275.75 (10.856)						



209 — Flattening Punches

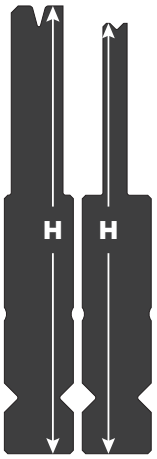
Part No. FEL	Height mm (in.)	Max Ton kN/m [T/m]	LX 8 x 100mm	SX 15	TX 12	X15 12 x 15mm	E L/R Ear
220 HEIGHT FAMILY							
209942	222.9 (8.776)	1000 [100]			N/A	N/A	N/A
240 HEIGHT FAMILY							
209944	242.9 (9.564)	1000 [100]			N/A	N/A	N/A

Anvil Punches

Part No. FEL	Height mm (in.)	Max Ton kN/m [T/m]	LX 8 x 100mm	SX 15	TX 12	X15 12 x 15mm	E L/R Ear
220 HEIGHT FAMILY							
209992	256 (10.079)	1000 [100]			N/A	N/A	N/A
240 HEIGHT FAMILY							
209994	276 (10.866)	1000 [100]			N/A	N/A	N/A

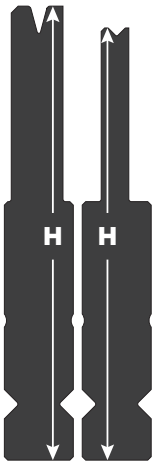
The anvil punches are a Wilson Tool exclusive design that has been optimized in height to reduce delays in production.

DIES



V4 Dies

Part No. FEL	V mm (in.)	SR mm (in.)	Height mm (in.)	Description	Max Ton kN/m [T/m]	LX 8 x 100mm	SX 15	TX 12	X15 12 x 15mm
30° ANGLE									
887439	4 (.157)	1.0 (.039)	129.87 (5.113)	Staging Punch 86° / .2 Rad.	200 [20]				
897439			128.91 (5.075)	Staging Punch 86° / .6 Rad.					
887479			129.87 (5.113)	Staging Punch 90° / .2 Rad.					
897479			128.89 (5.074)	Staging Punch 90° / .6 Rad.					
86° ANGLE									
887469	4 (.157)	0.4 (.016)	125.03 (4.922)	Full Body	400 [40]				
897469		1.0 (.039)							
90° ANGLE									
887409	4 (.157)	0.4 (.016)	124.89 (4.917)	Narrow Body	400 [40]				
897409		1.0 (.039)							
887419		0.4 (.016)		Full Body	1000 [100]				
897419		1.0 (.039)							



V5 Dies

Part No. FEL	V mm (in.)	SR mm (in.)	Height mm (in.)	Description	Max Ton kN/m [T/m]	LX 8 x 100mm	SX 15	TX 12	X15 12 x 15mm
30° ANGLE									
887539	5 (.197)	1.0 (.039)	131.74 (5.187)	Staging Punch 86°/.2 Rad.	190 [19]				
897539			130.78 (5.149)	Staging Punch 86°/.6 Rad.					
887579			131.73 (5.186)	Staging Punch 90°/.2 Rad.					
897579			130.75 (5.148)	Staging Punch 90°/.6 Rad.					
86° ANGLE									
887569	5 (.197)	0.4 (.016)	125.57 (4.944)	Full Body	500 [50]				
897569		1.0 (.039)							
90° ANGLE									
887509	5 (.197)	0.4 (.016)	125.39 (4.937)	Narrow Body	500 [50]				
897509		1.0 (.039)							
887519		0.4 (.016)		Full Body	1000 [100]				
897519		1.0 (.039)							

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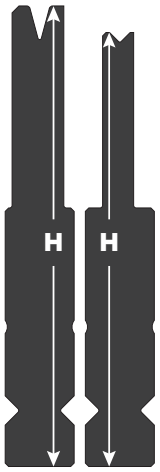
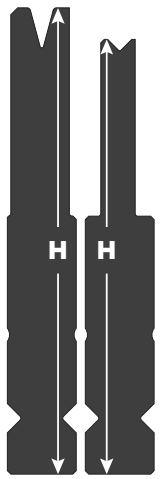
DIES



V6 Dies

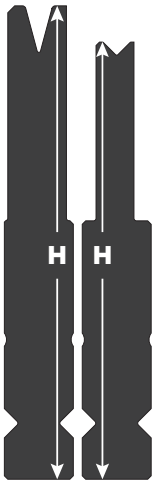
Part No. FEL	V mm (in.)	SR mm (in.)	Height mm (in.)	Description	Max Ton kN/m [T/m]	LX 8 x 100mm	SX 15	TX 12	X15 12 x 15mm
30° ANGLE									
887639	6 (.236)	1.0 (.039)	133.61 (5.260)	Staging Punch 86°/.2 Rad.	180 [18]				
897639			132.65 (5.222)	Staging Punch 86°/.6 Rad.					
887679			133.6 (5.260)	Staging Punch 90°/.2 Rad.					
897679			132.62 (5.221)	Staging Punch 90°/.6 Rad.					
86° ANGLE									
887669	6 (.236)	0.4 (.016)	126.11 (4.965)	Full Body	500 [50]				
897669		1.5 (.060)							
90° ANGLE									
887609	6 (.236)	0.4 (.016)	125.89 (4.956)	Narrow Body	550 [55]				
897609		1.5 (.060)							
887619		0.4 (.016)		Full Body	1000 [100]				
897619		1.5 (.060)							



V7 Dies

Part No. FEL	V mm (in.)	SR mm (in.)	Height mm (in.)	Description	Max Ton kN/m [T/m]	LX 8 x 100mm	SX 15	TX 12	X15 12 x 15mm
30° ANGLE									
887739	7 (.276)	1.0 (.039)	135.47 (5.333)	Staging Punch 86°/.2 Rad.	200 [20]				
897739			134.51 (5.296)	Staging Punch 86°/.6 Rad.					
887779			135.47 (5.333)	Staging Punch 90°/.2 Rad.					
897779			134.49 (5.295)	Staging Punch 90°/.6 Rad.					
86° ANGLE									
887769	7 (.276)	0.5 (.020)	126.64 (4.986)	Full Body	600 [60]				
897769		1.5 (.060)							
90° ANGLE									
887709	7 (.276)	0.5 (.020)	126.39 (4.976)	Narrow Body	600 [60]				
897709		1.5 (.060)							
887719		0.5 (.020)		Full Body	1000 [100]				
897719		1.5 (.060)							

DIES



V8 Dies

Part No. FEL	V mm (in.)	SR mm (in.)	Height mm (in.)	Description	Max Ton kN/m [T/m]	LX 8 x 100mm	SX 15	TX 12	X15 12 x 15mm
30° ANGLE									
887839	8 (.315)	1.0 (.039)	137.39 (5.409)	Staging Punch 86° / .2 Rad.	200 [20]				
897839			136.38 (5.369)	Staging Punch 86° / .6 Rad.					
887879			137.33 (5.407)	Staging Punch 90° / .2 Rad.					
897879			136.35 (5.368)	Staging Punch 90° / .6 Rad.					
86° ANGLE									
887869	8 (.315)	0.5 (.020)	127.18 (5.007)	Full Body	650 [65]				
897869		1.5 (.060)							
90° ANGLE									
887809	8 (.315)	0.5 (.020)	126.89 (4.996)	Narrow Body	650 [65]				
897809		1.5 (.060)							
887819		0.5 (.020)		Full Body	1000 [100]				
897819		1.5 (.060)							

V10 Dies

Part No. FEL	V mm (in.)	SR mm (in.)	Height mm (in.)	Description	Max Ton kN/m [T/m]	LX 8 x 100mm	SX 15	TX 12	X15 12 x 15mm
30° ANGLE									
888039	10 (.394)	1.0 (.039)	141.07 (5.554)	Staging Punch 86°/.2 Rad.	260 [26]				
898039			140.11 (5.516)	Staging Punch 86°/.6 Rad.					
888079			141.06 (5.554)	Staging Punch 90°/.2 Rad.					
898079			140.08 (5.515)	Staging Punch 90°/.6 Rad.					
86° ANGLE									
888069	10 (.394)	0.6 (.024)	128.25 (5.049)	Full Body	900 [90]				
898069		2.0 (.079)							
90° ANGLE									
888009	10 (.394)	0.6 (.024)	127.89 (5.035)	Narrow Body	900 [90]				
898009		2.0 (.079)							
888019		0.6 (.024)		Full Body	1000 [100]				
898019		2.0 (.079)							

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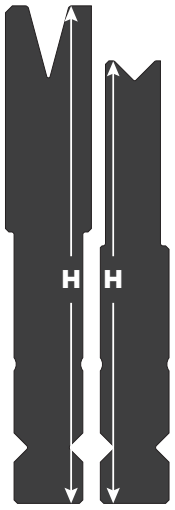
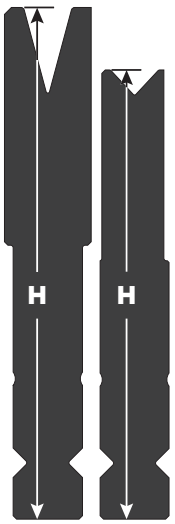
DIES



V12 Dies

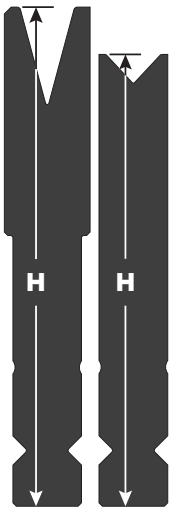
Part No. FEL	V mm (in.)	SR mm (in.)	Height mm (in.)	Description	Max Ton kN/m [T/m]	LX 8 x 100mm	SX 15	TX 12	X15 12 x 15mm
30° ANGLE									
881239	12 (.472)	1.0 (.039)	144.8 (5.701)	Staging Punch 86°/.2 Rad.	250 [25]				
891239			143.84 (5.663)	Staging Punch 86°/.6 Rad.					
881279			144.8 (5.701)	Staging Punch 90°/.2 Rad.					
891279			143.82 (5.662)	Staging Punch 90°/.6 Rad.					
86° ANGLE									
888269	12 (.472)	0.8 (.032)	129.32 (5.091)	Full Body	1000 [100]				
898269		2.5 (.098)							
90° ANGLE									
888209	12 (.472)	0.8 (.032)	128.89 (5.074)	Full Body	1000 [100]				
898209		2.5 (.098)							



V14 Dies

Part No. FEL	V mm (in.)	SR mm (in.)	Height mm (in.)	Description	Max Ton kN/m [T/m]	LX 8 x 100mm	SX 15	TX 12	X15 12 x 15mm
30° ANGLE									
881439	14 (.551)	1.0 (.039)	148.53 (5.848)	Staging Punch 86°/.2 Rad.	200 [20]				
891439			147.57 (5.810)	Staging Punch 86°/.6 Rad.					
881479			148.53 (5.848)	Staging Punch 90°/.2 Rad.					
891479			147.55 (5.809)	Staging Punch 90°/.6 Rad.					
86° ANGLE									
888469	14 (.551)	0.8 (.032)	130.4 (5.134)	Full Body	1000 [100]				
898469		2.5 (.098)							
90° ANGLE									
888409	14 (.551)	0.8 (.032)	129.89 (5.114)	Full Body	1000 [100]				
898409		2.5 (.098)							

DIES



V16 Dies

Part No. FEL	V mm (in.)	SR mm (in.)	Height mm (in.)	Description	Max Ton kN/m [T/m]	LX 8 x 100mm	SX 15	TX 12	X15 12 x 15mm
30° ANGLE									
831849	16 (.630)	1.0 (.039)	145.64 (95.734)	Staging Punch 84°/.3 Rad.	180 [18]				
861869			151.31 (5.957)	Staging Punch 86°/.6 Rad.					
86° ANGLE									
881669	16 (.630)	0.8 (.032)	131.47 (5.176)	Full Body	1000 [100]				
891669		2.5 (.098)							
90° ANGLE									
881609	16 (.630)	0.8 (.032)	130.89 (5.153)	Full Body	1000 [100]				
891609		2.5 (.098)							

V18 Dies

Part No. FEL	V mm (in.)	SR mm (in.)	Height mm (in.)	Description	Max Ton kN/m [T/m]	LX 8 x 100mm	SX 15	TX 12	X15 12 x 15mm
86° ANGLE									
881869	18 (.709)	1.0 (.039)	132.54 (5.218)	Full Body	1000 [100]				
891869		2.5 (.098)							
90° ANGLE									
881809	18 (.709)	1.0 (.039)	131.89 (5.193)	Full Body	1000 [100]				
891809		2.5 (.098)							

V20 Dies

Part No. FEL	V mm (in.)	SR mm (in.)	Height mm (in.)	Description	Max Ton kN/m [T/m]	LX 8 x 100mm	SX 15	TX 12	X15 12 x 15mm
86° ANGLE									
882069	20 (.787)	1.0 (.039)	133.61 (5.260)	Full Body	1000 [100]				
892069		3.0 (.118)							
90° ANGLE									
882009	20 (.787)	1.0 (.039)	132.89 (5.232)	Full Body	1000 [100]				
892009		3.0 (.118)							

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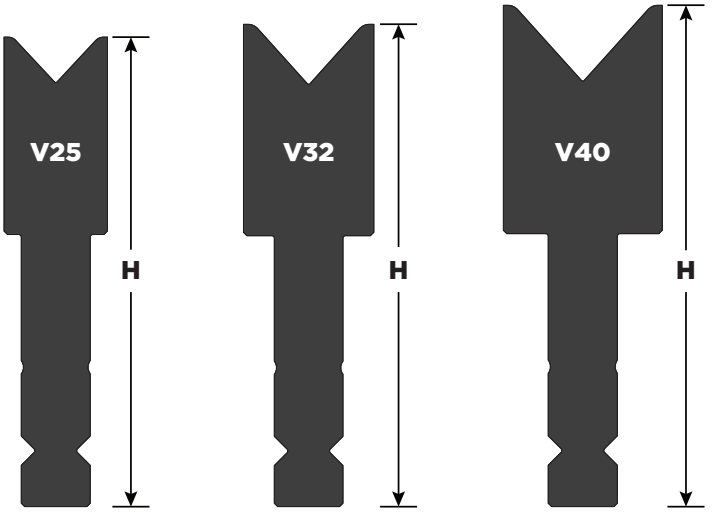
DIES



V25 Dies

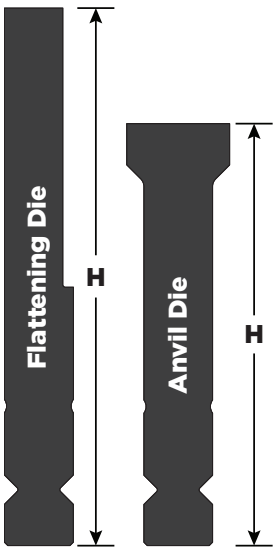
Part No. FEL	V mm (in.)	SR mm (in.)	Height mm (in.)	Description	Max Ton kN/m [T/m]	LX 8 x 100mm	SX 15	TX 12	X15 12 x 15mm
86° ANGLE									
892569	25 (.984)	3.0 (.118)	136.29 (5.366)	Full Body	1000 [100]				

V32 Dies

Part No. FEL	V mm (in.)	SR mm (in.)	Height mm (in.)	Description	Max Ton kN/m [T/m]	LX 8 x 100mm	SX 15	TX 12	X15 12 x 15mm
84° ANGLE									
893249	32 (1.260)	4.0 (.157)	140.66 (5.538)	Full Body	1000 [100]				

V40 Dies

Part No. FEL	V mm (in.)	SR mm (in.)	Height mm (in.)	Description	Max Ton kN/m [T/m]	LX 8 x 100mm	SX 15	TX 12	X15 12 x 15mm
84° ANGLE									
884049	40 (1.575)	4.0 (.157)	145.1 (5.713)	Full Body	1000 [100]				



Flattening Die

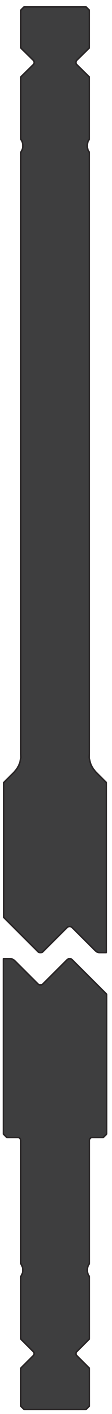
Part No. FEL	Height mm (in.)	Description	Max Ton kN/m [T/m]	LX 8 x 100mm	SX 15	TX 12	X15 12 x 15mm
889969	156 (6.142)	Full Body	1000 [100]			N/A	N/A

Anvil Die

Part No. FEL	Height mm (in.)	Description	Max Ton kN/m [T/m]	LX 8 x 100mm	SX 15	TX 12	X15 12 x 15mm
889999	122.9 (4.838)	Full Body	1000 [100]			N/A	N/A

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

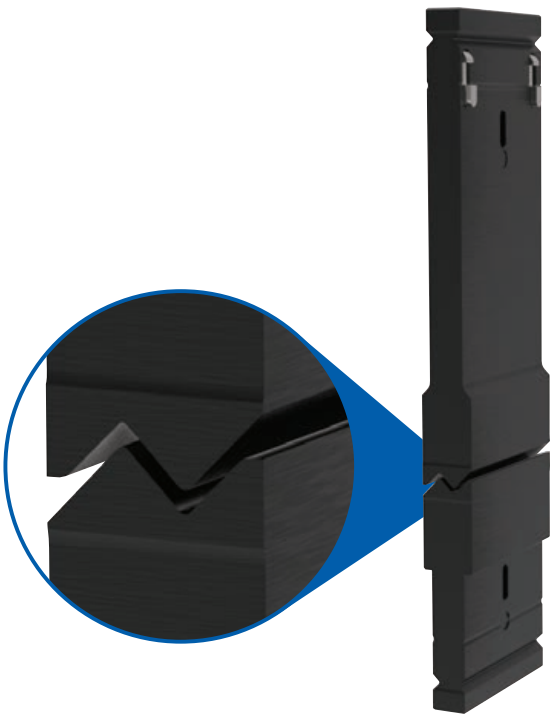
STAGED OFFSET



Offset – Metric Solid Body

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

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



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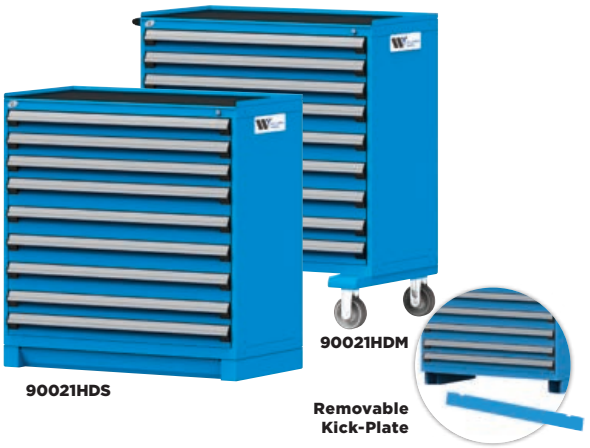
ACCESSORIES

TOOL STORAGE CABINET	DESCRIPTION



- Nine drawer lay-down tool storage cabinet allows visibility of laser marking for easy tool identification
- Solid steel construction
- Mobile base option with side handle has heavy-duty casters and extended wheel base to prevent tipping
- One-drawer-at-a-time integrated locking
- Stationary cabinets have a removable kick-plate for fork lift transportation
- Rated capacity of 3,600 lbs.
- Retainer top with rubber mat
- Total weight capacity: 440 lbs. per drawer

Cat. No.	Lead Time	Height	Width	Depth	Drawers Sizes
90021HDS	5-15 Days	49.0″	48.0″	27.0″	5 - 2.25″ [57.1mm] 4 - 3.25″ [82.5mm]
90021HDM		53.5″	48.0″	27.0″	

Ships via truck freight. Additional tooling cabinets available.

CUSTOM COLOR OPTIONS

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

Colors may differ slightly from those shown. Allow 15 working days lead time for custom colors.

XTREME STORAGE CABINETS	DESCRIPTION

55130
3 Drawers

55131
5 Drawers

- Vertical cabinet drawers are easily accessible from either side
- Each drawer contains three 7-inch wide shelves that hold up to 265 lbs. (120kg) each
- Each drawer contains a shallow top tray with adjustable dividers for storage of measurement devices, hand tools, etc.
- Flexible, adjustable trays and inserts can accommodate various tooling sizes and styles
- Punches are held securely in tip-up position
- Small footprint allows for easy placement of tools close to machines

Cat. No.	Number of Drawers	Cabinet Height (outside dim.)	Width — Left to Right (outside dim.)	Depth — Front to Back (outside dim.)	Number of Tool Trays	Total Length* of Tooling	
						1 Tool/Tray (inside dim.)	2 Tools/Tray (inside dim.)
55130 (XSC312)	3	48.8″ [1.24m]	26.0″ [0.66m]	41.3″ [1.05m]	9	Up to 31 ft. [9.44m]	Up to 62 ft. (18.9m]
55131 (XSC512)	5	48.8″ [1.24m]	40.9″ [1.04m]	41.3″ [1.05m]	15	Up to 51.5 ft. [15.7m)	Up to 103 ft. [31.4m]

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

ACCESSORIES

MAGNETIC SQUARING ARM

Increase bending accuracy with this simple hand tool. Suitable for any press brake die with a flat surface for easy attachment. Adjustable from 0° or 90° and is available in a left-handed or right-handed version.

Part No.	Description
42750L	Magnetic Squaring Arm LEFT
42750R	Magnetic Squaring Arm RIGHT
42750A	30° Die Adapter

URETHANE ROLLS — 6 in. x 100 ft.

Part No.	Thickness	Durometer	Description
42530	.015" [.4mm]	85A (Milky White)	• More elastic than blue • Well suited for deeper draw applications • Will not last as long as blue for 90° bends
42531	.030" [.8mm]		
42532	.022" [.56mm]	95A (Blue)	• A more ridged solution • Lasts considerably longer than the white options in many applications • Harder and less elastic than blue • Not suited for deeper draw applications

Note: This is not a good time to cheat the V-opening and make it smaller. Keep in mind you are filling the V-opening with two thicknesses of urethane so it would be safer to oversize the V-opening a bit. The larger the shoulder radius, the larger the V-opening relative to the material type and thickness, the longer the life will be realized.

MAGNET SQUARE

ON/OFF work holding magnet. 150 lb. [70 kg] of hold force. Size: [30] Square

Part No. 974150

PROTECTIVE FABRIC DRAPE

Forms a protective barrier between the sheet metal and the die shoulders during the bending process. Lasts 5–8 times longer than a urethane drape.

Part No.	Description
55335	12.5m [41'] length x 120mm [4.7"] width
55337	12.5m [41'] length x 240mm [9.5"] width
988156	3/8" x 1/2" Cylinder Magnet w/Blue Grip Cover

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AIR BENDING FORCE CHART

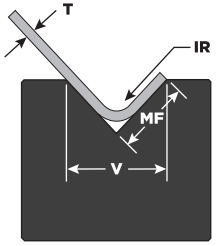
METRIC V-OPENINGS & IMPERIAL TONNAGE

NOTE: Formulas and chart are for reference only.

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

STANDARD FORMULAS FOR SELECTING A V-OPENING

Material Thickness: 2.6mm or Less = T x 6
3.00mm – 8.0mm = T x 8
9.00mm – 12.00mm = T x 10
14.00mm & Thicker = T x 12



GAUGE	DEC. inch	[mm]																	
			V (mm)	4	6	7	8	10	12	14	16	18	20	25	32	40	50	63	80	100	125
			V (in.)	0.157	0.236	0.276	0.315	0.394	0.472	0.551	0.630	0.709	0.787	0.984	1.260	1.575	1.969	2.480	3.150	3.937	4.921
			MF	0.110	0.165	0.193	0.220	0.276	0.331	0.397	0.454	0.510	0.567	0.709	0.945	1.181	1.476	1.860	2.362	2.953	3.789
			IR	0.026	0.039	0.046	0.052	0.066	0.079	0.092	0.105	0.118	0.131	0.164	0.210	0.262	0.328	0.413	0.525	0.656	0.820
20	0.036	[.9]	TONS PER FOOT	5.4	**3.6**	3.0	2.5	2.0	1.7												
18	0.048	[1.2]			7.2	**5.8**	4.8	3.7	2.7	2.4	2.0										
16	0.060	[1.5]					7.8	**6.0**	5.0	4.2	3.5	3.1	2.7								
14	0.075	[1.9]						11.3	**7.5**	7.1	5.6	4.8	4.1	3.2							
13	0.090	[2.3]							12.5	**10.1**	8.2	7.2	5.4	3.7							
12	0.105	[2.7]							15.8	13.0	10.5	**9.5**	7.5	5.6	4.0						
11	0.120	[3]									16.1	13.1	10.1	**7.2**	5.0	3.8					
10	0.135	[3.4]											12.0	**8.1**	6.2	4.7	3.5				
9	0.150	[3.8]												13.1	**9.0**	6.7	5.2				
3/16″	0.188	[4.8]												24.1	15.0	**11.3**	7.5	5.8			
1/4″	0.250	[6.35]													30.0	20.0	**15.0**	10.5	8.5		
5/16″	0.313	[8]														37.6	25.0	**18.8**	13.1	10.0	
3/8″	0.375	[9.5]															38.3	28.1	22.5	**15.0**	11.3
7/16″	0.438	[11.1]																35.0	28.0	24.0	**17.0**
1/2″	0.500	[12.7]																52.0	39.0	30.0	**22.0**
5/8″	0.625	[16]																	70.0	52.5	37.5
3/4″	0.750	[19]																			66.0
1″	1.000	[25.4]																			

Larger v-openings generate less tonnage.

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

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

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Tonnage Estimation Based on Material Type	
	Soft Aluminum, Brass, Copper = Tons x 0.35
	Half Hard Aluminum = Tons x 0.5
	Hard/Heat Treated AL, Mild Steel = Tons x 1.0
	Half Hard Brass, Copper = Tons x 1.1
	Stainless Steel = Tons x 1.5
	High Strength Steel = Tons x 2.75

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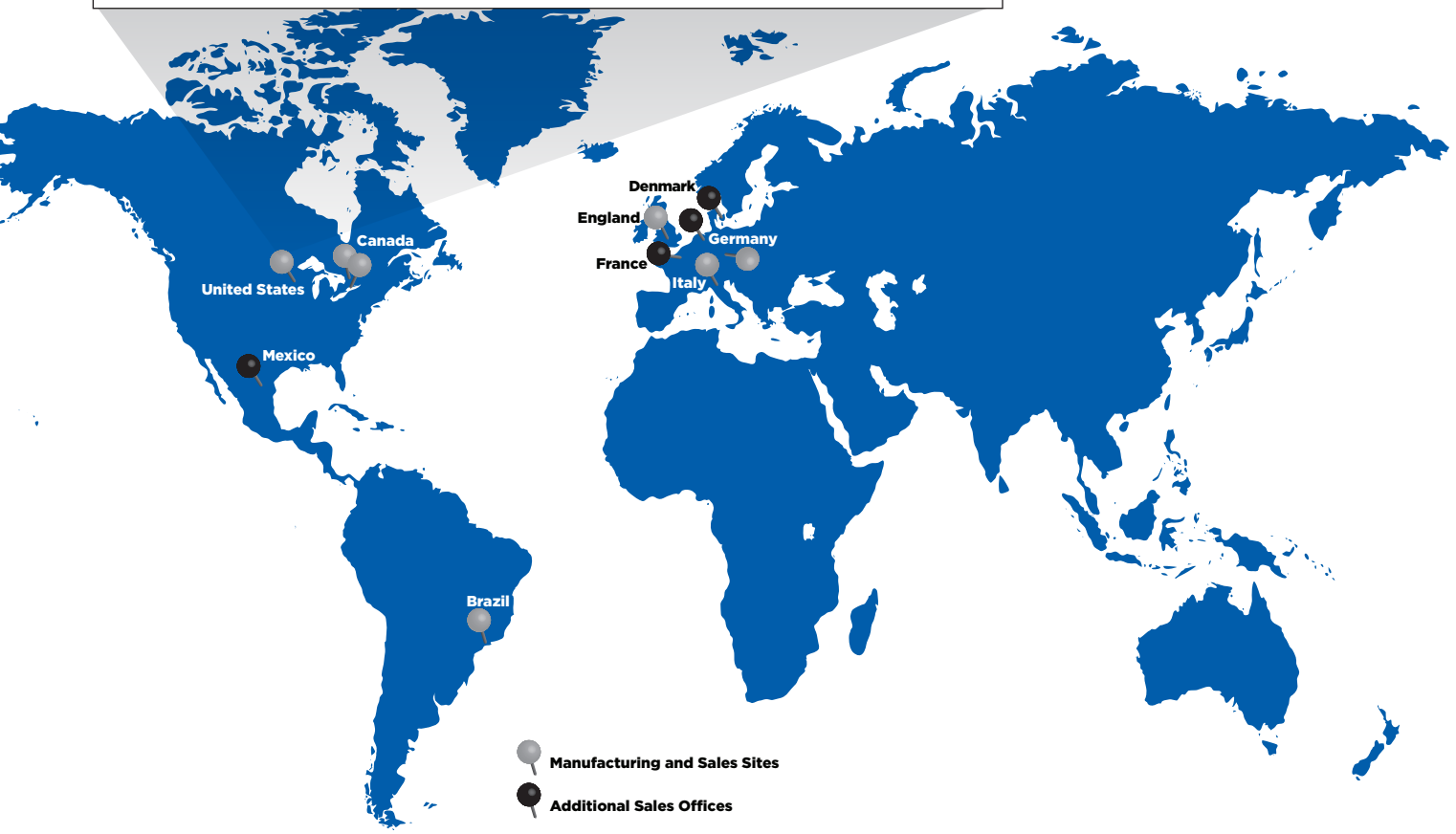

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