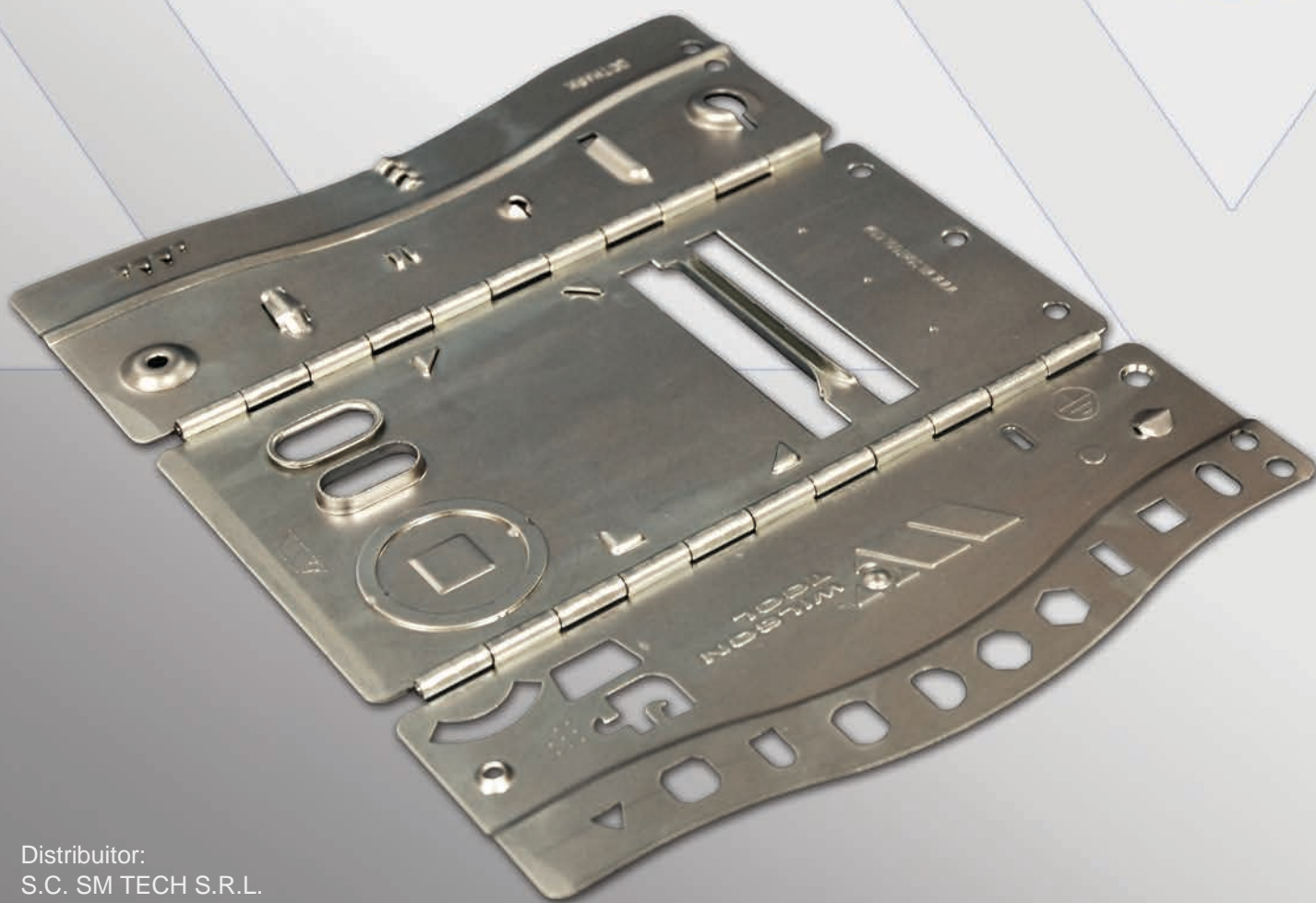


FORMING MADE EASY

Cateva exemple de aplicatii forming pentru masini Trumpf TruPunch / Trumatic sau compatibile

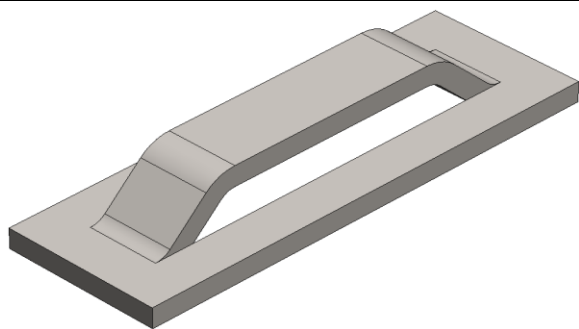


Distribuitor:
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Bridge Lance & Form - Single



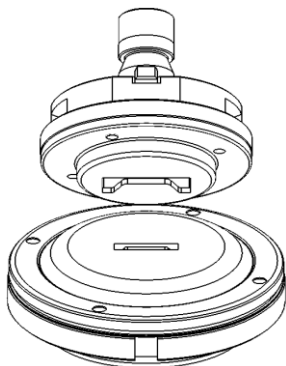
Typical Applications:-

- Cable guides
- Card holders
- Ventilation slots

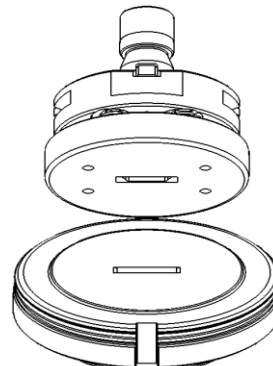
Wilson Tool Advantages:-

- Built-in alignment ring
- Replaceable cutting components for cost effective change of working parts
- Positive ejection for fast & reliable stripping performance
- Special coated die cap to reduce sheet marking
- Steel compression springs used for maximum life & reliability

Form Up



Form Down



Price

€ 1,181

Delivery

3 Days

Cat N°

25114

Price

€ 1,181

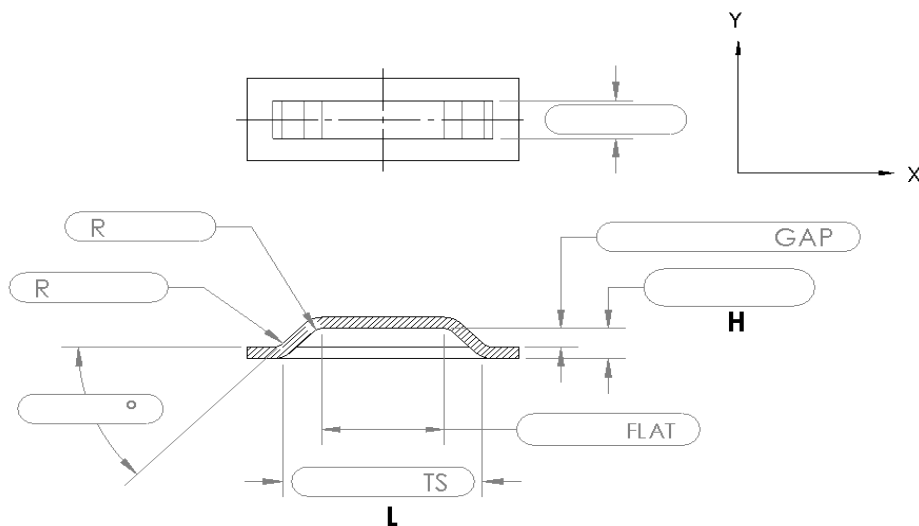
Delivery

5 Days

Cat N°

26805

Alternatively send a CAD file or drawing in any format of your choice



Company Name

Customer Number (If Known)

Contact Person

- ☐ Quote Only
☐ Order Number (Specify)

Machine Type & Model

Material Type

- ☐ AL ☐ MS ☐ SS
☐ Other _____

Sheet Thickness (S)

Form Direction

- ☐ Upwards ☐ Downwards

Other Forms Close By

- ☐ No
☐ Yes X = Y =

OptiGlide Die Cap (Up Only)

- ☐ Yes (Add £50) ☐ No

Coated Insert

- ☐ Yes ☐ No

Ultima Insert

- ☐ Yes ☐ No

Tool ID Marking (Specify)

Maximum Dimensions

for applications exceeding these sizes please contact us for alternative solutions (price & delivery indicated may vary)

S = Sheet Thickness

Form Up

L = 40

H = 7.7

S = 3.0

Form Down

L = 30

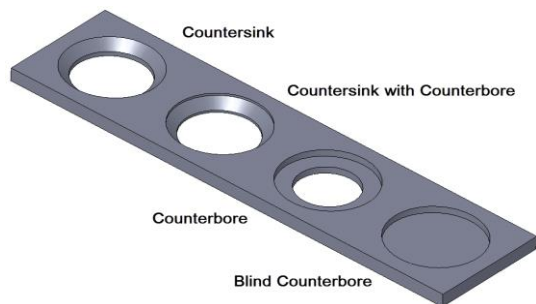
H = 4.5

S = 2.0

Ordering Tips & Advice:-

- **Important - Advise if any specific tolerances apply to any dimensions**
- Custom variations available e.g. doubles, lead-ins at one or both ends, differing geometries to that shown
- To ensure tool integrity keep a minimum 5mm between bridges, if this is not possible order a double bridge
- Try to keep side angles to a maximum 45°
- Bend radii should be a minimum R0.8mm
- Lubricate the sheet prior to forming using Xcel™ spray helps material flow more easily
- Use OptiGlide™ die cap to reduce sheet marking on the underside of the sheet if upwards forming
Extra £50 charge and 1 extra day delivery apply
- Coated inserts improve performance by reducing galling and improving surface hardness to increase hit count between regrinds
- Ultima™ powdered steel inserts help further enhance cutting edge longevity to maximise tool life

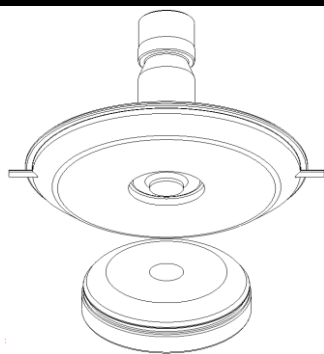
Countersink & Counterbore - Round



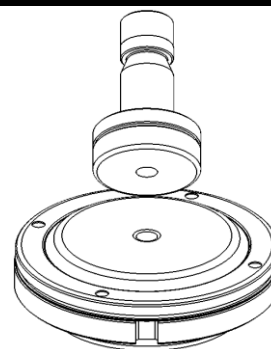
Typical Applications:-

- Non cutting process for screws & rivets, remove secondary processes

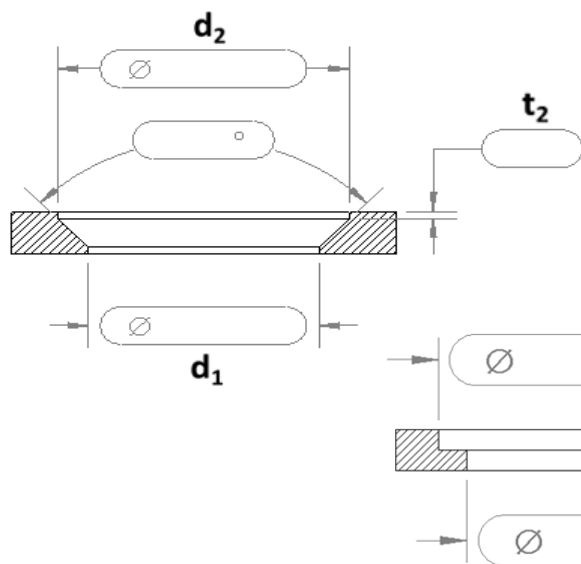
Form Down



Form Up



Size	Tool Type	Cat No°	Price	Delivery	Cat No°	Price	Price
1	Inserted	25331	€ 389	2 Days	25565	€ 623	2 Days
1	Solid	25115	€ 267				
2		S490	€ 558				



see table at bottom of page for dimensions d_1 d_2 & t_2

Company Name

Customer Number (If Known)

Contact Person

- ☐ Quote Only
☐ Order Number (Specify)

Machine Type & Model

Material Type

- ☐ AL ☐ MS ☐ SS
☐ Other _____

Sheet Thickness (S)

Ordering Tips & Advice:-

- Important - Advise if any specific tolerances apply to any dimensions
- Solid style is default for countersinks in materials 3mm and above and all sizes of counterbore
- Ø10 maximum d_2 dimension for inserted option
- Ordering with pilot helps control hole shape and size
- Lubricate the sheet prior to forming using Xcel™ spray to help the material flow more easily
- Optiglide™ die cap reduces sheet marking on the underside of the sheet when upforming (adds £50 & 1 day)
- Tool with pilot helps control and maintain hole size & shape consistency

DIN 74										
Screw Size	Slotted or Philips Headed Screws					Hexagon Socket Headed Screws				
	Medium Type (m)		Fine Type (f)			Medium Type (m)		Fine Type (f)		
	d_1	d_2	d_1	d_2	t_2	d_1	d_2	d_1	d_2	t_2
M3	3.4	6.5	3.2	6.0	0.25	3.4	6.6	3.2	6.3	0.20
M4	4.5	8.6	4.3	8.0	0.30	4.5	9.0	4.3	8.3	0.30
M5	5.5	10.4	5.3	10.0	0.20	5.5	11.0	5.3	10.4	0.30
M6	6.6	12.4	6.4	11.5	0.45	6.6	13.0	6.4	12.4	0.30
M8	9.0	16.4	8.4	15.0	0.70	9.0	17.2	8.4	16.5	0.40
M10	11.0	20.4	10.5	19.0	0.70	11.0	21.5	10.5	20.5	0.50

d_1 may not be achievable if material is too thin

Form Direction

- ☐ Downwards ☐ Upwards

OptiGlide Die Cap (Up Only)

- ☐ Yes (adds €75 & 1 extra day)
☐ No

Punch Style

- ☐ Classic
☐ Alignment Ring Required
☐ 241
☐ 241 Holder Required

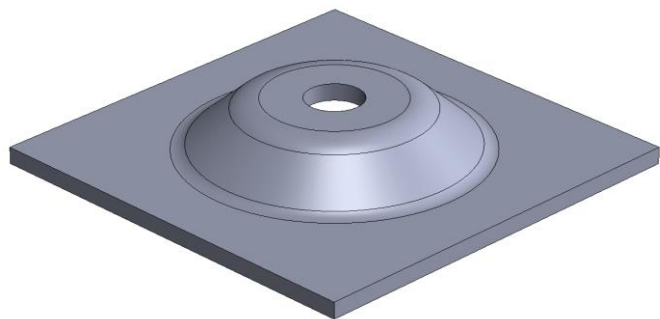
Stripper type (Down Only)

- ☐ Steel - Standard
☐ Urethane - Optional

Pilot Required

- ☐ Yes ☐ No

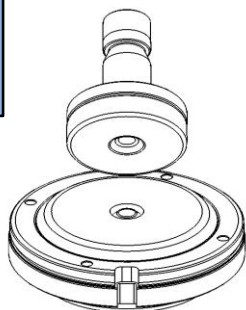
Embossing - Round / Upwards Direction



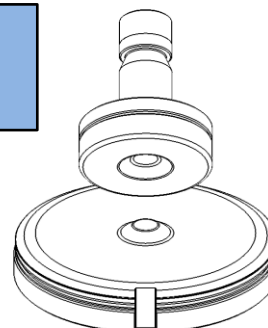
Typical applications:

- Mounting location
- Spacers and stand offs
- Architectural effects
- Depressions to captivate or hide components
- Drainage outlets
- Anti-slip tread plates

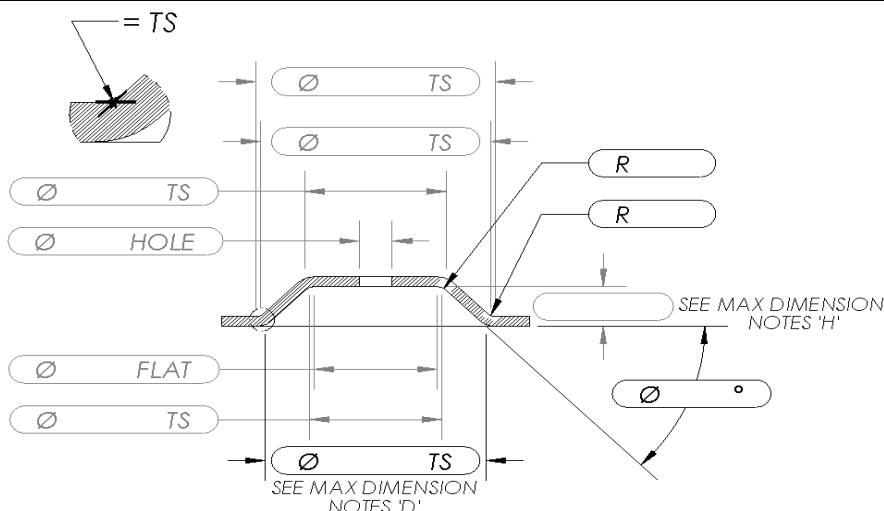
With Stripping



Without Stripping



Tooling Size	Price	Delivery	Cat N°	Tooling Size	Price	Delivery	Cat N°
Size 1	€ 526	2 Days	25176	Size 1	€ 370	2 Days	25194
Size 2	€ 941		25195	Size 2	€ 430		25143



Company Name

Customer Number (If Known)

Contact Person

- ☐ Quote Only
- ☐ Order Number (Specify)

Machine Type & Model

Material Type

- ☐ AL ☐ MS ☐ SS
- ☐ Other _____

Sheet Thickness (S)

Lower Unit Stripping

- ☐ Yes ☐ No

Other Forms Close By

- ☐ Yes (Add £50 & Inc Sketch) ☐ No

OptiGlide Die Cap

- ☐ Yes (Add £50) ☐ No

Punch Style:-

- ☐ Classic
- ☐ Alignment Ring Required
- ☐ 2·4·1
- ☐ 2·4·1 Holder Required

Tool ID Marking (Specify)

Maximum Dimensions

for applications exceeding these sizes please contact us for alternative solutions

S = Sheet Thickness

With Stripping

Size 1	Size 2
D = Ø20	D = Ø50
H = 3	H = 7.7
S = 1.5	S = 3

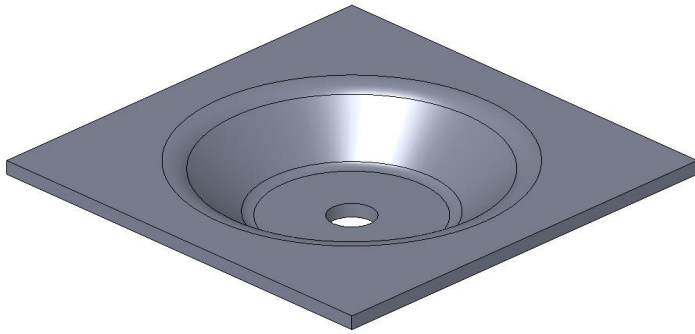
Without Stripping

Size 1	Size 2
D = Ø15	D = Ø40
H = 5	
S = 3	

Ordering Tips & Advice

- **With stripping** option protects tool, helps keep sheets flatter, allows the sheet safe travel over the tool and reduces marking on underside of sheet
- **Important - Advise if any specific tolerances apply to any dimensions**
- Minimum recommended bend radii = Height ÷ Sheet Thickness x 0.8
- Keeping side wall angle 45° or less helps reduce the risk of form splitting
- Adding a hole in the centre can help minimise risk of forms splitting by reducing stretching around bend radius
- Lubricate the sheet prior to forming using Xcel™ spray helps material flow more easily
- Use OptiGlide™ die cap to reduce sheet marking on the underside of the sheet
Extra £50 charge and 1 extra day delivery apply
- Hole can be punched after forming if tight tolerance required - Ask for details
- Keep a minimum 4X sheet thickness between hole & radius to stop the top of form springing upwards

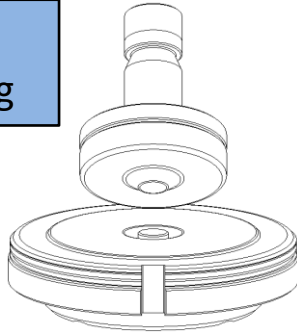
Embossing - Round / Downwards Direction



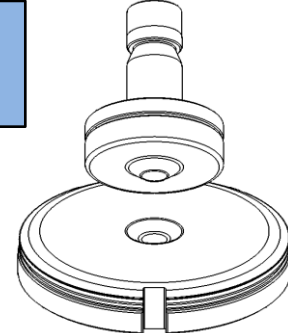
Typical applications:

- Mounting locations
- Spacers and stand offs
- Architectural effects
- Depressions to captivate or hide components
- Drainage outlets

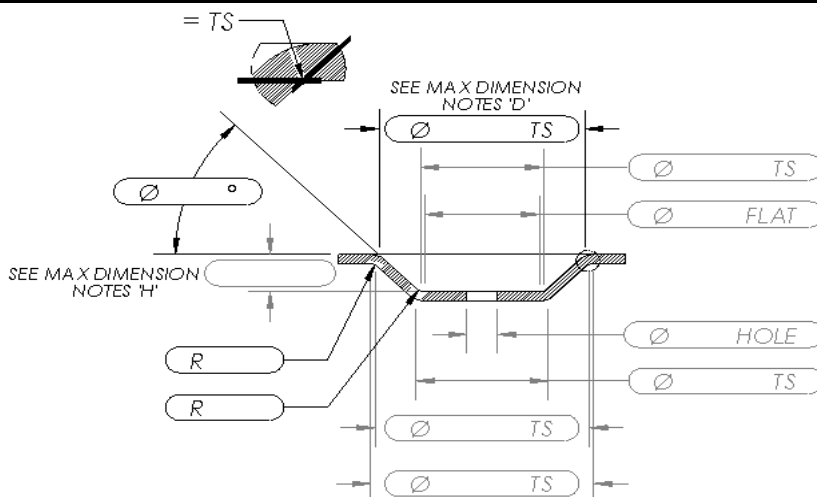
With Stripping



Without Stripping



Tooling Size	Price	Delivery	Cat N°	Tooling Size	Price	Delivery	Cat N°
Size 1	N/A			Size 1	€ 370	2 Days	25353
Size 2	€ 756	2 Days	25191	Size 2	€ 420	3 Days	25174



Provide as much detail as possible - Alternatively send a CAD or drawing in any format of your choice
Unspecified dimensions will be as recommended by Wilson Tool

Company Name

Customer Number (If Known)

Contact Person

- ☐ Quote Only
☐ Order Number (Specify)

Machine Type & Model

Material Type

- ☐ AL ☐ MS ☐ SS
☐ Other

Sheet Thickness (S)

Lower Unit Stripping

- ☐ Yes ☐ No

Other Forms Close By

- ☐ Yes (Add £50 & Inc Sketch) ☐ No

Punch Style

- ☐ Classic
☐ Alignment Ring Required
☐ 2-4-1
☐ 2-4-1 Holder Required

Tool ID Marking (Specify)

Maximum Dimensions

for applications exceeding these sizes please contact us for alternative solutions

S = Sheet Thickness

With Stripping

Size 1

Size 2

N/A

D = Ø40

H = 4.5

S = 2

Without Stripping

Size 1

Size 2

D = Ø15

D = Ø50

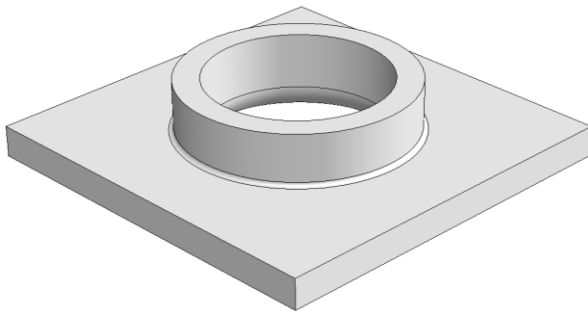
H = 6

S = 5

Ordering Tips & Advice:-

- With stripping option recommended if angle > 55° so form can lift out of the lower unit without sticking
- **Important - Advise if any specific tolerances apply to any dimensions**
- Minimum recommended bend radii = Height ÷ Sheet Thickness x 0.8
- Keeping side wall angle 45° or less helps reduce the risk of form splitting
- Adding a hole in the centre can help minimise risk of forms splitting by reducing stretching around bend radius
- Lubricate the sheet prior to forming using Xcel™ spray helps material flow more easily
- Hole can be punched after forming if tight tolerance required - Ask for details
- Keep a minimum 4X sheet thickness between hole & radius to stop the top of form springing upwards

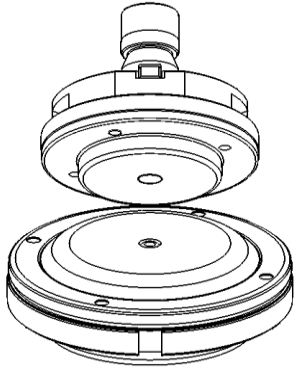
Extrusion - Round



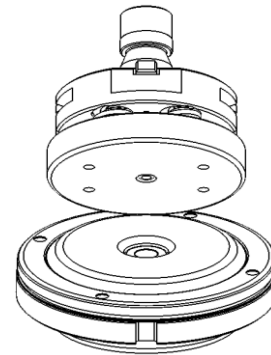
Typical Applications:-

- Alternative to separate insert fasteners when threaded
- Cable guides
- Guide for tubes and pipes
- Anti-slip plates
- Stops or locators
- Drainage or ventilation holes with safe edge

Form Up

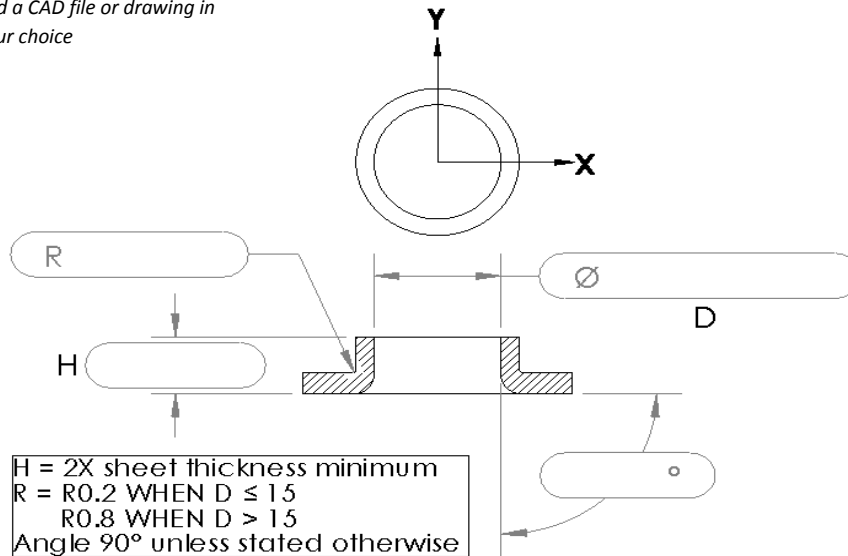


Form Down



Price	Cat N°		Delivery	Price	Cat N°	Machine Models	Delivery
€ 726	25144	Ø15 MAX	3 Days	€ 695	25707	240, 260, 200, 500 & 600	5 Days
€ 765	25438	Ø15.01 - Ø40		€ 493	26823	1000, 2000, 3000, 5000, 6000 & 7000	

Alternatively send a CAD file or drawing in any format of your choice



Company Name:-

Customer Number (If Known):-

Contact Person:-

- ☐ Quote Only
☐ Order Number (Specify)

Machine Type & Model:-

Material Type:-

- ☐ AL ☐ MS ☐ SS
☐ Other _____

Sheet Thickness (S):-

Form Direction:-

- ☐ Upwards ☐ Downwards

Other Forms Close By?

- ☐ No
☐ Yes (Add £50)
X =
Y =

OptiGlide Die Cap (Form Up Only)

- ☐ Yes (Add £50 & 1 extra Day)
☐ No

Tool ID Marking (Specify):-

Maximum Dimensions

for applications exceeding these sizes please contact us for alternative solutions (price & delivery indicated may vary)

S = Sheet Thickness (SS = Stainless Steel)

Form Up

Form Down

D = 40

D = 30

H = 6

H = 5

S = 3.0 (1.5 SS)

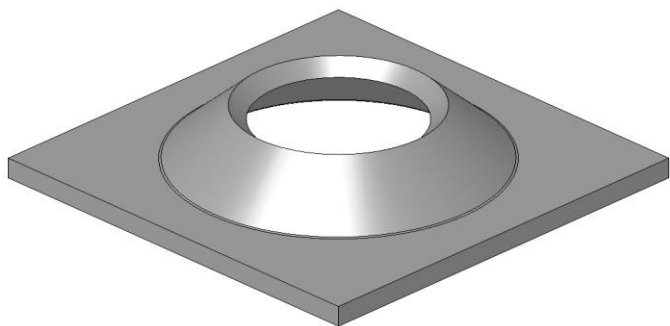
S = 3.0 (1.5 SS)

Ordering Tips & Advice:-

- **Important - Advise if any specific tolerances apply to any dimensions**
- Lubricate the sheet prior to forming using Xcel™ spray helps material flow more easily and improve stripping
- Use Optiglide™ die cap to reduce sheet marking on the underside of the sheet if upwards forming
Extra £50 charge and 1 extra day delivery apply
- Optima coated inserts improve performance by reducing friction between tool and material to reduce galling and improve processing reliability. SlipMax™ recommended for stainless steels

Cut Threads	M2.5	M3	M4	M5	M6	M8	M10
ØD	2.1	2.5	3.3	4.2	5.0	6.8	8.5
Material Thickness (Min/Max)	1.0 - 1.5	1.0 - 1.5	1.0 - 2.0	1.0 - 2.0	1.5 - 2.5	2.0 - 2.5	2.0 - 2.5
Roll Formed Threads	M2.5	M3	M4	M5	M6	M8	M10
ØD	2.3	2.8	3.7	4.65	5.55	7.4	9.3
Material Thickness (Min/Max)	1.0 - 1.5	1.0 - 2.0	1.0 - 2.5	1.0 - 3.0	1.0 - 3.0	1.5 - 3.0	1.5 - 3.0

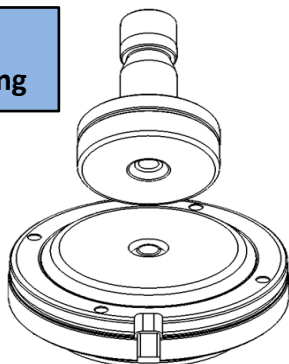
Form Only - Round



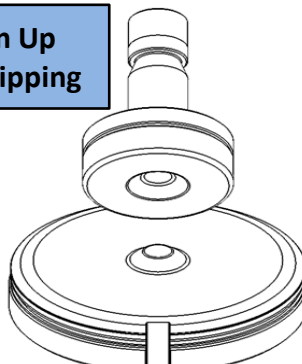
Typical applications:

- Captivate countersunk headed screws for flush finish
- Drainage outlets
- Anti-slip tread plates

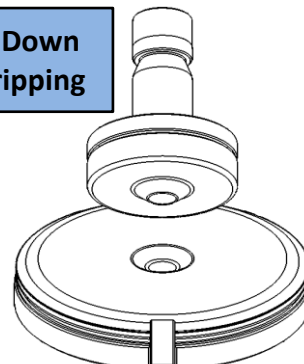
Form Up With Stripping



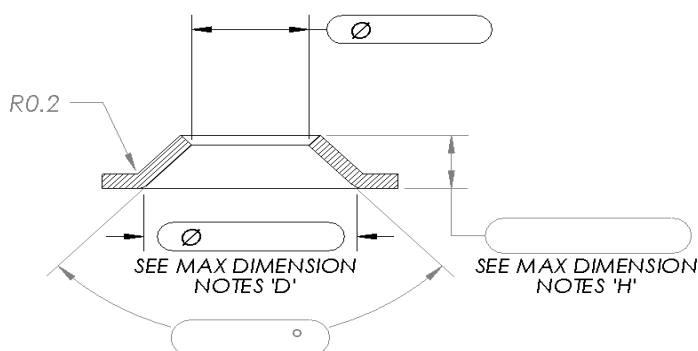
Form Up No Stripping



Form Down No Stripping



Tool Size	Price	Delivery	Cat N°	Price	Delivery	Cat N°	Price	Delivery	Cat N°
Size 1	€ 526	2 Days	25468	€ 370	2 Days	25572	€ 370	2 Days	25543
Size 2	€ 910		25469	€ 420		25618	€ 420		25619



DIN 74	ØD @ 90°	
	Slotted & Phillips Head	Hexagon Socket Head
M3	6.5	6.6
M4	8.6	9
M5	10.4	11
M6	12.4	13
M8	16.4	17.2
M10	20.4	21.5
M12	24.4	25.5
M14	28.4	28.5
M16	32.4	31.5
M18	36.4	35
M20	40.4	38

Alternatively send a CAD file or drawing in any format of your choice

Company Name

Customer Number (If Known)

Contact Person

- ☐ Quote Only
- ☐ Order Number (Specify)

Machine Type & Model

Material Type

- ☐ AL ☐ MS ☐ SS
- ☐ Other

Maximum Dimensions

for applications exceeding these sizes please contact us for alternative solutions

S = Sheet Thickness

With Stripping

Size 1	Size 2
D = Ø20	D = Ø50
H = 4.5	H = 7.7
S = 1.5	

Without Stripping

Size 1	Size 2
D = Ø15	D = Ø40
H = 10	
S = 3	

Sheet Thickness (S)

Form Direction

- ☐ Up ☐ Down

Lower Unit Stripping

- ☐ Yes ☐ No

Other Forms Close By

- ☐ Yes (Add £50 & Inc Sketch) ☐ No

OptiGlide Die Cap (Up Only)

- ☐ Yes (Add £50) ☐ No

Punch Style

- ☐ Classic
- ☐ Alignment Ring Required
- ☐ 2·4·1
- ☐ 2·4·1 Holder Required

Tool ID Marking (Specify)?

Ordering Tips & Advice:-

- **With stripping** option protects tool, helps keep sheets flatter, allows the sheet safe travel over the tool and reduces marking on underside of sheet (not necessary or an option on downward forming)
 - **Important - Advise if any specific tolerances apply to any dimensions**
 - For angles ≤ 30° use extrusion datasheet
 - Increase R0.2 to R0.8 if sheet has a protective foil to prevent it splitting
 - For angles ≤ 30° use extrusion datasheet
 - Lubricate the sheet prior to forming using Xcel™ spray helps material flow more easily
 - Use Optiglide™ die cap to reduce sheet marking on the underside of the sheet if upwards forming
- Extra £50 charge and 1 extra day delivery apply

Louvre - Closed End



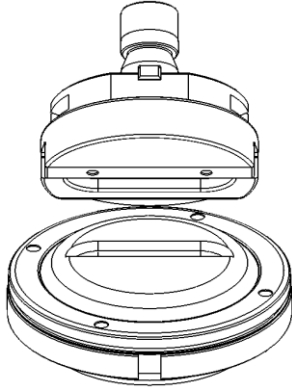
Typical Applications:-

- Ventilation & air flow

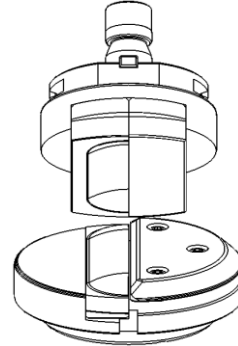
Wilson Advantages:-

- Built-in alignment ring
- Replaceable cutting components makes tool economical
- Reversible punch cutting blade provides 4 cutting edges
- Optima™ coated cutting inserts as standard
- Premium quality steels
- Sprung die cap to protect tool, reduce scratches and allow sheet safe movement over tool

Standard



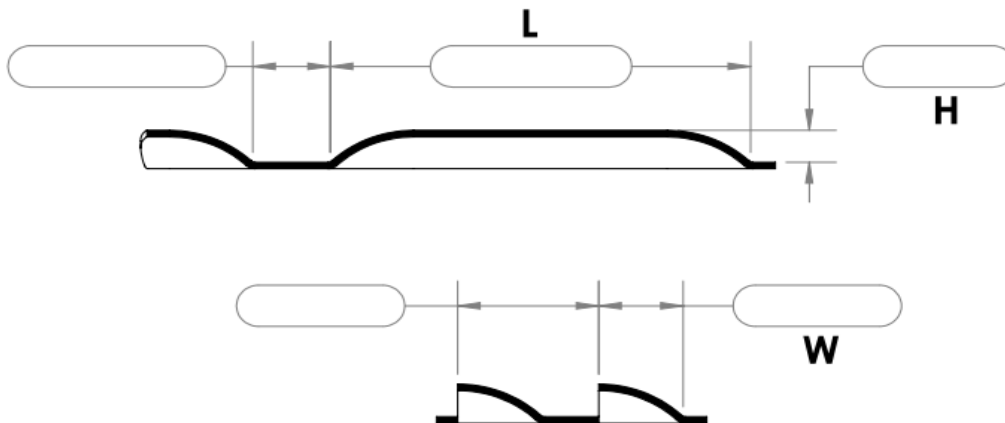
A-Plus Series™



Note: A-Plus Tooling Cartridge Also Needed #26296

SIZE	Cat No°	Price	Delivery	Cat No°	Delivery	Price
L60 X W12 X H5	25130	€ 1,397	2 Days	26287	5 Days	€ 2,427
L = 40 to 60	26695	€ 1,591	7 Days			
L = 60 to 72	26707	€ 1,962				

Alternatively send a CAD file or drawing in any format of your choice



Company Name:-

Customer Number (If Known):-

Contact Person:-

- ☐ Quote Only
☐ Order Number (Specify)

Machine Type & Model:-

Material Type:-

- ☐ AL ☐ MS ☐ SS

☐ Other

Sheet Thickness (S):-

OptiGlide Die Cap:-

- ☐ Yes (adds £50 & 1 extra day)
☐ No

Coating Option

- ☐ Optima - Standard
☐ WearBeater - Optional

A-Plus Cartridge Required:-

- ☐ Yes (Req'd for 26287 only)
☐ No

Tool ID Marking (Specify):-

Maximum Dimensions

for applications exceeding these sizes please contact us for alternative solutions (price & delivery indicated may vary)

S = Sheet Thickness (SS = Stainless Steel)

	26695	26707	26287
L	60	72	101
W	19		
H	6.5		
S	3.0 (2.0 SS)		

Ordering Tips & Advice:-

- **Important - Advise if any specific tolerances apply to any dimensions**
- Other louvre options available, continuous, open ended etc...
- For best results try to keep the width a minimum 2 to 3 times the height
- For best results try to keep the height a maximum 5 times sheet thickness for mild steel or 4 times for aluminium and stainless steel
- Lubricate the sheet prior to forming using Xcel™ spray to help the material flow more easily
- Consider OptiGlide™ die cap to reduce sheet marking on the underside of the sheet (adds £50 & 1 extra day)
- Coated inserts improve performance by reducing galling and improving surface hardness to increase hit count between regrinds - **WearBeater™ recommended for aluminium only (adds 1 extra day)**
- Ultima™ powdered steel inserts help further enhance cutting edge longevity to maximise tool life