

V-SERIES BLACK

Wilson Tool's V-Series Black for press brake dies incorporate replaceable inserts to decrease friction and to enable better performance on certain tough-to-bend applications.

Manufactured by Wilson Tool, the Wilson V-Series Black is available for virtually all major styles of press brake tooling. With Wilson Tool as the manufacturer, you will see:

- Higher quality tool steel
- Tighter tolerances
- Increased bend accuracy
- Shorter lead times

Hard-to-bend Application Capability

Wilson V-Series Black dies make it much easier to produce small flanges, small bend radii, and bends closer to holes. The Wilson V-Series Black also enables you to bend a wide range of materials using the same die, reducing set-up time and reducing the amount of tooling required.



Watch the V-Series Black die in action!

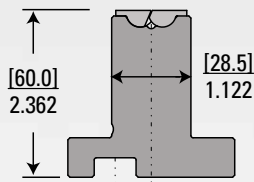
Reduced Friction

Wilson V-Series Black dies include replaceable built-in inserts that rotate so material glides on a flat surface rather than the traditional grabbing action of a die's shoulder radius. Friction and concentrated load is greatly reduced which reduces material marking. This tool is ideal for working with diamond plate, stainless and aluminum. Add Zip-Mar strips to the top of the inserts and marking on cosmetic materials such as painted or polished materials is practically eliminated.

EUROPEAN STYLE

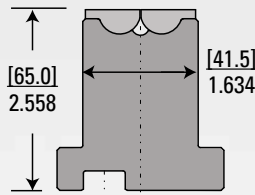
MODEL 1

41060



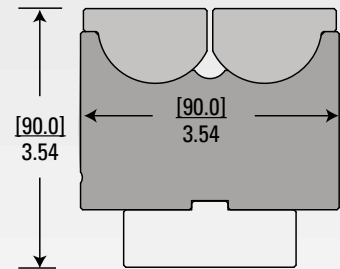
MODEL 2

42065



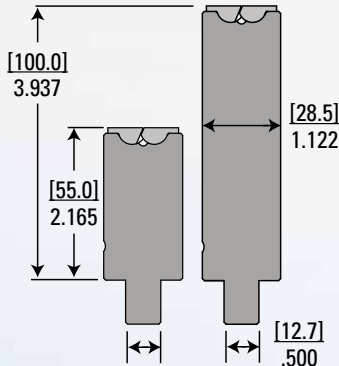
MODEL 3

43090

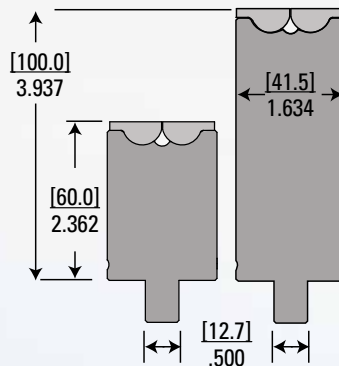


AMERICAN STYLE

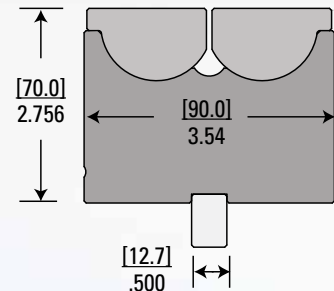
51055 51100



52060 52100

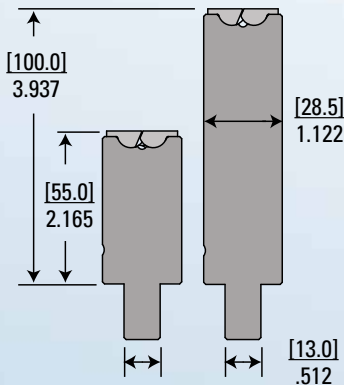


53070

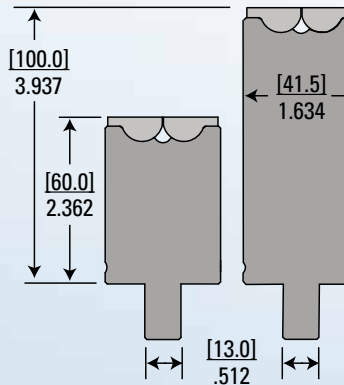


WT STYLE

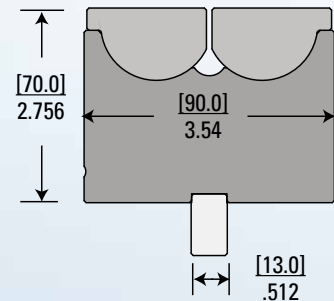
61055 61100



62060 62100



63070



V-Series Black Specifications

	Material Thickness	Min. Outside Flange	Ton/ FT	Min. Angle	Punch Tip Required to Achieve Angle	Max OR Radius @ Min. Angle	Max OR Radius @ 90°	Tonnage Cap/FT	T/M	kN/M
MODEL 1	<u>.45 mm</u> .018"	<u>3.0 mm</u> .118"	1.8	34°	0.054	<u>3.17 mm</u> .125"	<u>4.45 mm</u> .175"	34	112	1100
	<u>.50 mm</u> .020"		1.8		0.052					
	<u>.60 mm</u> .024"		2.0		0.047					
	<u>.80 mm</u> .030"		2.5		0.042					
	<u>.90 mm</u> .036"		3.3		0.036					
	<u>1.0 mm</u> .040"	<u>3.9 mm</u> .153"	4.0		0.031					
	<u>1.2 mm</u> .048"	5.8								
	<u>1.5 mm</u> .059"	<u>4.2 mm</u> .165"	9							
MODEL 2	<u>1.9 mm</u> .074"	<u>8.5 mm</u> .335"	7	42°	0.122	<u>5.5 mm</u> .216"	<u>9.0 mm</u> .354"	50	168	1650
	<u>2.9 mm</u> .105"	<u>8.8 mm</u> .347"	13		0.112					
	<u>3.0 mm</u> .118"	<u>9.3 mm</u> .366"	15		0.099					
	<u>3.2 mm</u> .126"		20		0.091					
	<u>3.4 mm</u> .135"		22	55°	0.082	<u>7.9 mm</u> .276"				
MODEL 3	<u>4.0 mm</u> .157"	<u>22.5 mm</u> .886"	9	65°	0.078	<u>11.5 mm</u> .453"	<u>20.2 mm</u> .797"	60 *	204	2000
	<u>4.75 mm</u> .187"		26		0.094					
	<u>6.35 mm</u> .250"		28		0.125					

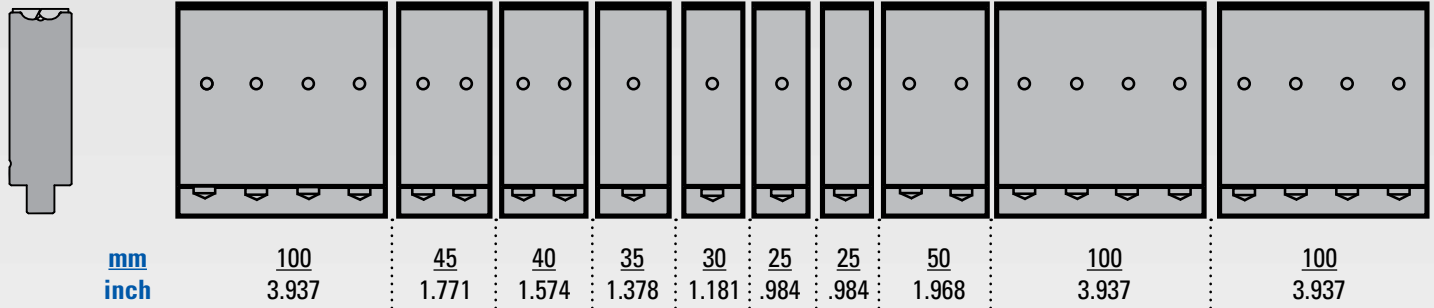
Inserts for Model 1 & 2 : HRC 45
 Inserts for Model 3: HRC 58 - 60

Consume 60% of the insert when bending to prevent insert damage.

V-SERIES BLACK DIMENSIONS

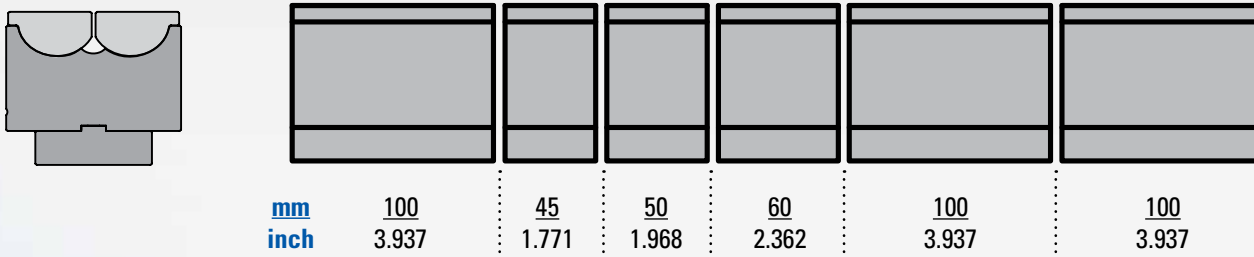
Model 1 & 2

Solid Total Length 500mm [19.68"]
Sectional (Shown) Total Length 550 mm [21.65"]



Model 3

Solid Total Length 250mm [9.84"]
Sectional (Shown) Total Length 455 mm [17.91"]



V OPENING AND SHOULDER RADIUS DIMENSIONS

MODEL	SHOULDER RAD	DESIRED ANGLE	THEORETICAL V METRIC	THEORETICAL V IMPERIAL	DESIRED ANGLE	THEORETICAL V METRIC	THEORETICAL V IMPERIAL
1	1.0mm .040"	90°	7.2	0.283	34°	6.5	0.256
2	1.3mm .051"	90°	13.9	0.547	42°	13.3	0.524
3	6.0mm .236"	90°	33.0	1.299	65°	31.4	1.236

ZIP MAR URETHANE SHOULDER STRIPS

CAT. No	Description
980953	Zip Mar Model 1
980954	Zip Mar Model 2
980955	Zip Mar Model 3

For more information on the Wilson V-Series Black,
 contact your local sales representative or
 contact our sales desk at 1-800-445-4518.