

## WILSON 2-4-1 Slitting Die System

**NOW AVAILABLE FROM WILSON TOOL  
FOR TRUMPF GROUP H & I MACHINES ONLY**

### FEATURES INCLUDE:

#### Larger Size

Available in slitting sizes up to 76.2mm long.

#### Long Life

Die blades are manufactured from Ultima™ tool steel for more hits between regrinds and reduced down time.

#### More Regrind Life

The 2-4-1 die system comes with 2mm of regrind life as standard - twice that of a standard Trumf die.

#### Durable Die Holder

The die holder and die shoe are integrated into one unit for increased strength and toughness.



For more information on the Wilson 2-4-1 Slitting Die System and any other products, Wilson Tool can be contacted direct on: 0800 373748 (freephone) 1-800 709009 (freephone Eire) or alternatively email [sales@wilsontool.eu.com](mailto:sales@wilsontool.eu.com)

## Tricks of the Trade

**Q:** I am aware of the fact that in air bending, the inside of the bend is created by the V-opening. What criteria should I use to determine the appropriate punch tip radius?

**A:** In each of the illustrations below, the V-opening is 10mm and the material is 1.5mm mild steel. This V-opening yields an inside radius of 1.67mm. Each of the punch tips shown can be used to create this bend. However, to ensure maximum punch life, it is best to use a punch with a tip radius that is slightly less than the inside radius yielded by the V-opening.

When bending a wide range of materials (i.e. 3mm - 0.8mm mild steel), it is possible to use a single punch tip radius provided that the tip radius is smaller than the inside radius that will be created by the smallest V-opening. For example, the recommended V-opening for a 0.8mm mild steel is 6mm, yielding an inside radius of 1mm. The recommended V-opening for a 3mm mild steel is 25mm, yielding an inside radius of 4.2mm. A punch with a 0.8mm tip radius could be used when air bending this range of material, as the tip radius is slightly less than the inside radius yielded by the smallest V-opening.



**Figure 1**  
90° punch  
0.2mm tip radius



**Figure 2**  
90° punch  
0.8mm tip radius



**Figure 3**  
90° punch  
1.5mm tip radius