

How to get started Press Brake Productivity Quick Start



Thank you for buying a quality product made by Wila

For more than 80 years, Wila has supplied trend-setting Toolholders, Tools and Accessories worldwide for press brake manufacturers and press brake users. Wila continues to invest in the latest Toolholder and Tooling technology. Objective: raise productivity of the press brake in the market for sheet metal working to ever-greater heights. The product in front of you is the result. Reproducible and reliable (e.g.: predictable) press brake processes rely on the combination of press brake and press brake tools. As part of our drive towards optimization of the productivity of press brakes, Wila has developed the New Standard Tooling System in addition to the European Style and American Style Tooling systems. This New Standard Tooling System was rapidly adopted by the leading press brake manufacturers and press brake users worldwide.

The New Standard Tooling System distinguishes itself by a high degree of:

- **accuracy** • **speed** • **safety** • **durability** • **flexibility**

New Standard Tooling in Top Condition

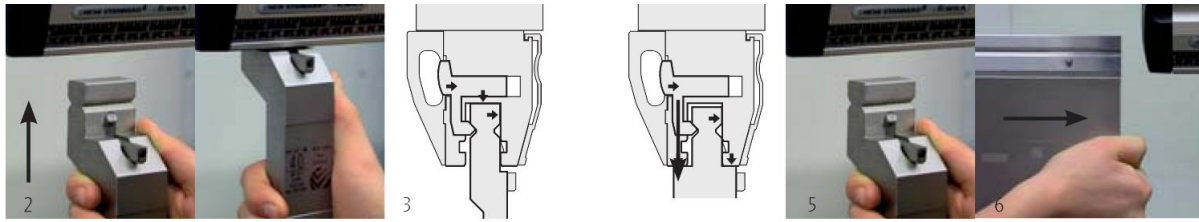
Make sure the tool is and stays in top condition by using Press Brake Productivity Wax on a regular basis. By the way Press Brake Productivity Wax is suitable for all Press Brake Tooling.

E2M®

As it is very easy to move tools equipped with E2M®, we recommend using roll-out safety devices in your tool holders for additional safety. For this, Wila has a number of ready-made solutions in its programme. For more information, please contact us via info@wila.nl or 0537 289 85.



Hydraulic Clamping



1. Make sure the clamping is in the unclamped position.

2. Inserting tools with Safety-Click®

The tooling can be vertically inserted in the clamping. When inserting the tool, the Safety-Click® does not need to be pressed in. The tooling can be inserted both vertically as horizontally.

3. Activate the clamping

All tool segments are now automatically individually seated, centered and aligned.

4. Deactivate the clamping

After deactivating the clamping system, the tooling remains suspended until the Safety-Click® has been pressed.

5. Removing the tools with Safety-Click®

Press the Safety-Click® to release the tooling vertically from the Clamping System. Be aware of the weight of the tool when pressing the Safety-Click®.

6. Exchanging tools with Safety-Pins, Safety-Keys or E2M®

Tools with Safety-Pins, Safety-Keys or E2M® can only be inserted horizontally. Slide the tool in sideways and support the tooling until the complete tool is inside the clamping system. Be aware of the weight of the tool when sliding out and also support the tool so a horizontal slide out is guaranteed.

Mechanical Clamping



Figure 1.2

1. Make sure the clamping is in the unclamped position.

2. Inserting tools with Safety-Click®

The tool can be vertically inserted in the clamping. When inserting the tool, the Safety-Click® does not need to be pressed in. The tooling can be inserted both vertically as horizontally.

3. Activate the clamping

Activate the clamping by firmly tightening the relevant clamping bolts between the dots (B) clock wise at the location of the tooling. If you are clamping a single tool, you only have to tighten the middle clamping bolt. See figure 1.2.

4. Deactivate the clamping

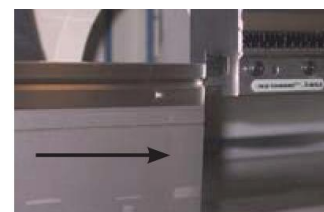
Deactivate the clamping by loosening the relevant clamping bolts (counterclockwise). The tooling remains suspended until the Safety-Click® has been pressed.

5. Removing tools with Safety-Click®

Press in the Safety-Click® to release the tooling vertically from the clamping. Be aware of the weight of the tool when pressing the Safety-Click®.

6. Exchanging tools with Safety-Pins, Safety-Keys or E2M®

Tools with Safety-Pins, Safety-Keys or E2M® can only be inserted horizontally. Slide the tool in sideways and support the tooling until the complete tool is inside the clamping system. Be aware of the weight of the tool when sliding out and also support the tool so a horizontal slide out is guaranteed.



HYDRAULIC AND MECHANICAL CROWNING



1. Inserting tools

Make sure the tool and the toolholder are clean and free of damage. Insert the tool in the toolholder.

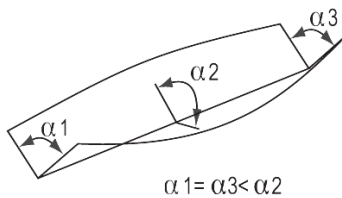
2. Activate the Clamping

By putting pressure on the clamping system or tightening the clamping bolts at the mechanical version, all tool segments are automatically centered and aligned.

3. Deactivate the Clamping

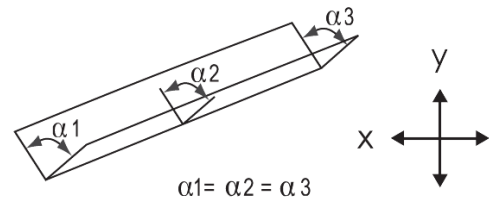
After releasing the pressure or loosening the clamping bolts, the tools are released and can be removed.

CROWNING ADJUSTMENTS



1. Check the bend angles

Check the bend angles. Due to the deflection of the press brake the angles in the middle and the end are not equal. Any differences between α_1 and α_3 can be corrected by changing the Y1 and Y2 setting of the press brake.



2. Adjusting the crowning

Adjust the crowning until $\alpha_2 = \alpha_1$ and α_3 . Too much crowning makes α_2 smaller than α_1 and α_3 .

CORRECTING LOCAL DEVIATIONS

(depending on the model chosen)

By operating the adjustment dials, the alignment in Y-direction will change. Depending on turning left or right, the bending of the sheet metal will locally have a larger or smaller angle.



TYPES OF CROWNING DRIVE UNITS

The "Wila Waves" can be adjusted via CNC motor or via manual adjustment.

All available adjustment options (right hand side):

- "CNC" means motorized at the end
- "H" means manual at the end
- "HF" means manual in the front
- "Hy" means hydraulic at the end (used with large units only)

See for detailed information the Press Brake Productivity Catalog.

GENERAL INSTRUCTIONS

- Check whether the tooling and the tool slot are clean and undamaged.
- Clean Tool and Toolholder with a cloth, if necessary with Press Brake Productivity Wax or a similar product.
- Do not use solvents or compressed air to clean the Clamping system.

SAFETY INSTRUCTIONS

- Do not place fingers in the tool slot if the clamping can be activated!
- Follow the safety instructions related to the press brake.
- Use of top tool without Safety-Click®, Safety-pin, Safety-key or E2M® is prohibited.
- The use of a lifting aid is mandatory for tooling above 50 kg.

Wila's toolholders systems are compact in design and are available in automatic hydraulic or manual versions to clamp all upper and lower tools quick and precise.

Wila's crowning systems fully compensate for machine deflection and machining tolerances and are available with automatic or manual clamping of bottom tools.

**WILA.
THE PRESS BRAKE
PRODUCTIVITY PEOPLE.**

Wila is totally focused on providing a line of products and support systems to maximize the productivity of your press brakes. For over 80 years, Wila has specialized in Toolholders, Tooling and Accessories to reduce set-up time and improve accuracy of the press brake. Through strong partnerships with the world's leading press brake manufacturers, an extensive and trained dealer network, long experienced regional managers, dedicated application support and engineering staff, Wila is always close at hand to support your needs.

WILA
P.O. Box 60
NL-7240 AB Lochem
The Netherlands
Tel: +31 (0)573 28 98 50
Fax: +31 (0)573 25 75 97
E-mail: info@wila.nl

WILA USA
7380 Coca Cola Drive
Hanover, MD 21076
Phones: (USA) 443-459-5496
Fax: (USA) 443-459-5515
E-mail: info@wilausa.com

www.wila.nl

www.wilausa.com