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NEW WILA IS DEDICATED TO MAXIMIZING YOUR PRESS BRAKE PRODUCTIVITY

Wila is totally focused on providing a line of products and support systems to maximize the productivity of your press brakes.

For over 70 years, Wila has specialized in Clamping Systems, Crowning Systems and Tooling and Accessories to reduce set-up time and improve accuracy of the press brake.

Through strong partnerships with the worlds leading press brake manufacturers, an extensive and trained dealer network, long experienced regional managers, application support and engineering staff, Wila is always close at hand to support your needs.

NEW STANDARD

Reproducable 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 optimalisation of the productivity of press brakes, Wila has developed its own tooling system in addition to the well known 'European Style' and 'American Style' tooling system. This system distinguishes itself by a high degree of accuracy, speed, safety, longevity and flexibility. This unique 'Wila Style' (previously known as Modufix) has become the 'New Standard' in the industry.

Accuracy

Each combination of New Standard Clamping and Crowning systems offers the unique ability to permanently eliminate all accumulated tolerances, both horizontally (Tx) and vertically (Ty). All modular tools and accessories (max. length 515 m) are developed and manufactured to the highest possible accuracy. The system furthermore allows extremely fine adjustments. Therefore accuracy (and the final bending result) are optimal.

Speed

Changing tools and crowning/correction of machine frame deflection are both carried out in the blink of an eye.

Safety

The tools can be exchanged quickly and safely. Top tools are fitted with Safety-Clicks, which enable quick and safe vertical change of tools. Due to safety regulations, this is limited to a tool weight of 12.5 kg.

Longevity

New Standard tools are CNC-Deephardened on the bending radii (56-60 HRc), and are therefore highly wear-resistant. Many New Standard Clamping and Crowning systems come with CNC Deephardened (approx. 56 HRc) pressure and reference surfaces. Consequently wear is negligible and a high level of performance is guaranteed for a long period. The New Standard tooling system can be applied on existing and new press brakes alike; when an older machine is replaced, the system can be transferred to the new machine.

Flexibility

New Standard Clamping and Crowning systems are characterized by their extremely compact design, the lack of any externally moving parts, and their extremely simple operation.
These systems are available on three different comfort levels, ranking from favourably-priced 'basic' models to models with a fully integrated hydraulically operated clamping system; they offer the ultimate accuracy, operating ease, bending freedom, adjustability, durability and clamping performance.
And all the positive benefits of this system are available to everyone in the press brake world who, like (and, as is often the case, thanks to) Wila places the utmost importance in Press Brake Productivity.

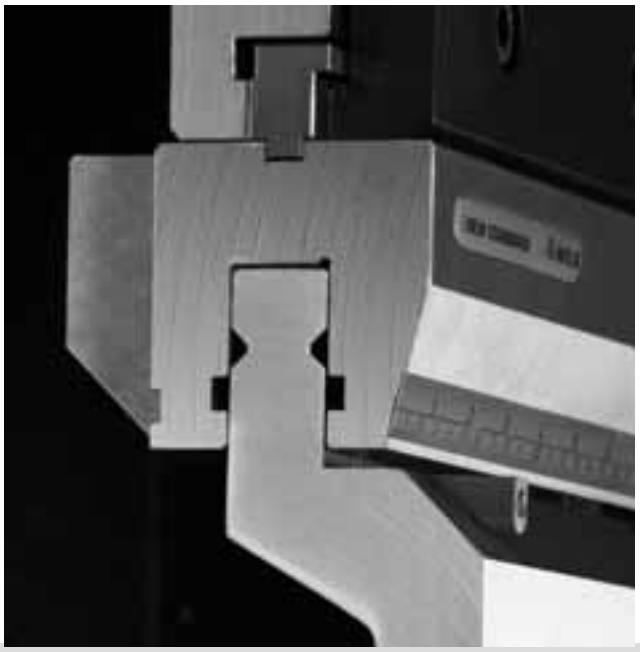
NEW STANDARD CLAMPING, CROWNING

New Standard Clamping

Wila's New Standard (N(S)CL) systems are characterized by their extremely compact design, the lack of any externally moving parts, and their extremely simple - often automatic - operation. These clamping systems, all designed according to the Universal Press Brake Concept, are available on three different comfort levels, namely:

- **Level II** offers a hydraulically operated clamping system that gives ultimate accuracy, operating ease, bending freedom, adjustability, durability and clamping performance. Because all of the pressure and reference surfaces are CNC deephardened (56 HRc), wear is negligible and a high level of performance is guaranteed for a long period.
- **Level I** also offers hydraulically operated clamping systems, the specifications of which differ little from those of the Level II systems, with the exception of the hardening of the pressure and reference surfaces. With these clamping systems Wila has added a new dimension to hydraulic tool clamping on press brakes.
- **Level Basic** offers favorably-priced 'basic' models with the similar specific characteristics. The mechanically operated clamping gives the operator optimum feed-back with minimum external dimensions.

NSCL II with Top Tool with Safety Click®



NCL-011 with Top Tool with Safety Click®

New Standard Crowning

Wila's New Standard Crownings systems (N(S)CR) are characterized by their extremely compact design, the lack of any externally moving parts, and their extremely simple - often automatic - operation. These crowning systems, all designed according to the Universal Press Brake Concept®, are available on three different comfort levels, namely:

- **Level II** offers a crowning with a fully integrated hydraulically operated clamping system that gives ultimate accuracy, operating ease, bending freedom, adjustability, durability and clamping and crowning performance. Because all of the pressure and reference surfaces are CNC deephardened (56 HRc), wear is negligible and a high level of performance is guaranteed for a long period.
- **Level I** also offers a crowning with a fully integrated hydraulically operated clamping system, the specifications of which differ little from those of the Level II systems, with the exception of the hardening of the pressure and reference surfaces.
- **Level Basic** offers favorably-priced 'basic' models with the similar specific characteristics.

NSCR II with OZU bottom tool

CNC-operated

manually operated

NEW STANDARD TOOLING

New Standard top tools

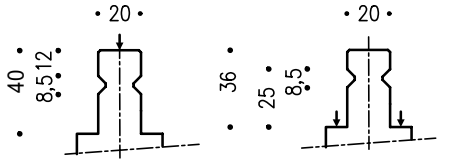
The essence of New Standard top tools is the Safety-Click©, a safety mechanism which is incorporated into the tool. With the Safety-Click© tools can be changed vertically simply by clicking them into and out of the holder. Changeover times are reduced considerable. Of course, tools can still be changed horizontally by sliding them in and out of the end of the ram. Tools up to 100 mm in length are equipped with one Safety-Click©; tools longer than 100 mm are equipped with two Safety-Clicks©. For safety reasons, Safety-Clicks© are used for tools weighing up to 12.5 kg. If the tool weighs more than 12.5 kg, it is equipped with Safety pins and can only be changed horizontally. For weights of more than 25 kg, the tools are equipped with Safety keys.

Because the New Standard adaptation is symmetrical to the center line, reversing the tool (over the x-axis) is also possible, providing additional versatility.
The top tools can be delivered with the pressure surface on top or on the shoulders of the adaptation.

Sectionalized Tooling allows you to quickly make any required bending length

TOOLING SPECIFICATIONS OVERVIEW NEW STANDARD STYLE

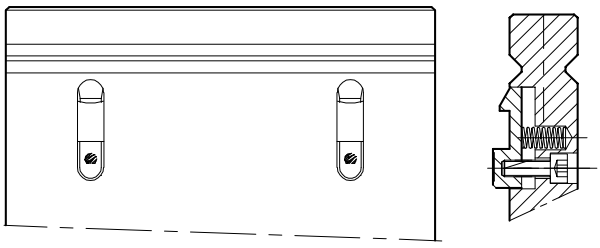
New Standard Style top tools type BIU/BMS/BM



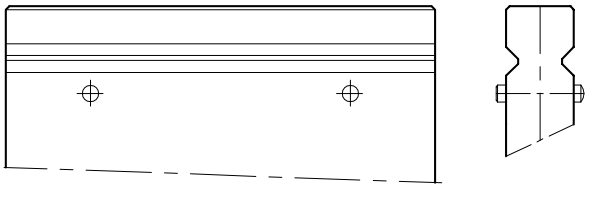
NS I
(New Standard I adaptation)

NS II
(New Standard II adaptation)

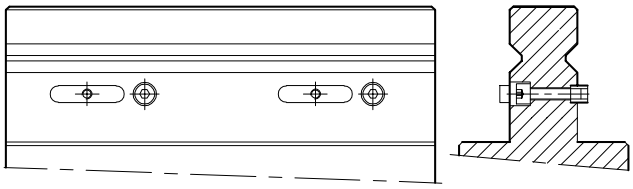
Toolsegments < 12.5 kg will be equipped with Safety Clicks®

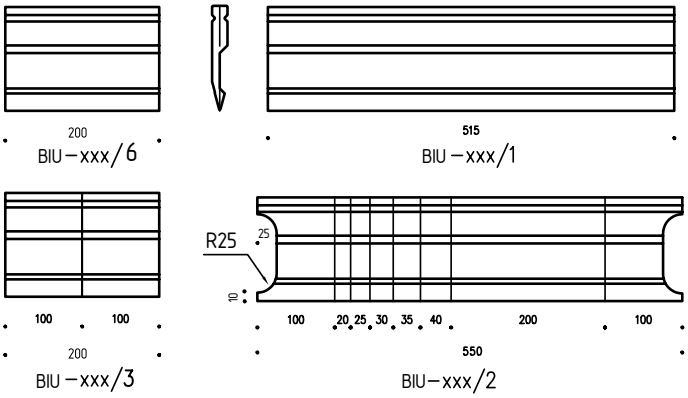


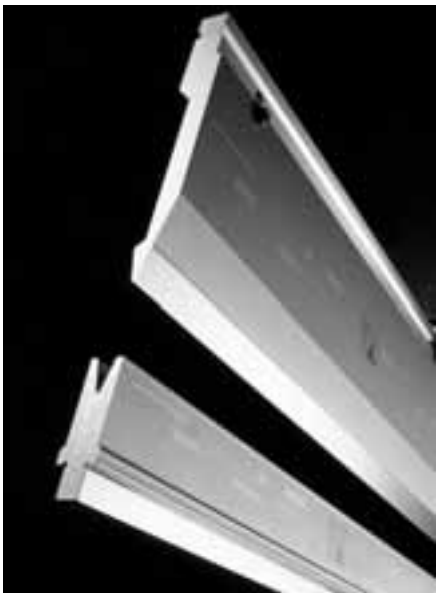
Toolsegments ≥ 12.5 kg and < 25 kg will be equipped with Fixed Safety Pins



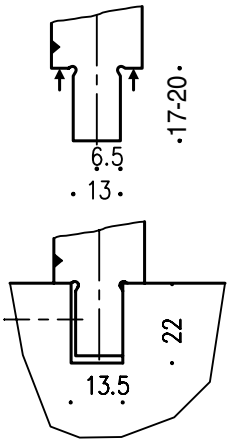
Toolsegments ≥ 25 kg will be equipped with Fixed Safety Keys

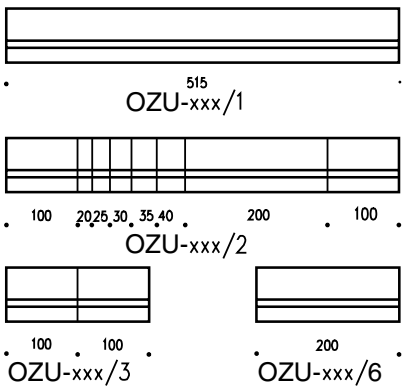




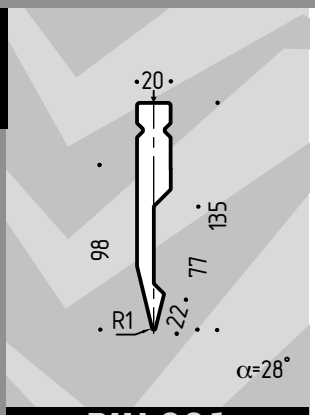


New Standard Style bottom tools type OZU





New Standard® Top tools 28°



BIU-001

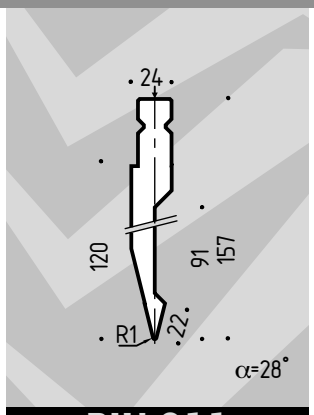
Wt./Mtr. 14.5 kg
Max. load/Mtr. 100T

BIU-001/1 Order no. W 24094 (L=515 mm)

BIU-001/2 Order no. W 24095 (L=550 mm - sectioned)

BIU-001/3 Order no. W 24096 (L=200 mm - sectioned)

BIU-001/6 Order no. W 36725 (L=200 mm)



BIU-011

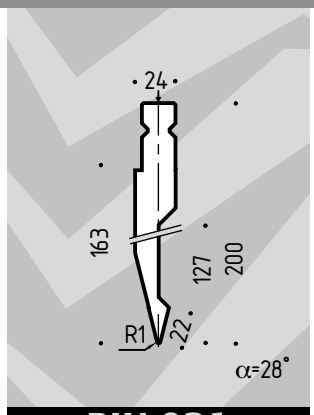
Wt./Mtr. 18.5 kg
Max. load/Mtr. 100T

BIU-011/1 Order no. W 24106 (L=515 mm)

BIU-011/2 Order no. W 24107 (L=550 mm - sectioned)

BIU-011/3 Order no. W 24108 (L=200 mm - sectioned)

BIU-011/6 Order no. W 36729 (L=200 mm)



BIU-021

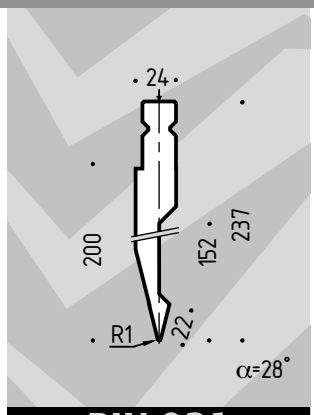
Wt./Mtr. 24 kg
Max. load/Mtr. 70T

BIU-021/1 Order no. W 24115 (L=515 mm)

BIU-021/2 Order no. W 24116 (L=550 mm - sectioned)

BIU-021/3 Order no. W 24117 (L=200 mm - sectioned)

BIU-021/6 Order no. W 36732 (L=200 mm)



BIU-031

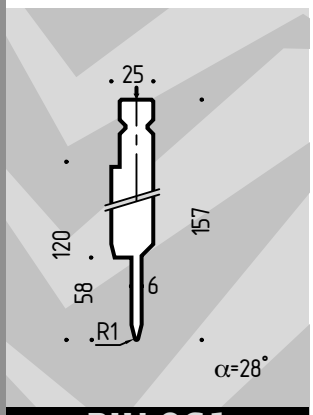
Wt./Mtr. 29 kg
Max. load/Mtr. 60T

BIU-031/1 Order no. W 24127 (L=515 mm)*

BIU-031/2 Order no. W 24128 (L=550 mm - sectioned)

BIU-031/3 Order no. W 24129 (L=200 mm - sectioned)

BIU-031/6 Order no. W 36736 (L=200 mm)



BIU-061

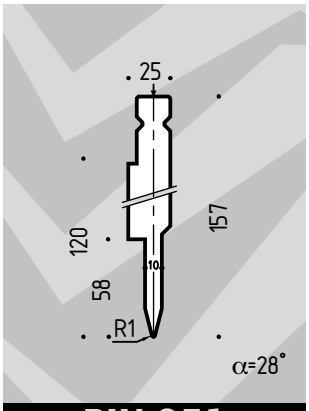
Wt./Mtr. 20.1 kg
Max. load/Mtr. 50T

BIU-061/1 Order no. W 36891 (L=515 mm)

BIU-061/2 Order no. W 36892 (L=550 mm - sectioned)

BIU-061/3 Order no. W 36893 (L=200 mm - sectioned)

BIU-061/6 Order no. W 36894 (L=200 mm)



BIU-051

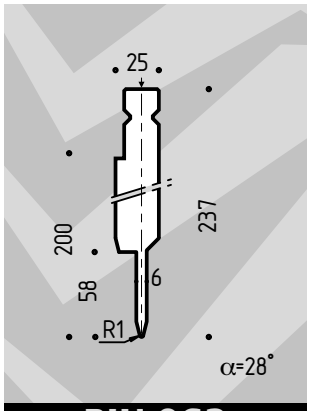
Wt./Mtr. 22 kg
Max. load/Mtr. 100T

BIU-051/1 Order no. W 24133 (L=515 mm)

BIU-051/2 Order no. W 24134 (L=550 mm - sectioned)

BIU-051/3 Order no. W 24135 (L=200 mm - sectioned)

BIU-051/6 Order no. W 36738 (L=200 mm)



BIU-063

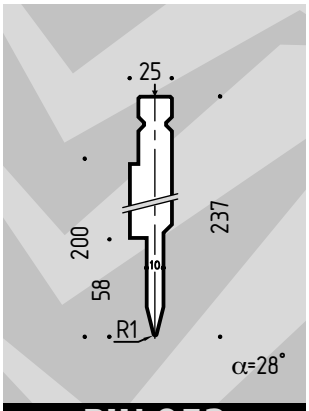
Wt./Mtr. 36.1 kg
Max. load/Mtr. 100T

BIU-063/1 Order no. W 37891 (L=515 mm)*

BIU-063/2 Order no. W 37892 (L=550 mm - sectioned)

BIU-063/3 Order no. W 37893 (L=200 mm - sectioned)

BIU-063/6 Order no. W 37894 (L=200 mm)



BIU-053

Wt./Mtr. 38 kg
Max. load/Mtr. 100T

BIU-053/1 Order no. W 24136 (L=515 mm)*

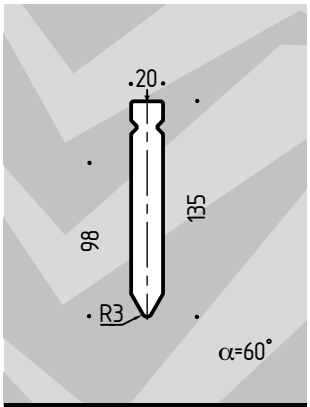
BIU-053/2 Order no. W 24137 (L=550 mm - sectioned)

BIU-053/3 Order no. W 24138 (L=200 mm - sectioned)

BIU-053/6 Order no. W 36739 (L=200 mm)

* provided with fixed safety pins (see page 13)

New Standard® Top tools 60°



BIU-004

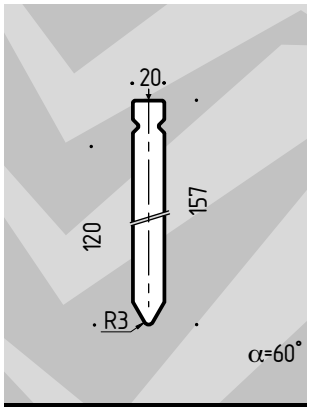
Wt./Mtr. 20.5 kg
Max. load/Mtr. 160T

BIU-004/1 Order no. W 24103
(L=515 mm)

BIU-004/2 Order no. W 24104
(L=550 mm - sectioned)

BIU-004/3 Order no. W 24105
(L=200 mm - sectioned)

BIU-004/6 Order no. W 36728
(L=200 mm)



BIU-014

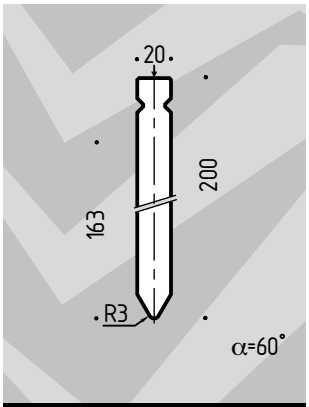
Wt./Mtr. 23.7 kg
Max. load/Mtr. 160T

BIU-014/1 Order no. W 38372
(L=515 mm)

BIU-014/2 Order no. W 38373
(L=550 mm - sectioned)

BIU-014/3 Order no. W 38374
(L=200 mm - sectioned)

BIU-014/6 Order no. W 38375
(L=200 mm)



BIU-024

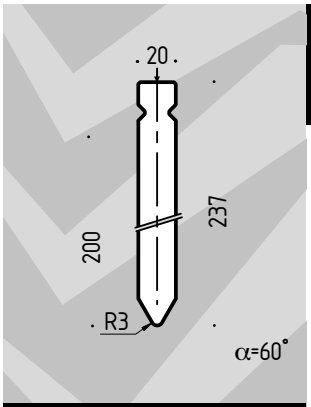
Wt./Mtr. 31 kg
Max. load/Mtr. 160T

BIU-024/1 Order no. W 24124
(L=515 mm)*

BIU-024/2 Order no. W 24125
(L=550 mm - sectioned)

BIU-024/3 Order no. W 24126
(L=200 mm - sectioned)

BIU-024/6 Order no. W 36735
(L=200 mm)



BIU-034

Wt./Mtr. 36.6 kg
Max. load/Mtr. 160T

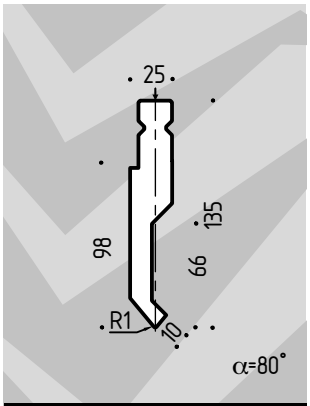
BIU-034/1 Order no. W 37732
(L=515 mm)*

BIU-034/2 Order no. W 37733
(L=550 mm - sectioned)

BIU-034/3 Order no. W 37734
(L=200 mm - sectioned)

BIU-034/6 Order no. W 37735
(L=200 mm)

New Standard® Top tools 80°



BIU-002

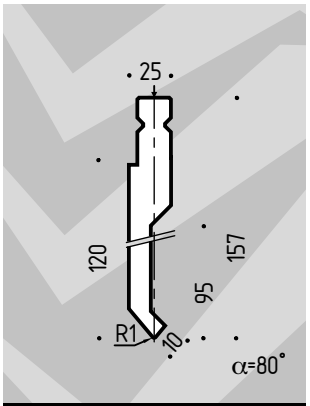
Wt./Mtr. 18 kg
Max. load/Mtr. 100T

BIU-002/1 Order no. W 24097
(L=515 mm)

BIU-002/2 Order no. W 24098
(L=550 mm - sectioned)

BIU-002/3 Order no. W 24099
(L=200 mm - sectioned)

BIU-002/6 Order no. W 36726
(L=200 mm)



BIU-012

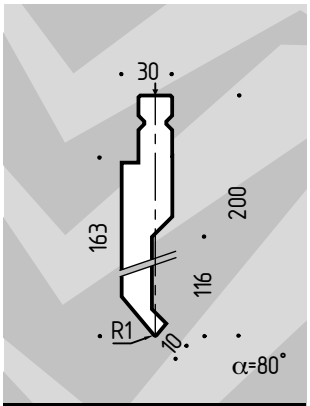
Wt./Mtr. 21 kg
Max. load/Mtr. 100T

BIU-012/1 Order no. W 24109
(L=515 mm)

BIU-012/2 Order no. W 24110
(L=550 mm - sectioned)

BIU-012/3 Order no. W 24111
(L=200 mm - sectioned)

BIU-012/6 Order no. W 36730
(L=200 mm)



BIU-022

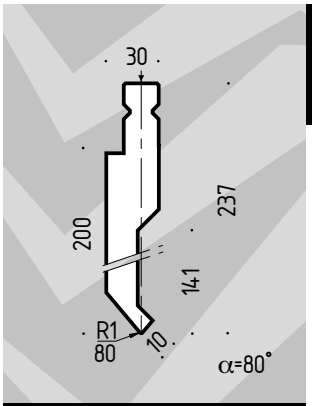
Wt./Mtr. 31.5 kg
Max. load/Mtr. 80T

BIU-022/1 Order no. W 24118
(L=515 mm)*

BIU-022/2 Order no. W 24119
(L=550 mm - sectioned)

BIU-022/3 Order no. W 24120
(L=200 mm - sectioned)

BIU-022/6 Order no. W 36733
(L=200 mm)



BIU-032

Wt./Mtr. 38.4 kg
Max. load/Mtr. 80T

BIU-032/1 Order no. W 37905
(L=515 mm)*

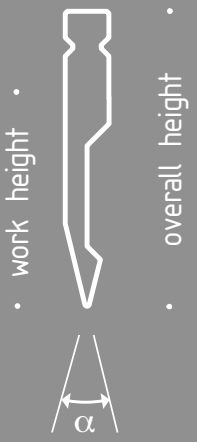
BIU-032/2 Order no. W 37906
(L=550 mm - sectioned)

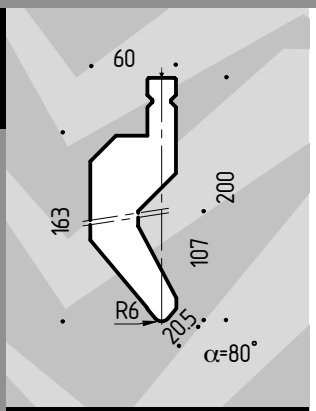
BIU-032/3 Order no. W 37907
(L=200 mm - sectioned)

BIU-032/6 Order no. W 37908
(L=200 mm)

* provided with fixed safety pins (see page 13)

New Standard® Top tools 80°





BIU-025

Wt./Mtr. 53 kg
Max. load/Mtr. 130T

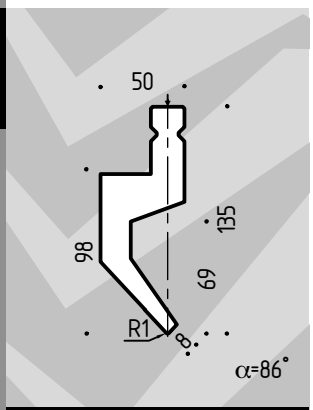
BIU-025/1 Order no. W 38729 (L=515 mm)*

BIU-025/2 Order no. W 38730 (L=550 mm - sectioned)

BIU-025/3 Order no. W 38731 (L=200 mm - sectioned)

BIU-025/6 Order no. W 38732 (L=200 mm)

New Standard® Top tools 86°



BIU-003

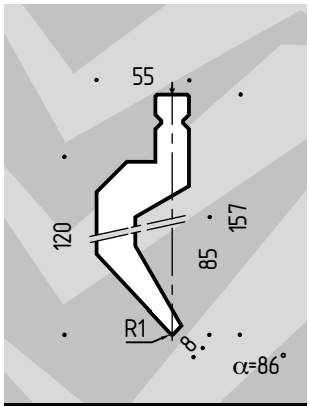
Wt./Mtr. 24 kg
Max. load/Mtr. 65T

BIU-003/1 Order no. W 24100 (L=515 mm)

BIU-003/2 Order no. W 24101 (L=550 mm - sectioned)

BIU-003/3 Order no. W 24102 (L=200 mm - sectioned)

BIU-003/6 Order no. W 36727 (L=200 mm)



BIU-013

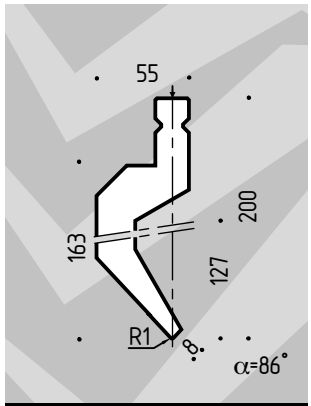
Wt./Mtr. 30 kg
Max. load/Mtr. 65T

BIU-013/1 Order no. W 24112 (L=515 mm)*

BIU-013/2 Order no. W 24113 (L=550 mm - sectioned)

BIU-013/3 Order no. W 24114 (L=200 mm - sectioned)

BIU-013/6 Order no. W 36731 (L=200 mm)



BIU-023

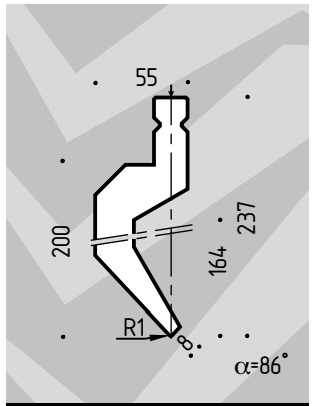
Wt./Mtr. 38 kg
Max. load/Mtr. 65T

BIU-023/1 Order no. W 24121 (L=515 mm)*

BIU-023/2 Order no. W 24122 (L=550 mm - sectioned)

BIU-023/3 Order no. W 24123 (L=200 mm - sectioned)

BIU-023/6 Order no. W 36734 (L=200 mm)



BIU-033

Wt./Mtr. 45 kg
Max. load/Mtr. 50T

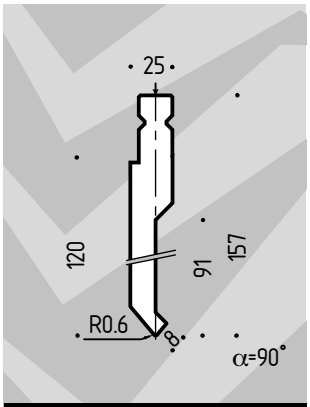
BIU-033/1 Order no. W 24130 (L=515 mm)*

BIU-033/2 Order no. W 24131 (L=550 mm - sectioned)

BIU-033/3 Order no. W 24132 (L=200 mm - sectioned)

BIU-033/6 Order no. W 36737 (L=200 mm)

* provided with fixed safety pins (see page 13)



BIU-015

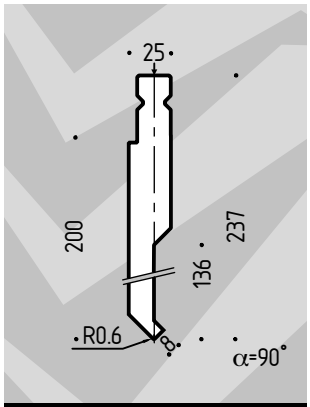
Wt./Mtr. 21 kg
Max. load/Mtr. 60T

BIU-015/1 Order no. W 24139
(L=515 mm)

BIU-015/2 Order no. W 24140
(L=550 mm - sectioned)

BIU-015/3 Order no. W 24141
(L=200 mm - sectioned)

BIU-015/6 Order no. W 36740
(L=200 mm)



BIU-035

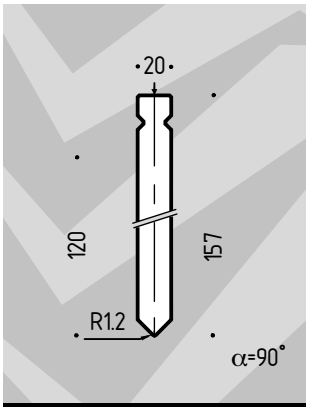
Wt./Mtr. 34 kg
Max. load/Mtr. 60T

BIU-035/1 Order no. W 24145
(L=515 mm)*

BIU-035/2 Order no. W 24146
(L=550 mm - sectioned)

BIU-035/3 Order no. W 24147
(L=200 mm - sectioned)

BIU-035/6 Order no. W 36742
(L=200 mm)



BIU-016

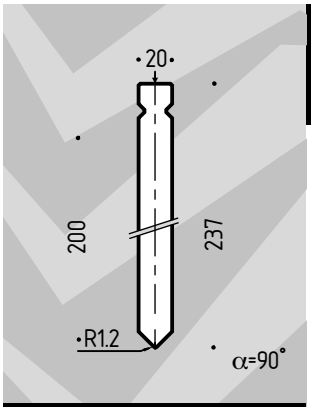
Wt./Mtr. 24 kg
Max. load/Mtr. 100T

BIU-016/1 Order no. W 24142
(L=515 mm)

BIU-016/2 Order no. W 24143
(L=550 mm - sectioned)

BIU-016/3 Order no. W 24144
(L=200 mm - sectioned)

BIU-016/6 Order no. W 36741
(L=200 mm)



BIU-036

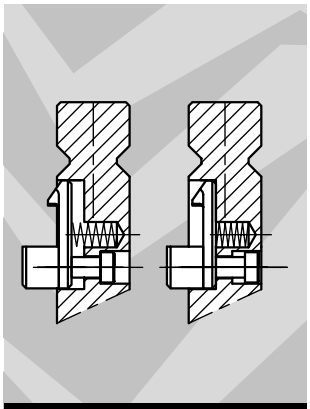
Wt./Mtr. 37 kg
Max. load/Mtr. 100T

BIU-036/1 Order no. W 24148
(L=515 mm)*

BIU-036/2 Order no. W 24149
(L=550 mm - sectioned)

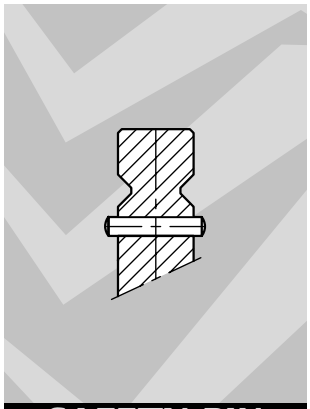
BIU-036/3 Order no. W 24150
(L=200 mm - sectioned)

BIU-036/6 Order no. W 36743
(L=200 mm)



SAFETY-CLICK®

BIU top tools weighing up to 12,5 kg (28 Lbs) are equipped with a patented safety mechanism, known as Safety-Click®. With this device, the tools can be vertically interchanged at any time in the NSCL I and NSCL II.



SAFETY PIN

BIU top tools sections weighing more than 12,5 kg (28 Lbs), indicated by (*), are equipped with fixed safety pins, allowing for horizontal interchange only.

* provided with fixed safety pins

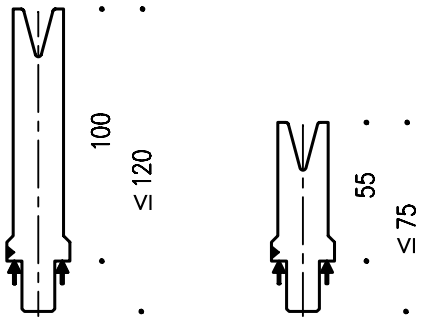
New Standard bottom tools

New Standard bottom tools can be used on all press brakes that have a clamping slot measuring 13.5 x 22 mm (W x H). OZU tools in the New Standard program with a working height of < 100 mm, have V openings with bending radii amounting to approximately 10% of the V opening. OZU bottom tools with a working height of 100 mm come with larger bending radii (approximately 20% of the V opening), which is particularly effective when bending foil covered materials.
By using larger bending radii, the foil remains intact longer and marking on sensitive sheet materials is reduced.
A number of tools in the New Standard program are available in two working heights: 55 mm and 100 mm (fig. 5.12). The tools with a working height of 100 mm offer more bending freedom (fig. 5.14).

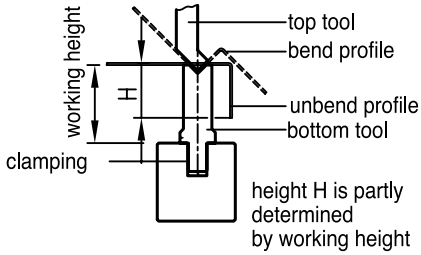
In addition to tools for air bending, the program also includes tools for bottom bending. For the bottom bending tools, not only the bending radii but also the entire V-opening are CNC deephardened, because with bottom bending the sheet comes into contact with not only the bending radii (like in air bending), but also with the sides of the V-opening.

CNC-Deephardening

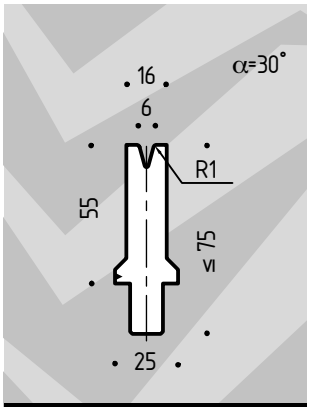
CNC-Deephardening® is a hardening process developed by Wila specifically for use in press brake tooling.
The specific properties of this process make it 'the' process to apply a superior functional hardening layer. Applying the hardened layer is very well controlled; the hardening depth can be influenced with great – consistent – accuracy and no additional stresses are brought into the product.
Based on many years of research and experience, we have determined that the bending radii of press brake tooling should at least be hardened to 54 HRc; this value can be fully guaranteed by using the CNC-Deephardening® process.
Compared to the other hardening processes like laser hardening, nitrating etc., CNC-Deephardening® results in a product with a superior longevity.



n **fig. 5.12**



n **fig. 5.14**



OZU-061

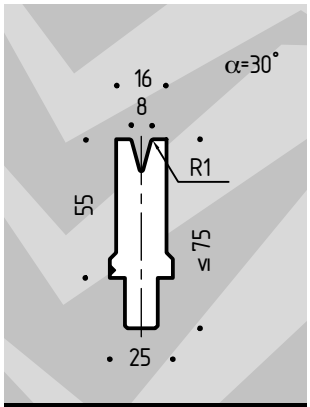
Wt./Mtr. 9.5 kg
Max. load/Mtr. 40T (α=90°)

OZU-061/1 Order no. W 24208
(L=515 mm)

OZU-061/2 Order no. W 24209
(L=550 mm - sectioned)

OZU-061/3 Order no. W 24210
(L=200 mm - sectioned)

OZU-061/6 Order no. W 29967
(L=200 mm)



OZU-051

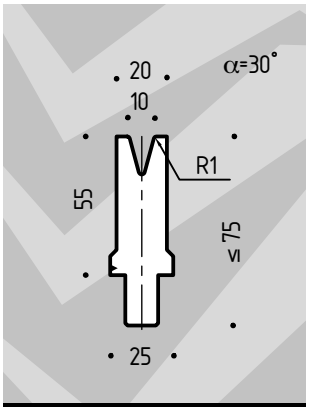
Wt./Mtr. 9.5 kg
Max. load/Mtr. 40T (α=90°)

OZU-051/1 Order no. W 24211
(L=515 mm)

OZU-051/2 Order no. W 24212
(L=550 mm - sectioned)

OZU-051/3 Order no. W 24213
(L=200 mm - sectioned)

OZU-051/6 Order no. W 29968
(L=200 mm)



OZU-062

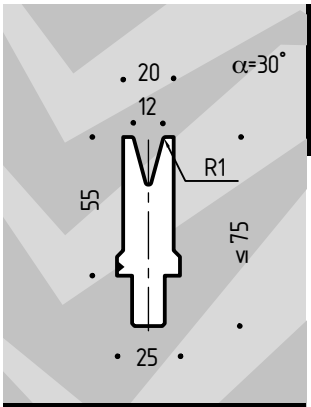
Wt./Mtr. 10.5 kg
Max. load/Mtr. 40T (α=90°)

OZU-062/1 Order no. W 24214
(L=515 mm)

OZU-062/2 Order no. W 24215
(L=550 mm - sectioned)

OZU-062/3 Order no. W 24216
(L=200 mm - sectioned)

OZU-062/6 Order no. W 29969
(L=200 mm)



OZU-052

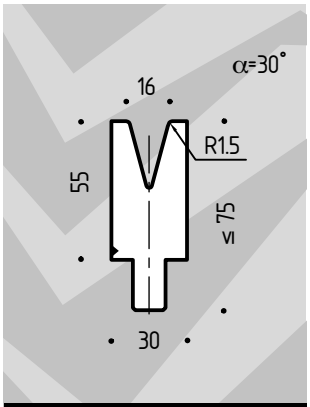
Wt./Mtr. 10 kg
Max. load/Mtr. 40T (α=90°)

OZU-052/1 Order no. W 24217
(L=515 mm)

OZU-052/2 Order no. W 24218
(L=550 mm - sectioned)

OZU-052/3 Order no. W 24219
(L=200 mm - sectioned)

OZU-052/6 Order no. W 29970
(L=200 mm)



OZU-053

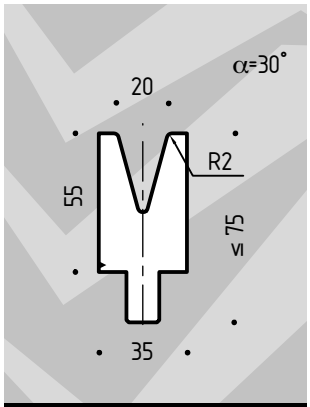
Wt./Mtr. 13.5 kg
Max. load/Mtr. 55T (α=90°)

OZU-053/1 Order no. W 24220
(L=515 mm)

OZU-053/2 Order no. W 24221
(L=550 mm - sectioned)

OZU-053/3 Order no. W 24222
(L=200 mm - sectioned)

OZU-053/6 Order no. W 29971
(L=200 mm)



OZU-063

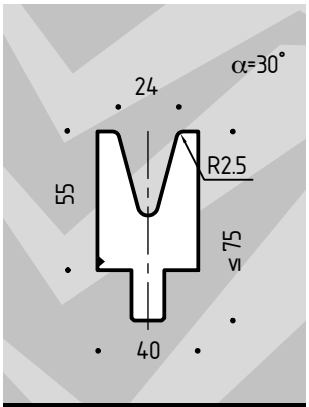
Wt./Mtr. 15 kg
Max. load/Mtr. 55T (α=90°)

OZU-063/1 Order no. W 24223
(L=515 mm)

OZU-063/2 Order no. W 24224
(L=550 mm - sectioned)

OZU-063/3 Order no. W 24225
(L=200 mm - sectioned)

OZU-063/6 Order no. W 29972
(L=200 mm)



OZU-054

Wt./Mtr. 16 kg
Max. load/Mtr. 60T (α=90°)

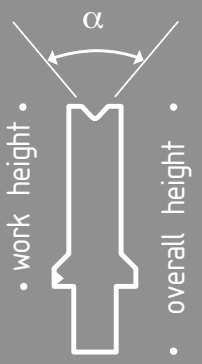
OZU-054/1 Order no. W 24226
(L=515 mm)

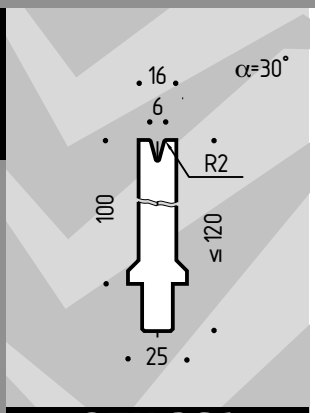
OZU-054/2 Order no. W 24227
(L=550 mm - sectioned)

OZU-054/3 Order no. W 24228
(L=200 mm - sectioned)

OZU-054/6 Order no. W 29973
(L=200 mm)

New Standard® Bottom tools 30°





OZU-361

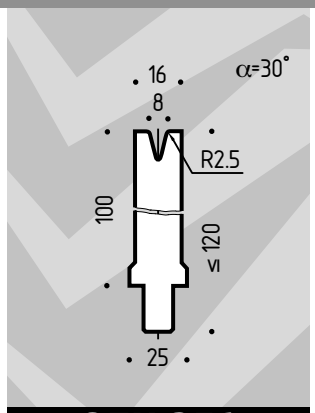
Wt./Mtr. 15.2 kg
Max. load/Mtr. 40T (α=90°)

OZU-361/1 Order no. W 24247 (L=515 mm)

OZU-361/2 Order no. W 24248 (L=550 mm - sectioned)

OZU-361/3 Order no. W 24249 (L=200 mm - sectioned)

OZU-361/6 Order no. W 29980 (L=200 mm)



OZU-351

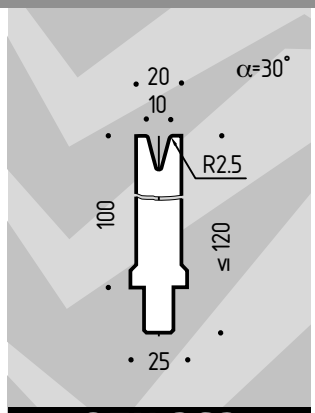
Wt./Mtr. 15 kg
Max. load/Mtr. 40T (α=90°)

OZU-351/1 Order no. W 24250 (L=515 mm)

OZU-351/2 Order no. W 24251 (L=550 mm - sectioned)

OZU-351/3 Order no. W 24252 (L=200 mm - sectioned)

OZU-351/6 Order no. W 29981 (L=200 mm)



OZU-362

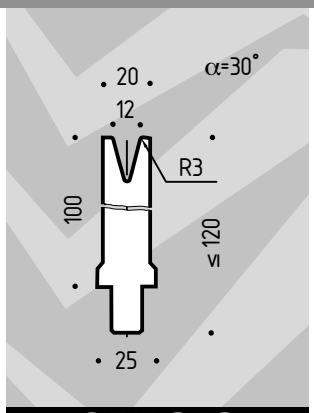
Wt./Mtr. 17.7 kg
Max. load/Mtr. 40T (α=90°)

OZU-362/1 Order no. W 24253 (L=515 mm)

OZU-362/2 Order no. W 24254 (L=550 mm - sectioned)

OZU-362/3 Order no. W 24255 (L=200 mm - sectioned)

OZU-362/6 Order no. W 29982 (L=200 mm)



OZU-352

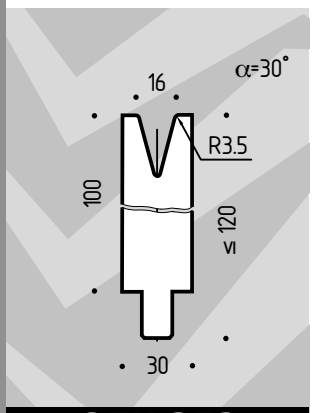
Wt./Mtr. 17.4 kg
Max. load/Mtr. 40T (α=90°)

OZU-352/1 Order no. W 24256 (L=515 mm)

OZU-352/2 Order no. W 24257 (L=550 mm - sectioned)

OZU-352/3 Order no. W 24258 (L=200 mm - sectioned)

OZU-352/6 Order no. W 29983 (L=200 mm)



OZU-353

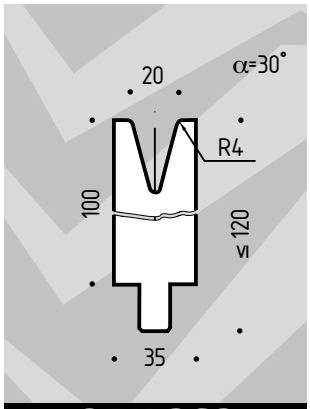
Wt./Mtr. 24.2 kg
Max. load/Mtr. 55T (α=90°)

OZU-353/1 Order no. W 24259 (L=515 mm)

OZU-353/2 Order no. W 24260 (L=550 mm - sectioned)

OZU-353/3 Order no. W 24261 (L=200 mm - sectioned)

OZU-353/6 Order no. W 29984 (L=200 mm)



OZU-363

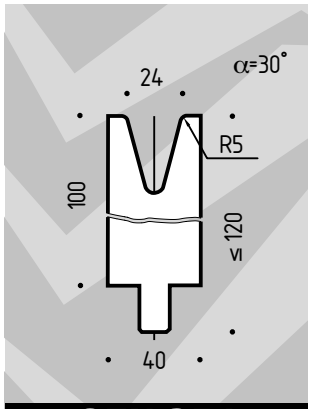
Wt./Mtr. 27.2 kg
Max. load/Mtr. 55T (α=90°)

OZU-363/1 Order no. W 24262 (L=515 mm)

OZU-363/2 Order no. W 24263 (L=550 mm - sectioned)

OZU-363/3 Order no. W 24264 (L=200 mm - sectioned)

OZU-363/6 Order no. W 29985 (L=200 mm)



OZU-354

Wt./Mtr. 30.1 kg
Max. load/Mtr. 60T (α=90°)

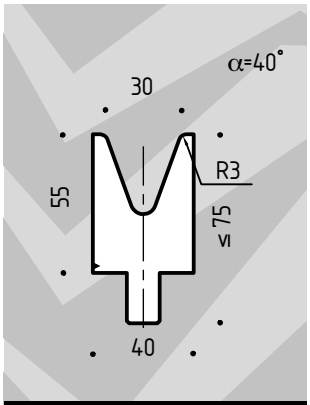
OZU-354/1 Order no. W 24265 (L=515 mm)

OZU-354/2 Order no. W 24266 (L=550 mm - sectioned)

OZU-354/3 Order no. W 24267 (L=200 mm - sectioned)

OZU-354/6 Order no. W 29986 (L=200 mm)

New Standard® Bottom tools 40°



OZU-031

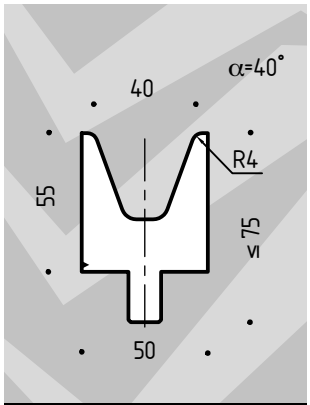
Wt./Mtr. 15 kg
Max. load/Mtr. 70T (α=90°)

OZU-031/1 Order no. W 24202 (L=515 mm)

OZU-031/2 Order no. W 24203 (L=550 mm - sectioned)

OZU-031/3 Order no. W 24204 (L=200 mm - sectioned)

OZU-031/6 Order no. W 29965 (L=200 mm)



OZU-032

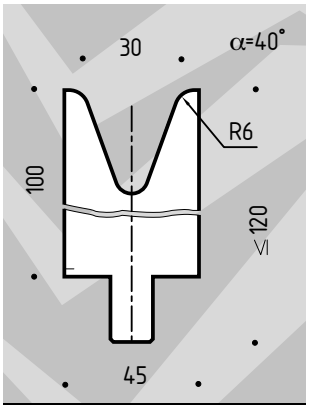
Wt./Mtr. 17 kg
Max. load/Mtr. 80T (α=90°)

OZU-032/1 Order no. W 24205 (L=515 mm)

OZU-032/2 Order no. W 24206 (L=550 mm - sectioned)

OZU-032/3 Order no. W 24207 (L=200 mm - sectioned)

OZU-032/6 Order no. W 29966 (L=200 mm)



OZU-328

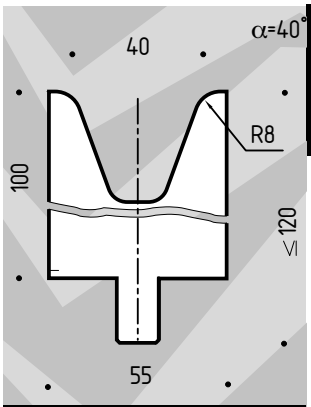
Wt./Mtr. 33.1 kg
Max. load/Mtr. 70T (α=90°)

OZU-328/1 Order no. W 37975 (L=515 mm)

OZU-328/2 Order no. W 37976 (L=550 mm - sectioned)

OZU-328/3 Order no. W 37977 (L=200 mm - sectioned)

OZU-328/6 Order no. W 37978 (L=200 mm)



OZU-329

Wt./Mtr. 54.1 kg
Max. load/Mtr.100T (α=90°)

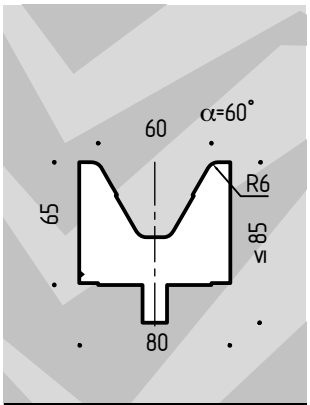
OZU-329/1 Order no. W 37979 (L=515 mm)

OZU-329/2 Order no. W 37980 (L=550 mm - sectioned)

OZU-329/3 Order no. W 37981 (L=200 mm - sectioned)

OZU-329/6 Order no. W 37982 (=200 mm)

New Standard® Bottom tools 60°/70°



OZU-016

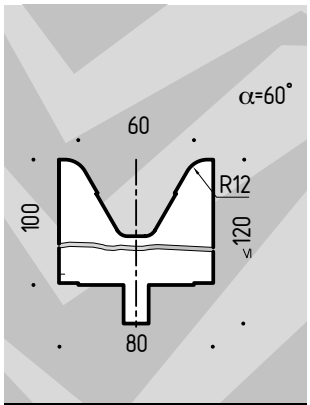
Wt./Mtr. 32 kg
Max. load/Mtr. 100T (α=90°)

OZU-016/1 Order no. W 24199 (L=515 mm)

OZU-016/2 Order no. W 24200 (L=550 mm - sectioned)

OZU-016/3 Order no. W 24201 (L=200 mm - sectioned)

OZU-016/6 Order no. W 29964 (L=200 mm)



OZU-327

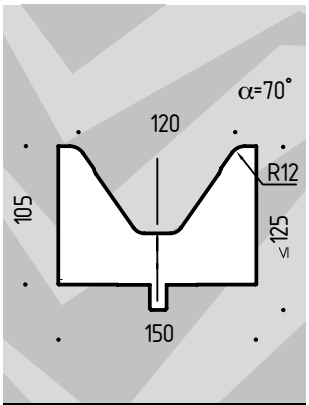
Wt./Mtr. 54.1 kg
Max. load/Mtr.100T (α=90°)

OZU-327/1 Order no. W 37971 (L=515 mm)

OZU-327/2 Order no. W 37972 (L=550 mm - sectioned)

OZU-327/3 Order no. W 37973 (L=200 mm - sectioned)

OZU-327/6 Order no. W 37974 (L=200 mm)

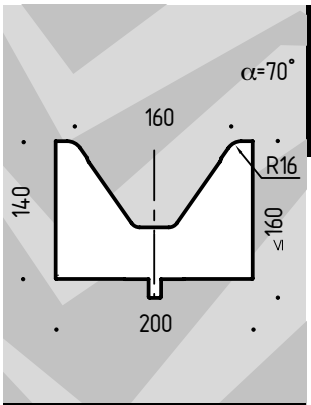


OZU-070

Wt./Mtr. 88.3 kg
Max. load/Mtr.170T (α=90°)

OZU-070/1 Order no. W 38376 (L=515 mm)

OZU-070/6 Order no. W 38377 (L=200 mm)

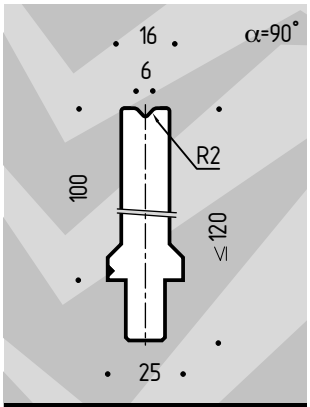


OZU-071

Wt./Mtr. 153.8 kg
Max. load/Mtr.200T (α=90°)

OZU-071/1 Order no. W 38378 (L=515 mm)

OZU-071/6 Order no. W 38379 (L=200 mm)



OZU-341

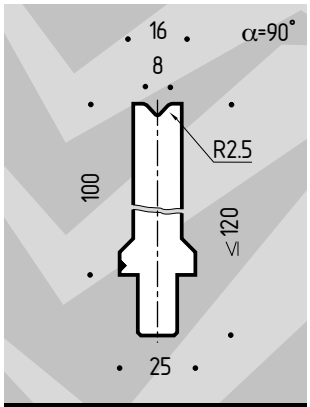
Wt./Mtr. 15.1 kg
Max. load/Mtr. 40T

OZU-341/1 Order no. W 37857
(L=515 mm)

OZU-341/2 Order no. W 37858
(L=550 mm - sectioned)

OZU-341/3 Order no. W 37859
(L=200 mm - sectioned)

OZU-341/6 Order no. W 37860
(L=200 mm)



OZU-342

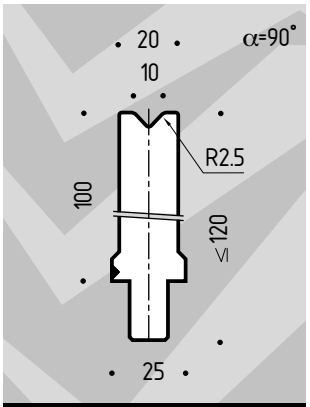
Wt./Mtr. 15.1 kg
Max. load/Mtr. 40T

OZU-342/1 Order no. W 37861
(L=515 mm)

OZU-342/2 Order no. W 37862
(L=550 mm - sectioned)

OZU-342/3 Order no. W 37863
(L=200 mm - sectioned)

OZU-342/6 Order no. W 37864
(L=200 mm)



OZU-343

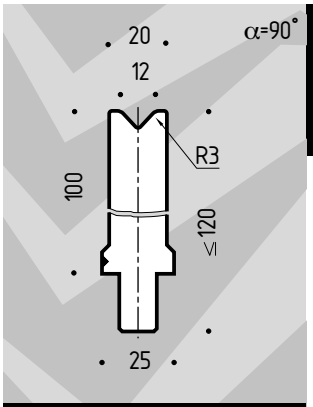
Wt./Mtr. 17.9 kg
Max. load/Mtr. 50T

OZU-343/1 Order no. W 37865
(L=515 mm)

OZU-343/2 Order no. W 37866
(L=550 mm - sectioned)

OZU-343/3 Order no. W 37867
(L=200 mm sectioned)

OZU-343/6 Order no. W 37868
(L=200 mm)



OZU-344

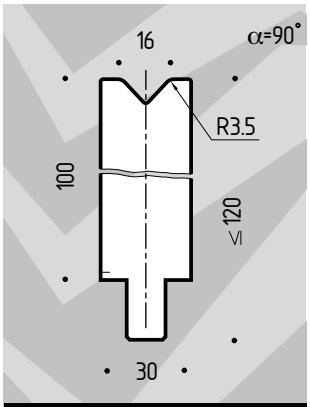
Wt./Mtr. 17.8 kg
Max. load/Mtr. 60T

OZU-344/1 Order no. W 37869
(L=515 mm)

OZU-344/2 Order no. W 37870
(L=550 mm - sectioned)

OZU-344/3 Order no. W 37871
(L=200 mm - sectioned)

OZU-344/6 Order no. W 37872
(L=200 mm)



OZU-345

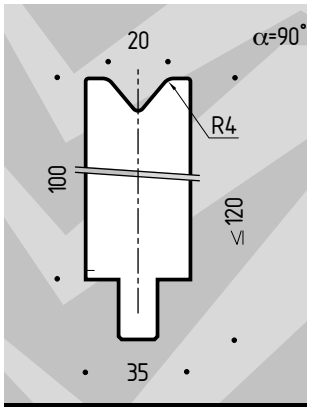
Wt./Mtr. 24.6 kg
Max. load/Mtr. 80T

OZU-345/1 Order no. W 37873
(L=515 mm)

OZU-345/2 Order no. W 37874
(L=550 mm - sectioned)

OZU-345/3 Order no. W 37875
(L=200 mm - sectioned)

OZU-345/6 Order no. W 37876
(L=200 mm)



OZU-346

Wt./Mtr. 28.7 kg
Max. load/Mtr. 100T

OZU-346/1 Order no. W 37877
(L=515 mm)

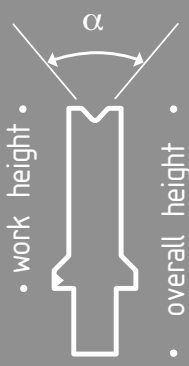
OZU-346/2 Order no. W 37878
(L=550 mm - sectioned)

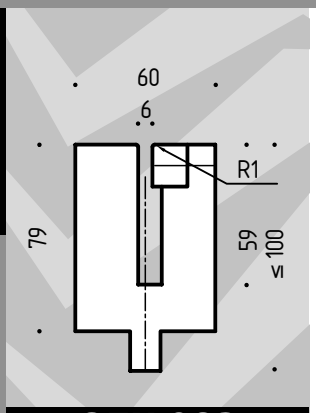
OZU-346/3 Order no. W 37879
(L=200 mm - sectioned)

OZU-346/6 Order no. W 37880
(L=200 mm)

New Standard® Bottom tools

Overbend & flattening tools



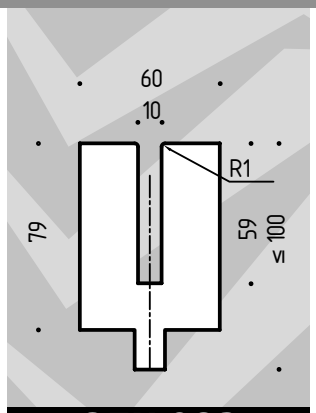


OZU-082

Wt./Mtr 36 kg
Max. load/Mtr. 50T (α=90°)

OZU-082/1 Order no. W 36895 (L=515 mm)

OZU-082/6 Order no. W 36898 (L=200 mm)

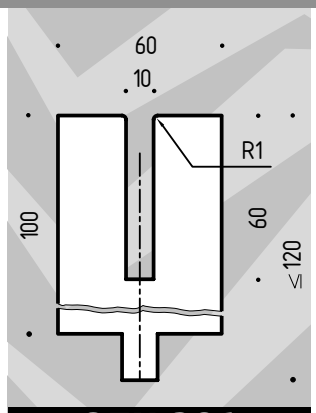


OZU-083

Wt./Mtr. 35 kg
Max. load/Mtr. 50T (α=90°)

OZU-083/1 Order no. W 38360 (L=515 mm)

OZU-083/6 Order no. W 38361 (L=200 mm)

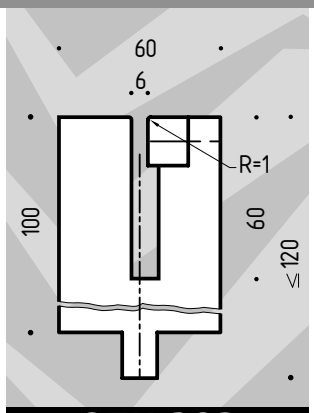


OZU-381

Wt./Mtr. 44.6 kg
Max. load/Mtr. 50T (α=90°)

OZU-381/1 Order no. W 37881 (L=515 mm)

OZU-381/6 Order no. W 37884 (L=200 mm)

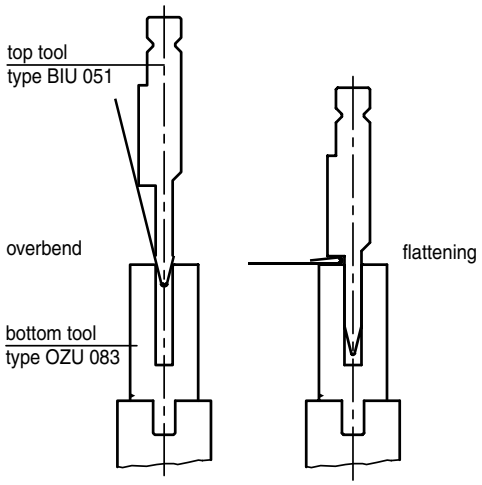


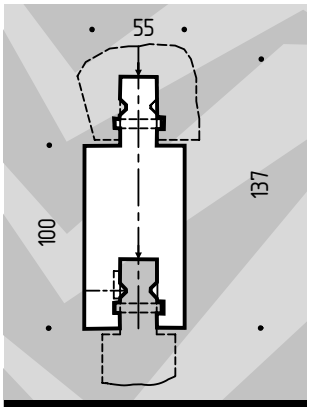
OZU-382

Wt./Mtr. 45.1 kg
Max. load/Mtr. 50T (α=90°)

OZU-382/1 Order no. W 37885 (L=515 mm)

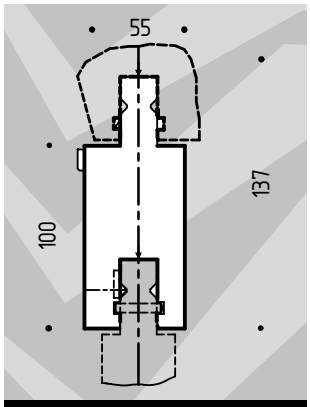
OZU-382/6 Order no. W 37886 (L=200 mm)





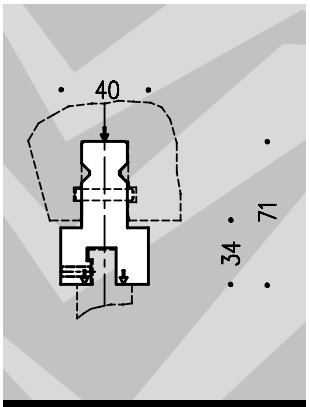
TSU-029

Adapter, top and bottom provided with New Standard® adaptation. Top side, adaptation provided with safety pins/keys. Bottom side with clamping bar.
Work height 100 mm.
Max. Load./Mtr. 100T.
TSU-029/1 length 515 mm
Order no. W 25154
TSU-029/4 length 150 mm
Order no. W 25153



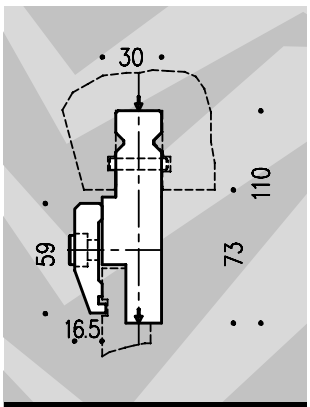
TSU-030

Adapter, top and bottom provided with New Standard® adaptation. Top side, adaptation provided with Safety-Clicks. Bottom side with clamping bar.
Work height 100 mm.
Max. Load./Mtr. 100T.
TSU-030/4 length 150 mm
Order no. W 25157



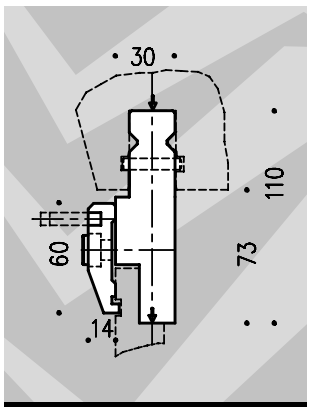
TSU-023

New Standard® to American Style. Adapter, top provided with New Standard® adaptation and safety pins. Bottom provided with American Style I adaptation and 1 clamping screw every 100 mm.
Work height 34 mm.
Max. load/Mtr. 100T.
TSU-023/1 length 515 mm
Order no. W 25131
TSU-023/4 length 150 mm
Order no. W 25130



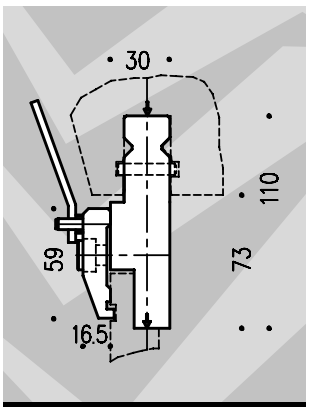
TSU-024

New Standard® to European Style. Adapter, top provided with New Standard® adaptation and safety pins. Bottom provided with European Style I adaptation and with clamping plate type TK-031. (see TSU-020)
Working height 73 mm.
Max. load/Mtr. 100T.
TSU-024/1 length 515 mm
Order no. W 25136
TSU-024/4 length 150 mm
Order no. W 25135



TSU-025

New Standard® to European Style. Adapter, top provided with New Standard® adaptation and safety pins. Bottom provided with European Style I adaptation and with clamping plate type TK-033 (see TSU-022).
Work height 73 mm.
Max. load/Mtr. 100T.
TSU-025/1 length 515 mm
Order no. W 25141
TSU-025/4 length 150 mm
Order no. W 25140

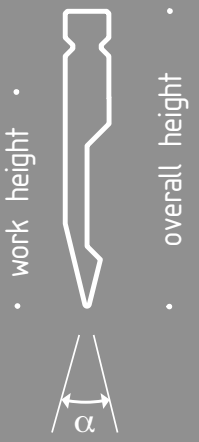


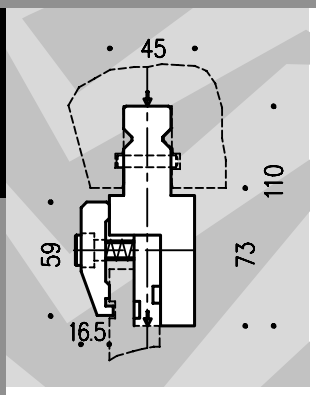
TSU-026

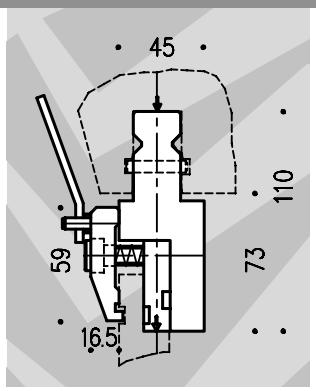
New Standard® to European Style. Adapter, top provided with New Standard® adaptation and safety pins. Bottom provided with European Style I adaptation and with clamping plate type TK-032 (see TSU-021).
Work height 73 mm.
Max. load/Mtr. 100T
TSU-026/1 length 515 mm
Order no. W 25146
TSU-026/4 length 150 mm
Order no. W 25145

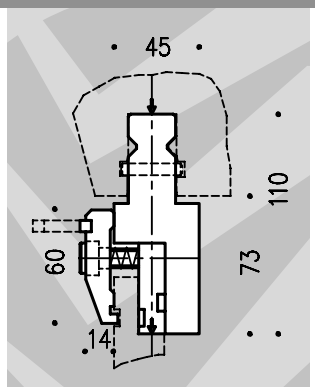
New Standard® Accessories

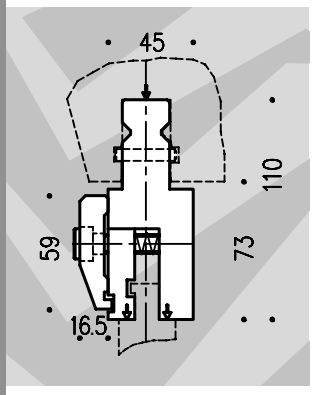
Adapters

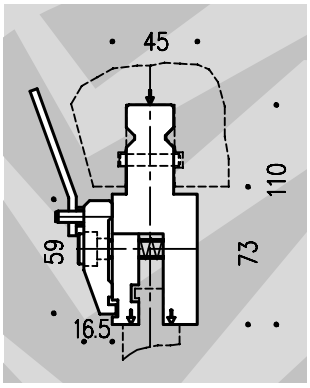


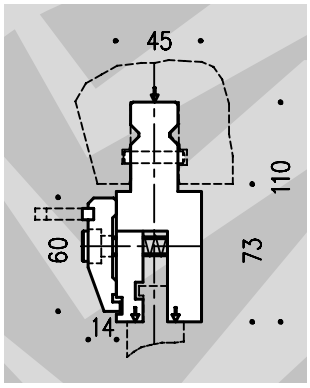


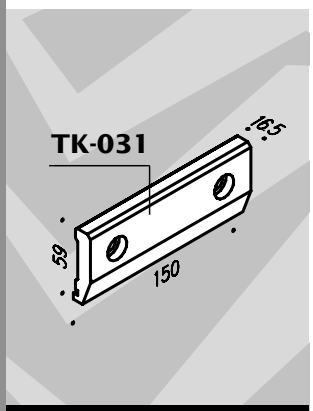


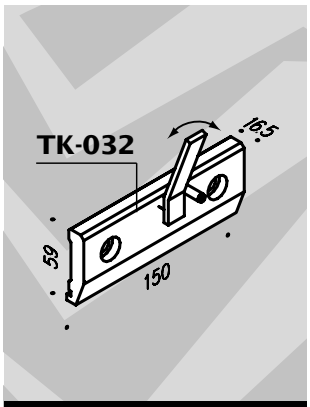


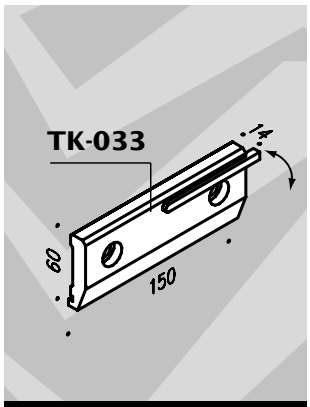












TSU-020

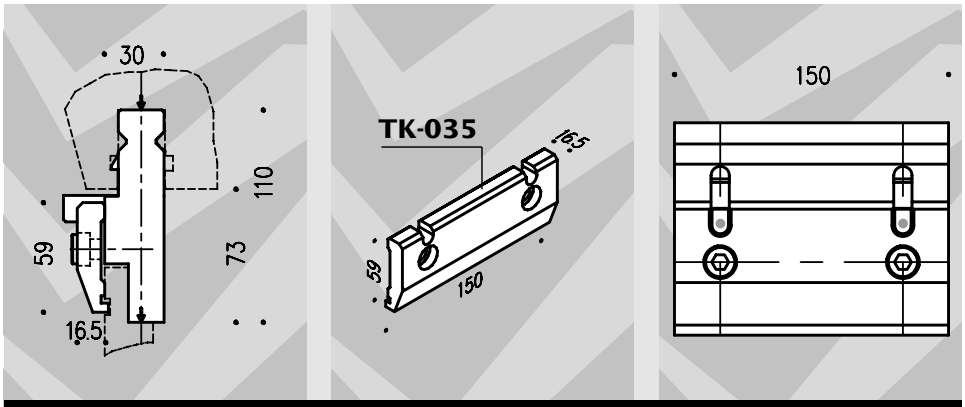
New Standard® to European or American. Adapter, top provided with New Standard® adaptation and safety pins. Bottom side interchangeable between European Style I and American Style adaptation and with clamping plate type TK-031.
Work height 73 mm.
Max. load/Mtr. 100T
TSU-020/1 length 515 mm
Order no. W 25116
TSU-020/4 length 150 mm
Order no. W 25115

TSU-021

New Standard® to European or American. Adapter, top provided with New Standard® adaptation and safety pins. Bottom side interchangeable between European Style I and American Style adaptation and with clamping plate type TK-032.
Work height 73 mm.
Max. load/Mtr. 100T.
TSU-021/1 length 515 mm
Order no. W 25121
TSU-021/4 length 150 mm
Order no. W 25120

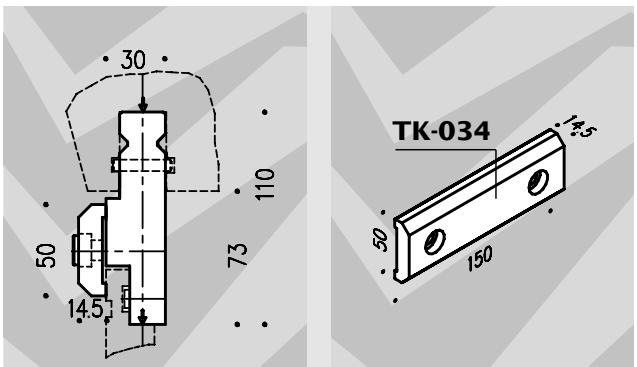
TSU-022

New Standard® to European or American. Adapter, top provided with New Standard® adaptation and safety pins. Bottom side interchangeable between European Style I and American Style adaptation and with clamping plate type TK-033.
Work height 73 mm.
Max. load/Mtr. 100T.
TSU-022/1 length 515 mm
Order no. W 25126
TSU-022/4 length 150 mm
Order no. W 25125



TSU-028

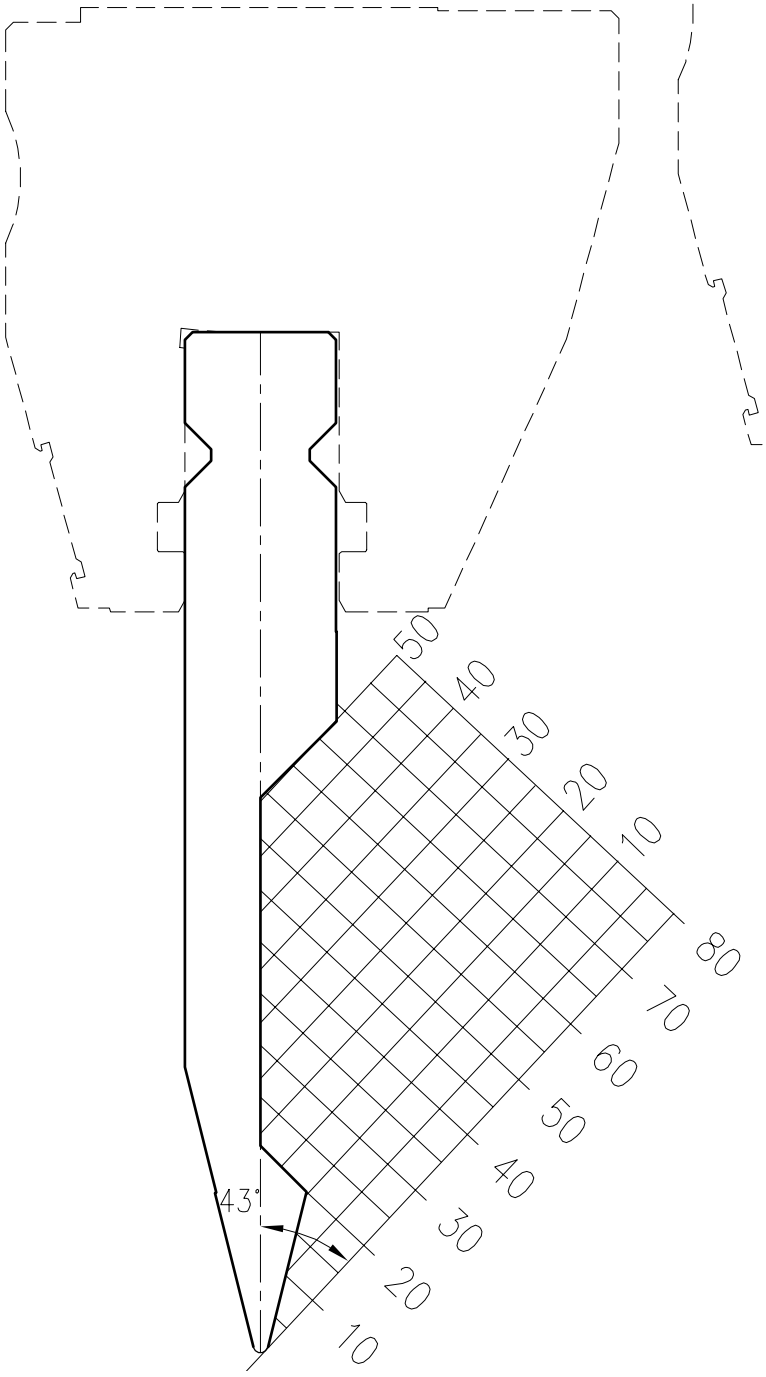
New Standard® to European Style with Safety-Clicks.
Adapter, top provided with New Standard® adaptation and Safety-Clicks. Bottom European Style I adaptation and provided with clamping plate type TK-035 (see TS-024, however provided with extra opening for Safety-Clicks).
Work height 73 mm.
Max. load/Mtr. 100T
TSU-028/4 length 150 mm
Order no. W 25155
Note: max. allowable weight (tooling incl.) 12,5 kg/28 Lbs



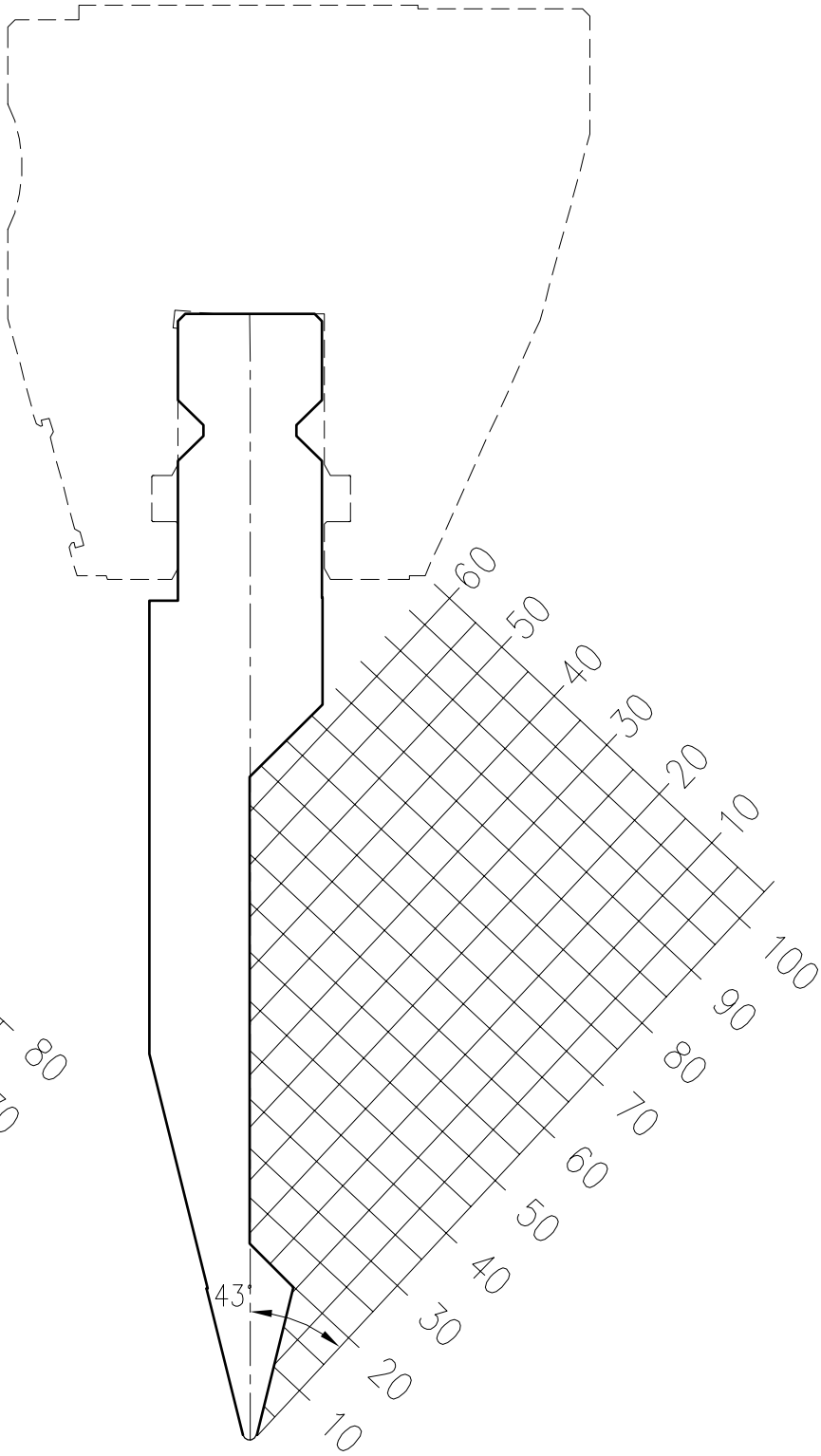
TSU-027

Adapter, top provided with New Standard® adaptation and safety pins. Bottom provided with European Style I adaptation with extra safety-slot, and with clamping plate type TK-034.
Work height 73 mm.
Max. load/Mtr. 100T
TSU-027/1 length 515 mm
Order no. W 25151
TSU-027/4 length 150 mm
Order no. W 25150

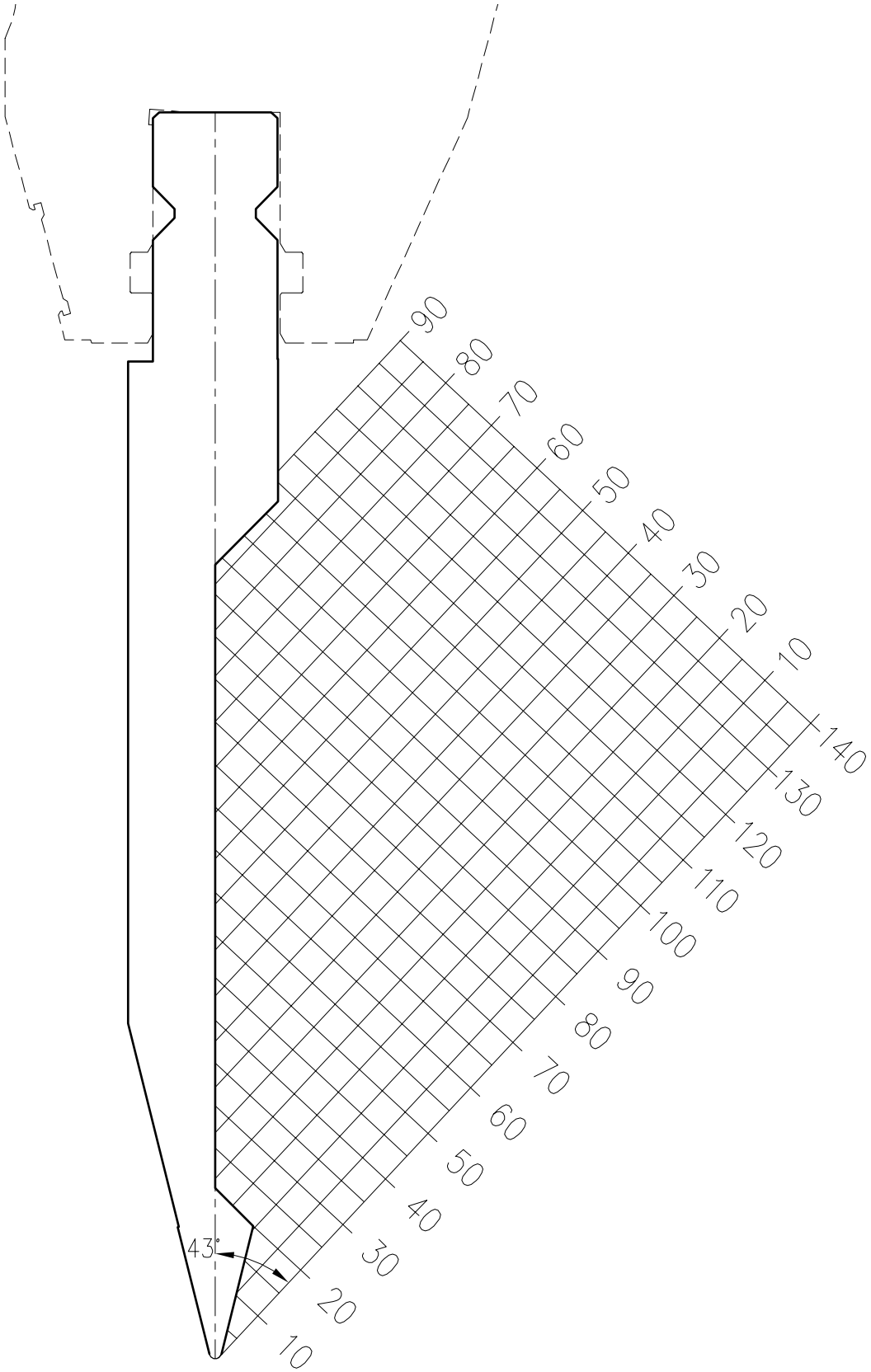
BIU-001 28°



BIU-011 28°



BIU-021 28°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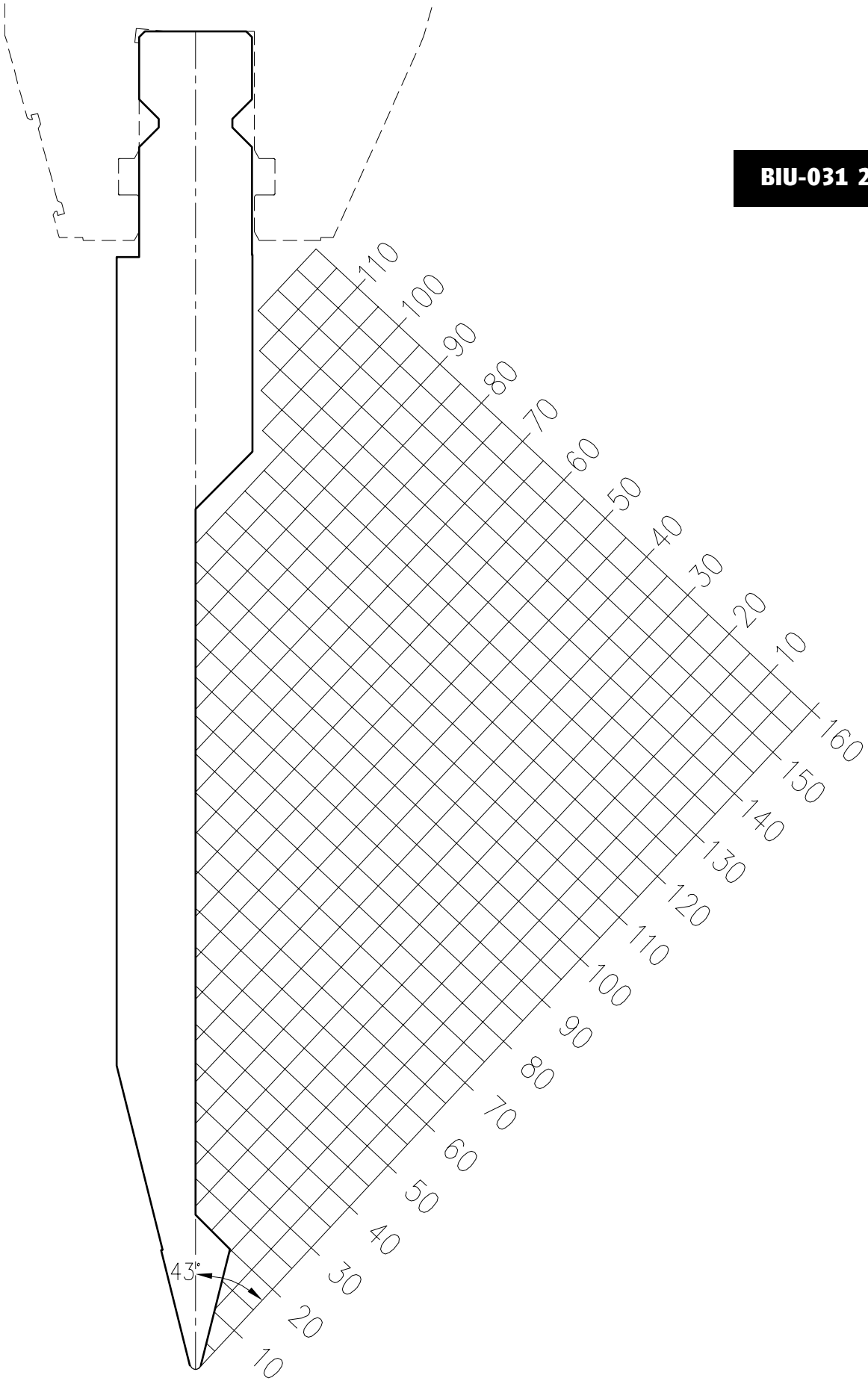
BIU-031 28°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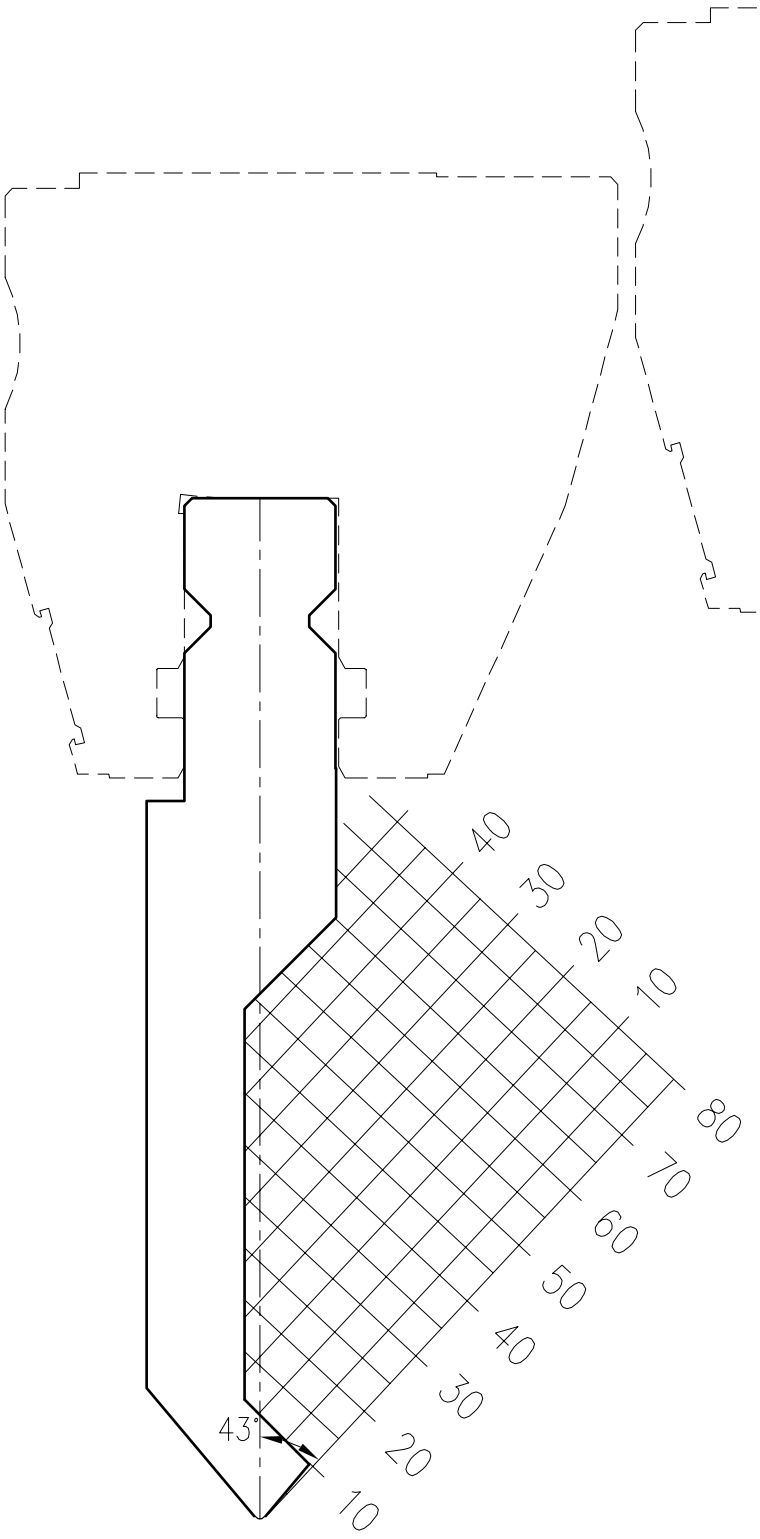
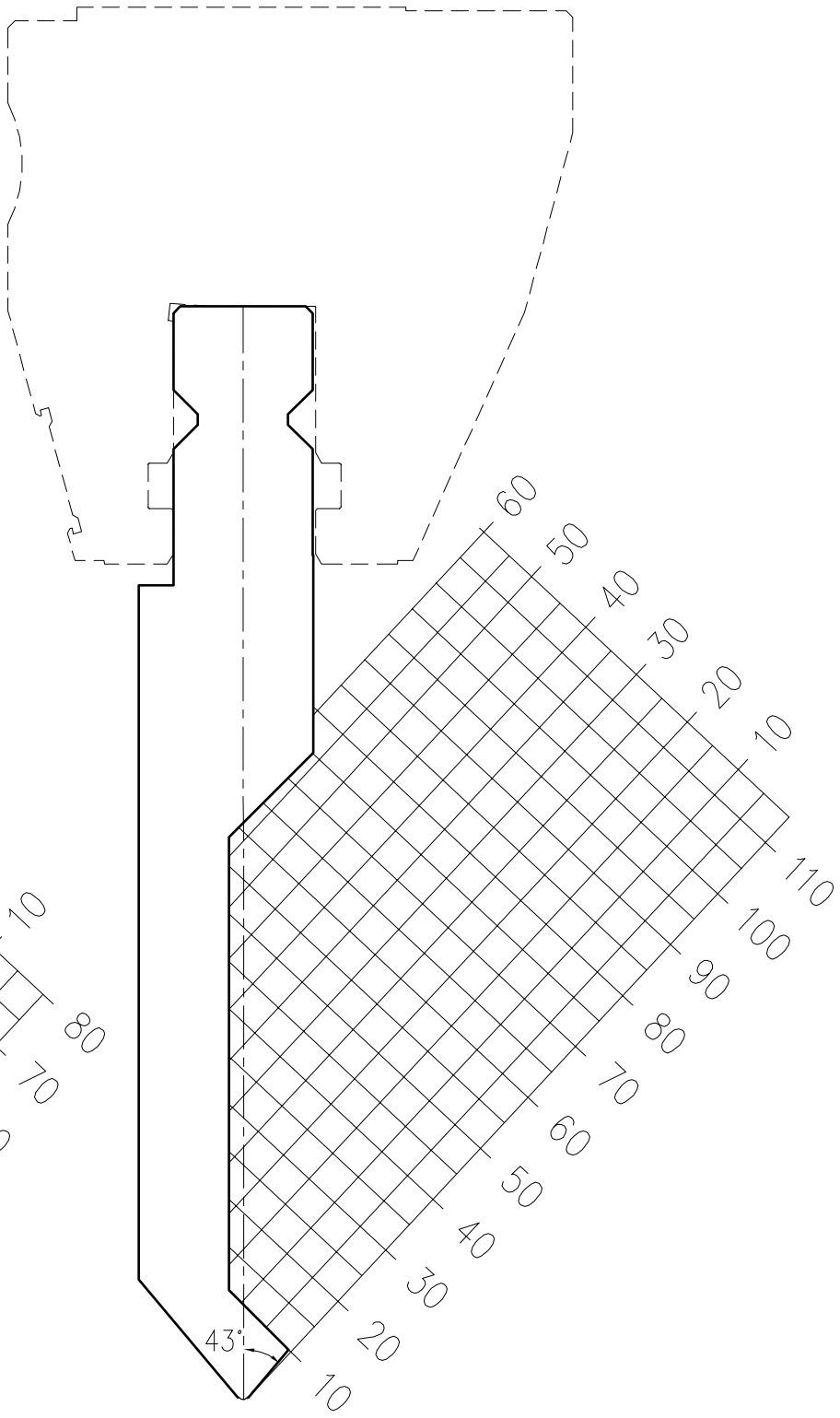
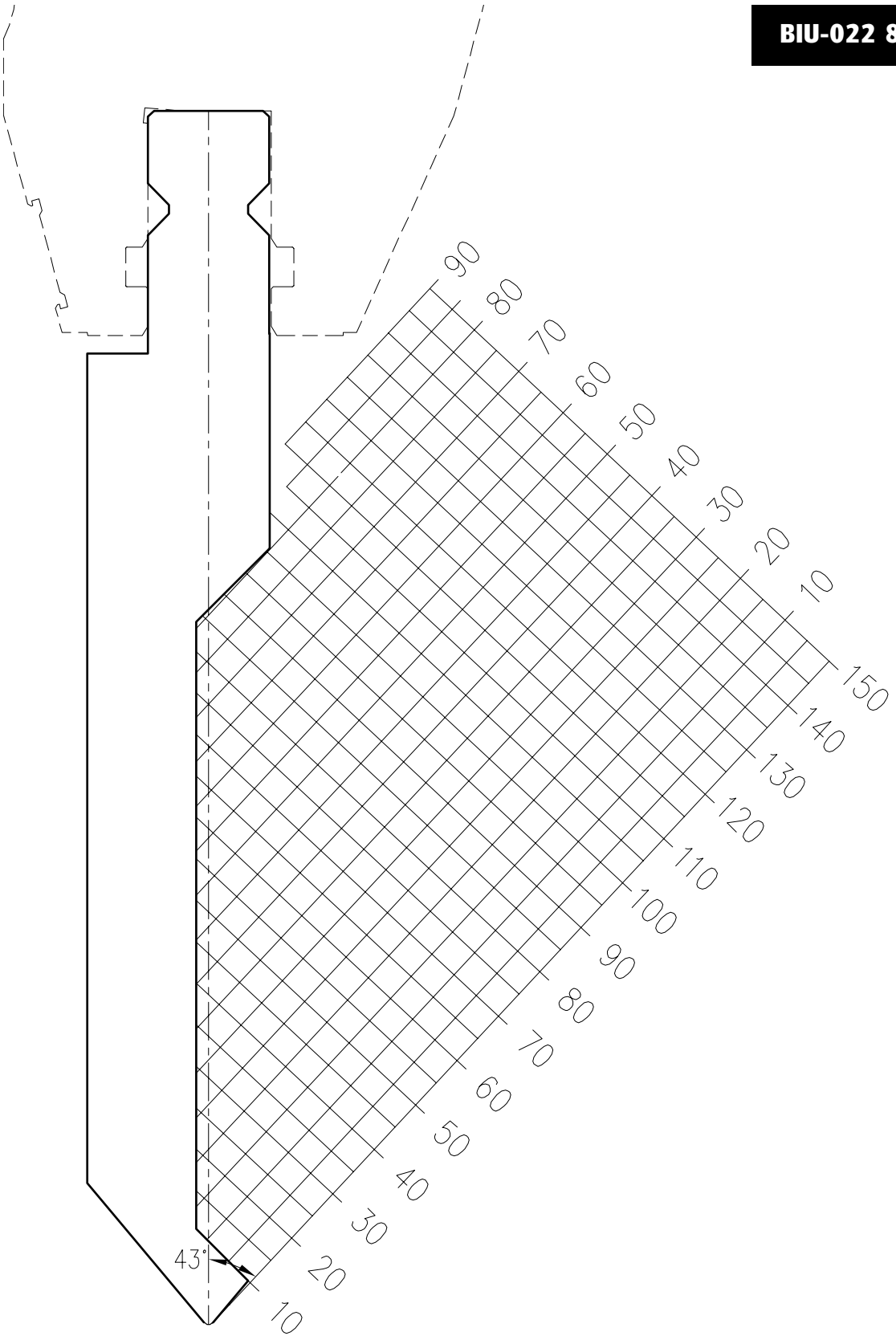
BIU-002 80°



BIU-012 80°



BIU-022 80°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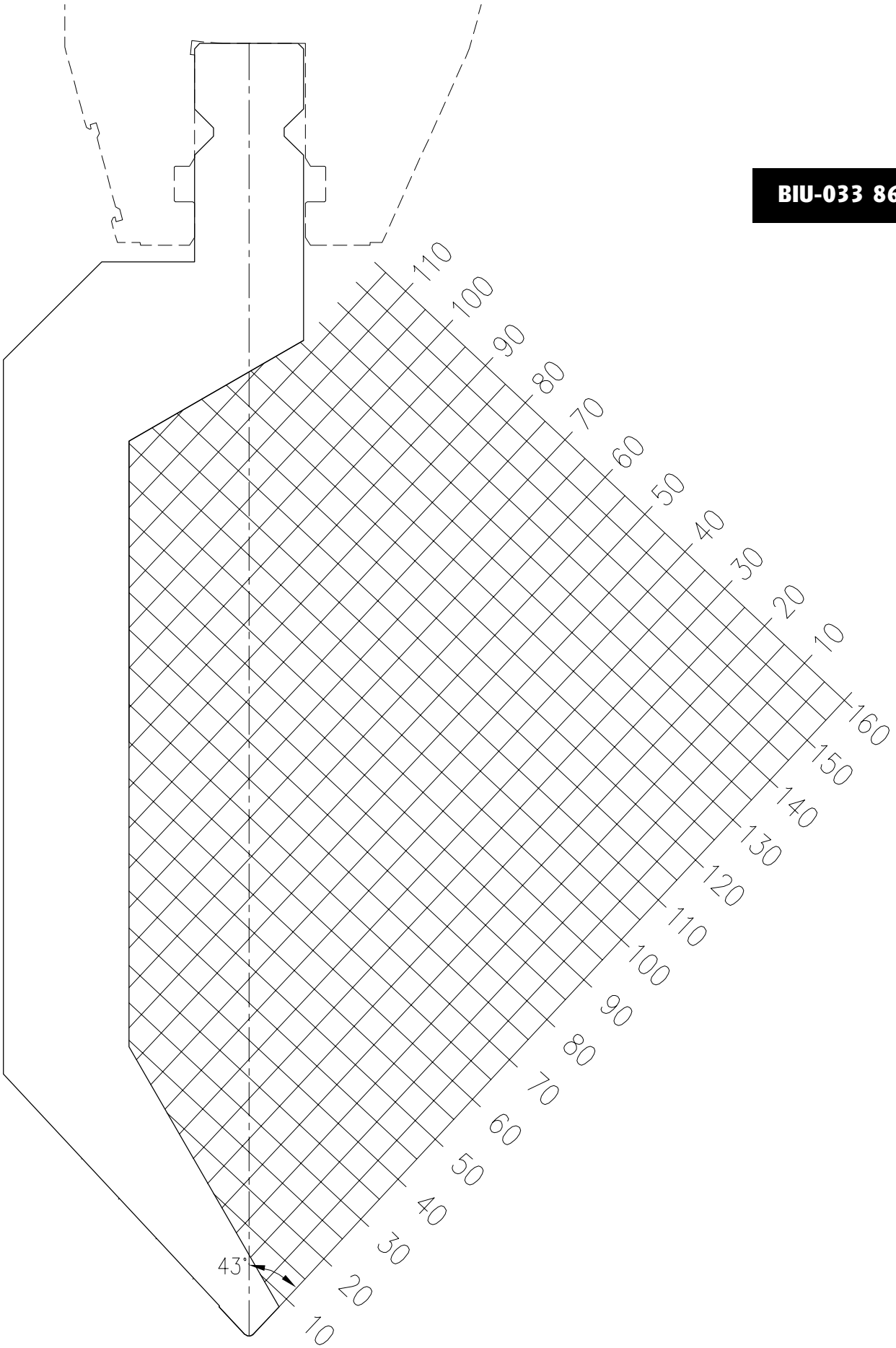
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SPECIAL TOOLING

We have taken great care in the design of our New Standard top tooling to provide a limited number of universal shapes that maximize part clearance and load capacity. This allows you to form a very large variety of parts with the same tool. These universally shaped top tools are available off-the-shelf in a number of different heights to maximize the utilization of your press brake's open height and ram stroke.

We also recognize that there are cases where special tooling is required to properly form a part. At Wila, we have recently taken steps to provide special radius punches and single V-dies with front or rear relief faster and more economically.

Modified Standard Top Tools with Special Nose Radii

We offer almost all of our New Standard top tools with a series of made-to-order nose radii. These special nose radii are precision ground to the same tolerance as our standard tools i.e. +/- .01 mm. These made-to-order tools will also be CNC-Deephardened to a minimum depth of 2.5 mm for maximum durability. Furthermore, we guarantee that subsequent orders for the same punch style nose radius will match up to the initial order.
Made-to-order tools with special nose radii will be laser marked with full tool specifications similar to our standard tools.

Made-To-Order Nose Radius Top Tools:

New Standard
28˚ models: R = 1.5mm, R = 2mm
60˚ models: R = 4mm, R = 5mm
80 thru 90˚ models: R = 2mm, R = 3mm,
R = 4mm, R = 5mm, R = 6mm

Modified Standard Bottom tools with step down relief

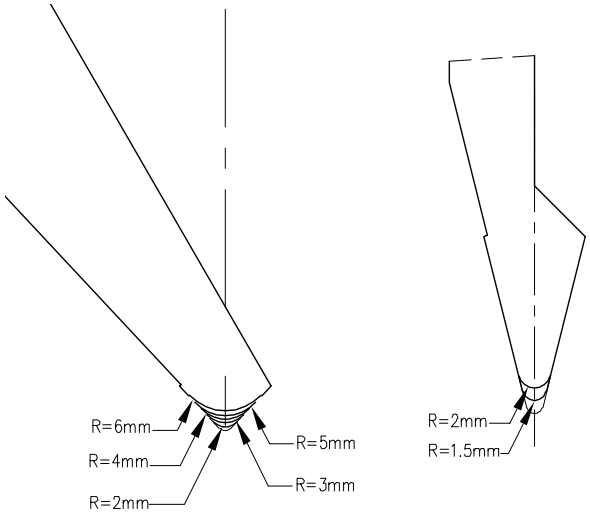
We offer almost all of our New Standard OZU Single V-Dies with V-openings of 6 mm through 12 mm, with an extra step down (cut away) on the front and/or the back side of the die. The step down (cut away) on the front and/or rear side of the die is 2 mm on either side.

Other Specials

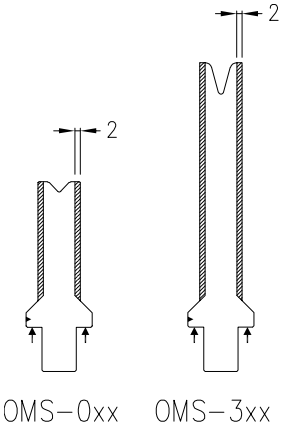
We can, of course, offer other Special Tooling as per your requirements. Please contact our Application Engineering department (quotes@wila.nl) with your specific requirements (see form at page 47).

Top tools BMS with Special Nose radii

New Standard	BIU	BMS (modified standard)	
	Standard radius	Modified radius	Working height
28º	1.0	1.5	-1.5
	1.0	2.0	-3.1
60º	3.0	4.0	-0.9
	3.0	5.0	-1.9
80º	1.0	2.0	-0.5
	1.0	3.0	-1.0
	1.0	4.0	-1.6
	1.0	5.0	-2.2
	1.0	6.0	-2.7
86º	1.0	2.0	-0.4
	1.0	3.0	-0.9
	1.0	4.0	-1.3
	1.0	5.0	-1.8
	1.0	6.0	-2.3
90º	0.6	2.0	-0.5
	0.6	3.0	-0.9
	0.6	4.0	-1.3
	0.6	5.0	-1.8
	0.6	6.0	-2.2
90º	1.2	2.0	-0.3
	1.2	3.0	-0.7
	1.2	4.0	-1.1
	1.2	5.0	-1.5
	1.2	6.0	-1.9



Single V-Dies OMS with front and/or rear step down relief



Special tooling with New Standard adaptation

n *Tools with special geometry (BM and OM)*

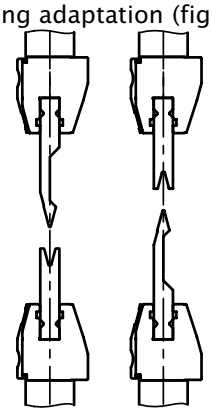
The design of these tools depends on factors like product shape, sheetmetal thickness and the required inside radius. The bending method (air bending or bottom bending) is another important factor. These tools are available in virtually any design and with various surface hardenings. The profile section of the tool can be planed or ground, as desired. The BM and OM tools can be supplied upon request with a New Standard (in this case, head or shoulder-bearing as desired) adaptation. All of the tools of the BM and OM type can be supplied in four standard lengths.

n *Bottom Tool with New Standard adaptation (OM 0 - 599)*

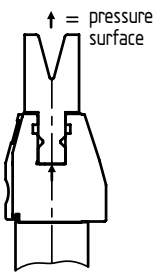
The demand for tools of this type is gradually increasing because New Standard Adaptation is becoming increasingly popular for both top and bottom tools. This offers the considerable advantage that top tools can be used in the bottom clamps and bottom tools can be used in the top clamps (fig. 4.6). This advantage is especially evident when a robot is used to manipulate the sheet: The sheet no longer needs to be rotated for bending in the opposite direction.

Automatic Tool Changing (ATC) for both the top and the bottom tools is possible in this manner. All bottom tools in Wila's New Standard OZU program can also be supplied with a New Standard adaptation.

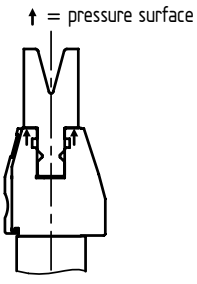
Tools with a V opening of up to 24 mm are equipped with a head bearing mount. In order to safeguard their stability, V-dies with V-openings larger than 24 mm have a shoulder bearing adaptation (fig. 4.7 and 4.8).



n **fig. 4.6**



n **fig. 4.7**



n **fig. 4.8**

Please photocopy this page, complete the information and fax back at Wila +31(0)573257597 / E-mail: quotes@wila.nl

CUSTOM STYLE TOOLS SPECIFY FORM

Company name:

Address:

City: Postal code:

Country:

Contact person: Mrs/Ms/Mr

Phone: Fax: E-mail:

Date:

PRESS BRAKE INFORMATION:

Brand name:

Model:

Tonnage: ton

Length: mm

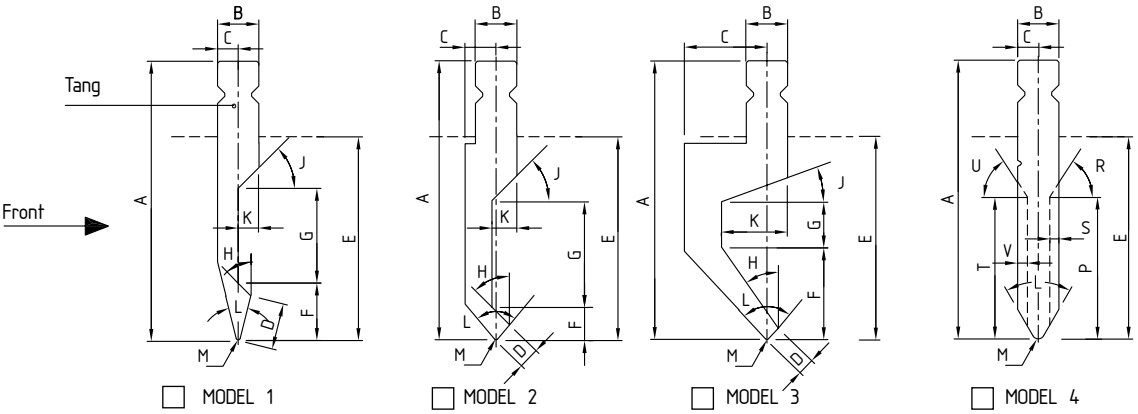
PRODUCT INFORMATION:

Number:

Material:

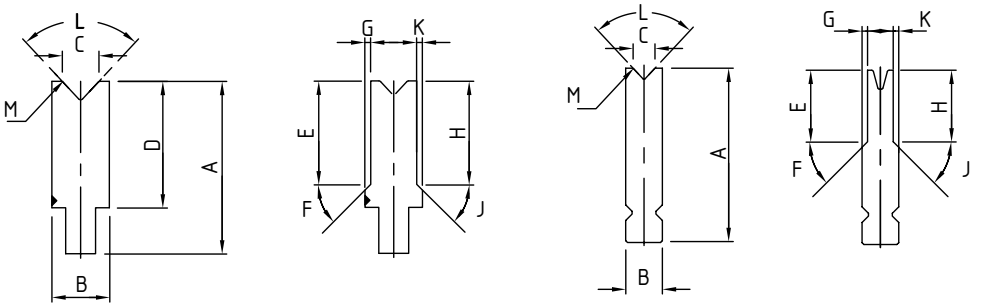
Length: mm

REQUESTED TOP TOOL MODEL:



☐ MODEL 1 ☐ MODEL 2 ☐ MODEL 3 ☐ MODEL 4

REQUESTED BOTTOM TOOL MODEL:



☐ MODEL 1 ☐ MODEL 1B ☐ MODEL 2 ☐ MODEL 2B

LENGTH TOOL = ... mm

LENGTH SEGMENTED: ☐ No ☐ Yes

Required segments: ☐ xxx/1 (.....off.) ☐ xxx/2 (.....off.) ☐ xxx/3 (.....off.) ☐ xxx/6 (.....off.)

☐ Other .....

HARDENING OF THE BENDING RADII / NOSE RADIUS:

☐ No ☐ CNC-deephardened (max. length of tool about 550 mm, not possible with model 3) ☐ Nitrated

MATCHING

Will tools be used in combination with existing top tools? ☐ No ☐ Yes (we need your model L≥ 100 mm), to guarantee matching)

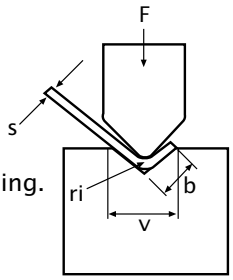
FOR ADDITIONAL INFORMATION MAKE YOUR OWN SKETCH

AIR BENDING TONNAGE CHART

Required press force at 90˚ air bending, force in ton/mtr.
The charts below give the appropriate tonnage to air bend mild steel.
Bending force for other metals:

Soft aluminum : Tons per unit length x 50%
Aluminum alloys heat treated : Tons per unit length x 100%
Stainless : Tons per unit length x 150%

Bottoming: Tonnage requirements are three to five times greater than for air bending.



s = Material thickness
ri = Inside radius of formed part
v = V-die opening
b = Minimum flange

Metric

(F = tons per meter of workpiece)

	v(mm)	4	6	8	10	12	16	20	22	25	32	40	50	63	80	100	125	160
	b(mm)	2.8	4.2	5.6	7.0	8.6	11.5	14.4	15.8	18.0	24.0	30.0	37.5	47.3	60.0	75.0	96.3	123.2
	ri(mm)	0.7	1.0	1.3	1.7	2.0	2.7	3.3	3.7	4.2	5.3	6.7	8.3	10.5	13.3	16.7	20.8	26.7
s(mm)																		
0.5		4.5	2.8															
0.6		6.0	4.2	3.2								APPROX MULTIPLIERS FOR SELECTING V-OPENING						
0.8			8.0	5.6	4.4							Material Thickness			0,7mm or less = s x 6			
1.0			11.0	9.0	7.0	5.5									3.0mm or less = s x 8			
1.2	T				13.2	10.8	8.4	6.6							9.0mm or less = s x 10			
1.4	O			15.4	14.0	12.6	8.8								14mm or less = s x 12			
1.6	N				17.6	16.0	11.2	8.8										
2.0	S					22.0	18.0	14.0	12.5	11.0								
2.3							23.0	18.4	16.1	14.4	12.7							
2.6	P						28.6	23.4	20.8	18.2	14.3							
3.0	E							30.0	28.5	27.0	21.0	16.5						
3.2	R							35.2	32.0	28.8	22.4	17.6	14.4					
3.5									38.5	35.0	28.0	21.9	15.8	14.0				
4.0	M									44.0	36.0	28.1	20.3	18.0				
4.5	E										45.0	36.0	28.1	20.3				
5.0	T										55.0	45.0	35.0	26.3	22.5			
6.0	E											60.0	54.0	37.5	31.5	24.0		
7.0	R													56.0	43.8	31.5	28.0	
9.0															72.0	56.3	40.5	
10.0															90.0	70.0	52.5	45.0
12.0																108.0	84.0	63.0
16.0																	144.0	112.0

TONNAGE CHART FOR FLATTENING

Mild steel

	Rm≈42 KN/cm²		Rm≈42 KN/cm²	
Thickness	**Tonnage**	**D**	**Tonnage**	**D**
Mm	Ton/meter	Mm	Ton/meter	Mm
0.6	12	2.3	20	1.3
0.8	16	2.3	30	1.7
1.0	20	2.4	30	2.2
1.2	24	3.0	40	2.5
1.5	30	4.4	50	3.5
2	40	5.1	60	4.2

PRESS BRAKE PRODUCTIVITY GUIDE®

Would you like to know everything – and we mean everything – about press brake productivity, in theory and in practice? Wila's Press Brake Productivity Guide, a 220 page book, can justifiably be named 'the complete manual for the press brake world'. If you are interested, please contact us.

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TERMS

Credit: New customers should furnish us with a banking reference and 3 supplier references (or your D&B rating) prior to Wila's acceptance of the first order.

Payment: Terms are net 30 days from date of invoice for all standard items. Prices are EXW Lochem, The Netherlands.

Packing: For standard packing we charge 1,5% of the price list price with a minimum of € 10 per order.

Returns: Prior approval, a Wila RMA# and shipping instructions are required prior to any material return. A handling charge of 20% is made on all standard items returned. Special tooling cannot be returned.

Claims: All claims and shortages must be made by e-mail, fax or mail within 10 days of invoice date.

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DISCLAIMER

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SAFETY WARNING

All Wila standard top tools include a safety adaptation, respectively a safety device incorporated in the adaptation. (New Standard and American Style top tools either have a Safety-Click®, Fixed Safety Pins or Fixed Safety Keys).

When using top and bottom tools on a press brake, a forming system is created which requires analysis to determine the appropriate safeguarding for operator safety and protection.

It is the user's responsibility to ensure that the point of operation is effective and all applicable safety requirements are met.

Safe use of Wila's New standard tools is only guaranteed when used in Wila's clamping systems. Wila will not be held liable for unsafe use and consequences there of in combination with non-Wila clamping systems.