

**SUPERCHARGE YOUR PRESS BRAKE!**

# PRESS BRAKE RETROFIT PROGRAM



October 2018

 **WILA**  
SINCE 1932  
THE PRESS BRAKE PRODUCTIVITY PEOPLE



# SUPER-CHARGE YOUR PRESS BRAKE

**GROW  
YOUR  
BUSINESS**

with WILA

**Craig Burk | Plant Supervisor, Standard Sheet Metal**

"Before the upgrade, we'd have to round up two or three guys to put in one of our dies, some of which weigh up to 400 lbs, or we'd have to use a forklift. On top of that, some of our older dies just didn't make sense. Now, they just pop the new dies in, press the hydraulics and they're done."

**READ THE FULL STORY**  
[wilausa.com/retrofit-program](http://wilausa.com/retrofit-program)

## WILA RETROFIT PROGRAM

When a new press brake isn't in the budget, the WILA Retrofit Program can be a great way to extend the life of your current press brake, improve performance, and make your bending operations more productive. A WILA retrofit can be performed on any press brake, adapting it for use with WILA New Standard or American Style tooling, clamping, and crowning. With installations typically requiring no more than a few hours and no custom machining, a WILA retrofit provides instant, bolt-on performance for your press brake operations. **GROW YOUR BUSINESS WITH WILA.**



## INSTANT BOLT-ON PRESS BRAKE PERFORMANCE.

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## WILA'S VALUES

### SPEED

WILA's award-winning technology allows for easy, quick-change of all top and bottom tools.

### FLEXIBILITY

No matter what brand and size press brake, WILA's precision Clamping and Crowning systems can be configured to be easily mounted to any style ram or bed.

### ACCURACY

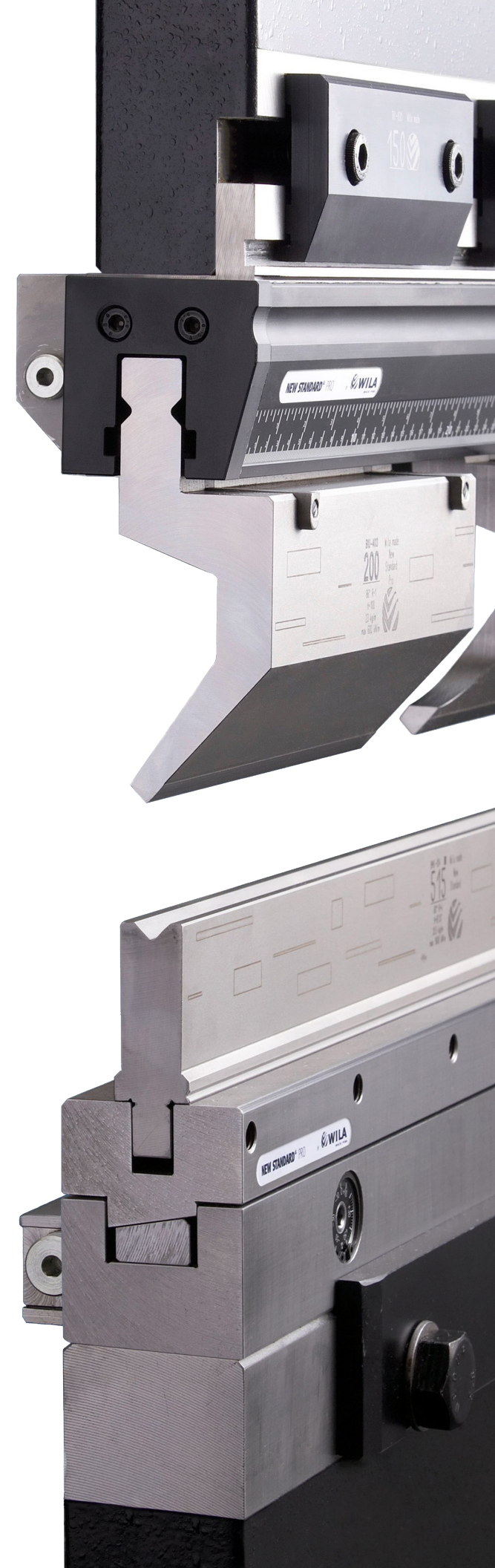
All WILA's New Standard and American Style tools and accessories have a modular structure and have been created with the highest level of precision, with guaranteed tolerances of  $\pm 0.0004$ " for all New Standard tools and  $\pm 0.0008$ " for all American Style tools.

### DURABILITY

With proper care, WILA tools will maintain their accuracy and efficiency for many years to come. New Standard and American Style tools are CNC-Deepph hardened® (56-60 HRc) for all bending radii.

### SAFETY

WILA takes no risks when it comes to creating safe working environments. Product features such as Safety-Click system and segmented tooling allows easy, safe, and efficient single operator handling.





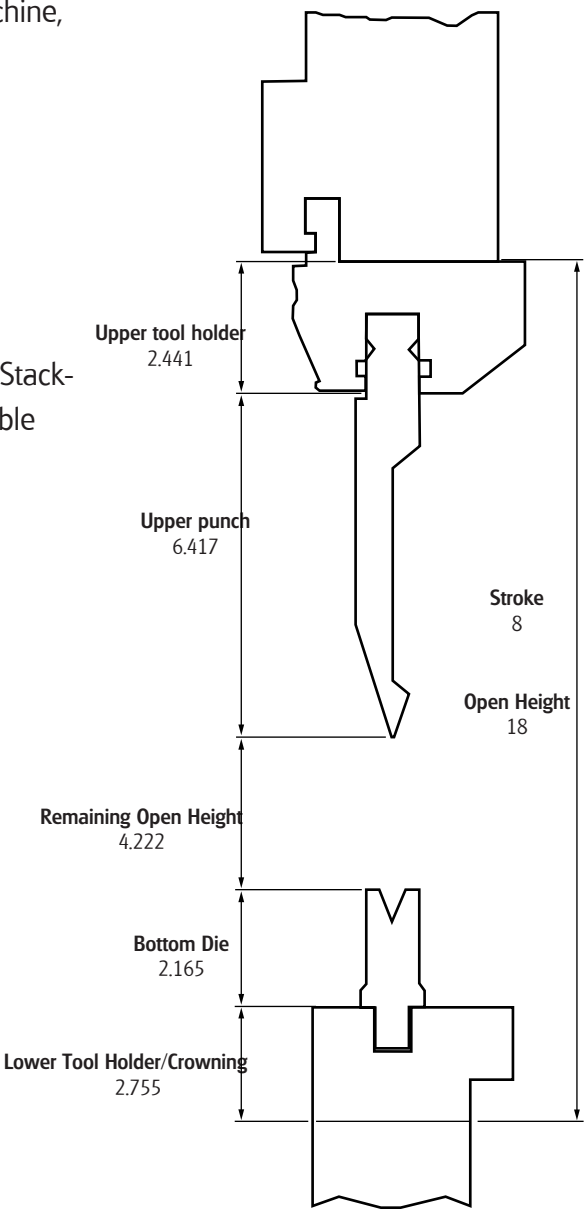
# WILL IT WORK FOR MY MACHINE?

When determining if a press brake retrofit is right for your machine, it is important to consider the following:

- Physical condition of press brake
- Existing press brake features, technology, and capability
- Available open height of your machine
- Ram repeatability

Visit the link the bottom of this page to access WILA's Retrofit Stack-Up Calculator (pictured right and below) for determining available open height and die penetration.

Open Height (Inch)	18
Stroke (Inch)	8
Upper Tool Holder (Inch)	2.441
Upper Punch (Inch)	6.417
Bottom Die (Inch)	2.165
Lower Tool Holder / Crowning (Inch)	2.755
Remaining Open Height (Inch)	4.222
Die Penetration (Inch)	-3.778



## Retrofit Assessment Guide

Download the Retrofit Assessment Guide to access the complete Return on Investment Chart, Return on Investment Calculator, WILA Stack-Up Calculator, and Machine Retrofit Information Form that asks for data about your press brake in order to provide you with a WILA retrofit solution.



[www.wilausa.com/retrofit-program](http://www.wilausa.com/retrofit-program)

# SPEND LESS. BEND MORE.

Opting for a retrofit over investing in a new press brake can save a lot of money in your initial investment while yielding high returns in productivity for the long term.

In alignment with lean manufacturing strategy, WILA's quick change tooling, clamping, and crowning systems enable our customers to work smarter, not just harder. Customers who switch to WILA can expect faster throughput, better part quality, reduced scrap materials, and reduced work-in-process inventory.

At WILA, we understand that you want your investment to work for you, which is why we have put together a variety of tools in our Retrofit Assessment Guide, to help you make the most informed decision possible for your business. In the Retrofit Assessment Guide, you can find financial tools to help you determine your return on investment and technical resources to help determine feasibility of implementation.

## The cost of non-value-added-time

Independent studies and customer feedback have shown that converting to WILA precision quick change tooling typically results in an 80% reduction in average tooling setup time. Reducing this non-value-added time allows for higher labor and machine utilization rates, resulting in increased profitability.

WILA's ROI Chart makes it easy for you to project your annual additional revenue and estimate the time it takes for your investment to pay for itself. Accounting for an 80% improvement in average tooling setup time, the ROI Chart prompts you to consider your average number of setups per day, average setup time, and your burden rate. Using these factors, you can instantly see your projected yearly time savings.



WILA's segmented tooling provides maximum flexibility and versatility.

The ROI Chart displayed below is only a sample of our full chart, which can be found in our Retrofit Assessment Guide, along with a description on how to use the chart. To calculate based on various hourly rates and number of setups per day, you can download the Retrofit Assessment Guide online and access the complete ROI Chart.

Non-Value-Added Time (minutes)	Hourly Rate	Minute Rate	Daily Cost - 4 Set Ups Per Day	Annual Cost	Yearly Savings at 80%
15	\$ 60	\$ 1.00	\$ 60	\$ 15,600	\$ 12,480
30	\$ 60	\$ 1.00	\$ 120	\$ 31,200	\$ 24,960
45	\$ 60	\$ 1.00	\$ 180	\$ 46,800	\$ 37,440
60	\$ 60	\$ 1.00	\$ 240	\$ 62,400	\$ 49,920

Non-Value-Added Time (minutes)	Hourly Rate	Minute Rate	Daily Cost - 8 Set Ups Per Day	Annual Cost	Yearly Savings at 80%
15	\$ 75	\$ 1.25	\$ 150	\$ 39,000	\$ 31,200
30	\$ 75	\$ 1.25	\$ 300	\$ 78,000	\$ 62,400
45	\$ 75	\$ 1.25	\$ 450	\$ 117,000	\$ 93,600
60	\$ 75	\$ 1.25	\$ 600	\$ 156,000	\$ 124,800


\*\* All annual calculations are based on a 52 week production calendar.

Use the provided pricelist to estimate common retrofit project costs for use with the Return on Investment Calculator on the next page. For a complete list of products and pricing, please reference WILA's Press Brake Productivity Catalog or speak with your sales representative.

Model	Type	2380mm (8ft)	3060mm (10ft)	3655mm (12ft)	4250mm (14ft)
NSCL-I-HC	New Standard Hyd Clamping	\$8,490	\$10,090	\$11,590	\$13,090
ASCL-I-HC	American Hyd Clamping	\$8,290	\$9,790	\$11,165	\$12,890
NSCR-I-HC-H	Crowning with Hyd Clamping	\$13,395	\$15,795	\$18,045	\$19,995
NSCR-I-MC-H	Crowning with Mech Clamping	\$9,275	\$10,395	\$11,875	\$13,395
OB-I-HC/ES IV	Bottom Holder with Hyd Clamping	\$4,900	\$5,900	\$6,700	\$7,600
OB-I-MC/ES IV	Bottom Holder with Mech Clamping	\$2,800	\$3,400	\$3,900	\$4,400
HM-11	Hyd Power Pack	\$2,975	\$2,975	\$2,975	\$2,975
2nd Hyd Hose	Needed for both top and bottom hyd clamping	\$240	\$240	\$240	\$240

WILA's Return on Investment Calculator utilizes the same concepts used in the Return on Investment Chart but takes it a step further by using cost of investment to determine the time it takes to payoff your investment. To determine the number of months required for payback, simply fill in the yellow squares - the calculator will make all necessary calculations for you.

An example scenario is provided below:



**WILA**

SINCE 1932

**THE PRESS BRAKE PRODUCTIVITY PEOPLE**

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**COST JUSTIFICATION WORKSHEET: WILA CLAMPING, CROWNING, AND TOOLING SYSTEMS**

1	Average Non-Value Added Time (minutes) per set up	20	
2	Hourly Rate	\$ 75.00	
3	Minute Rate	\$ 1.25	
4	Average Number of Set-Ups Per Day	8	
5	Daily Cost	\$ 200.00	
6	Monthly Cost	\$ 4,200.00	
7	Yearly Cost	\$ 52,000.00	
8	Daily Savings at 80%	\$ 160.00	
9	Monthly Savings at 80%	\$ 3,360.00	
10	Yearly Savings at 80%	\$ 41,600.00	
11	Cost of WILA Clamping System	\$ 10,395.00	
12	Cost of WILA Crowning System or Lower Tool Holder	\$ 10,090.00	
13	Cost of WILA Power Pack	\$ 2,975.00	
14	Cost of WILA Tooling	\$ -	
15	Cost to Install WILA Components	\$ 500.00	
16	Total Cost of WILA Components with Installation	\$ 23,960.00	
17	Total Number of Months Required for Payback	7.1	
18	Projected Cost Savings Over Three Years	\$ 124,800.00	
19	Projected Cost Savings Over Five Years	\$ 208,000.00	
20	Projected Cost Savings Over Ten Years	\$ 416,000.00	

**NOTE:** Only enter numbers into the yellow cells. All other numbers are generated by formulas in the worksheet.

1. Begin by entering your average setup time

2. Then enter your hourly burden rate

3. Enter your average number of set-ups per day

4. Calculate the cost of your investment

Number of months required to payoff retrofit investment



# CLAMPING SYSTEMS

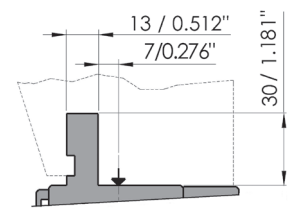
Improve setup times by up to 10 times faster with hydraulic clamping and quick change tooling - easily mounted on any style press brake ram!

WILA's state-of-the-art clamping systems offer the ultimate solution when it comes to efficiently changing tools - both hydraulically and mechanically. Several innovations, like the Safety-Click® and E2M® (Easy-To-Move) for heavy tools, have made the changeover process easier, faster and safer. Accuracy and ergonomics have been combined to achieve the highest level of productivity. Vertical tool loading with WILA Safety-Click technology and automatic clamping, self-seating, and alignment in seconds makes press brake operations safer, faster, and more efficient.

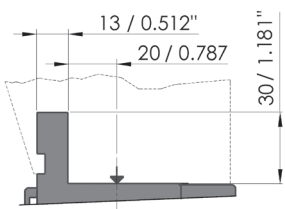
WILA's New Standard or American Style clamping systems can be easily mounted and installed on any press brake, regardless of ram style and tang type.

## Common retrofit mounting options for upper Clamping Systems

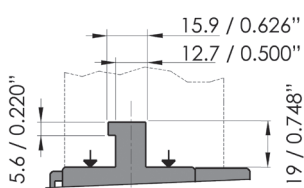
\*No matter what brand and size press brake, WILA's upper tool holders can be configured to be easily mounted to any style ram.



ES I European Style Adaption



ES II European Style Adaption



AS I American Style Adaption

## SAFETY-CLICK®



The Safety-Click® is WILA's patented safety mechanism which has been integrated into top tools with a weight up to 12.5kg/28lbs. This revolutionary mechanism allows tools to be changed vertically by simply clicking them in and out of the clamping.

## REVERSIBLE TOOLS

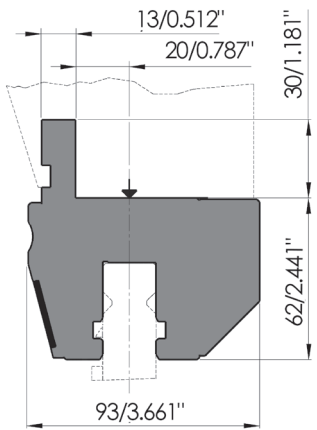


Because New Standard and American Style tools are symmetrical in relation to the centerline, these (top) tools can be easily rotated, such as when bending a reverse flange with a gooseneck tool.

## NSCL-I-HC New Standard Pro Clamping



Shown with Hydraulic Clamping for ES II European style ram adaption.



WILA Clamping Systems can be configured for use with any style ram. To view more options, please reference our Press Brake Productivity Catalog.



NSCL-I-HC/AS I



NSCL-I-HC-TY/ES II

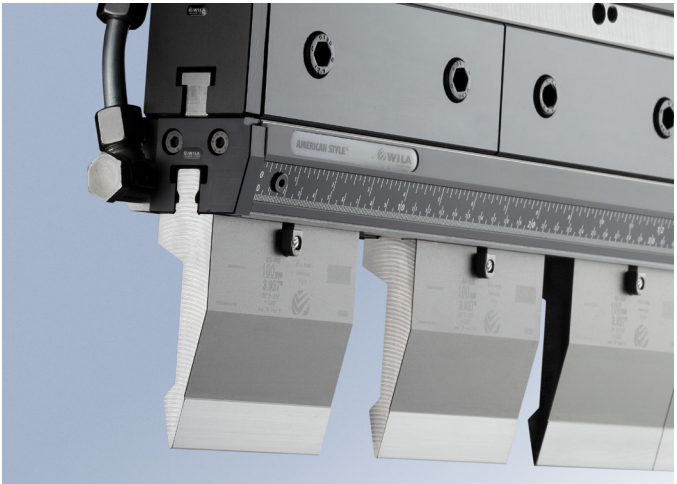


ASCL-I-HC/ES II

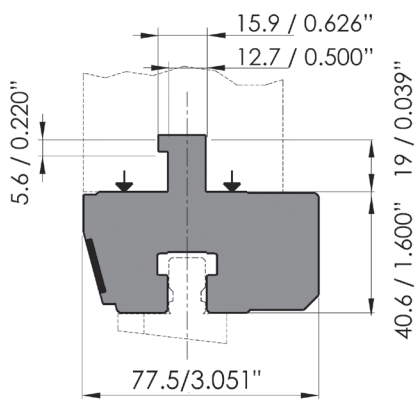


ASCL-I-HC-TY/ES II

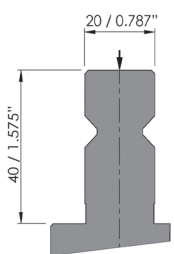
## ASCL-I-HC American Clamping



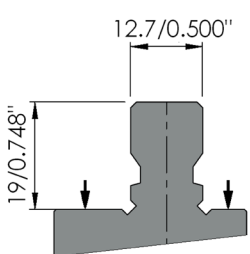
Shown with Hydraulic Clamping for American Style ram adaption.



## ADAPTION



New Standard I Tang (20mm)



AS II American Style (0.5")

## HYDRAULIC POWER PACKS



For use in combination with Tool Holders with Hydarulic Clamping. Operation via push button on the power pack or via remote control. Available in 208 - 230 - 460 - 575 volt 3 phase.

# CROWNING SYSTEMS / BOTTOM HOLDERS

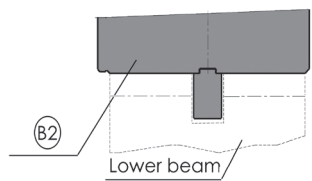
WILA Crowning systems fully compensate for the deflection in press brakes. This results in a consistent bending angle across the entire length of the machine, eliminating the need for time consuming shimming of dies. WILA New Standard Crowning Systems utilize a series of patented adjustable wedges known as Wila Waves. This opposing wave technology features centralized adjustment from a single point, making for simple and ultra-fast set-ups.

WILA bottom holders are a great option for short length machines or machines with existing crowning systems already built in.

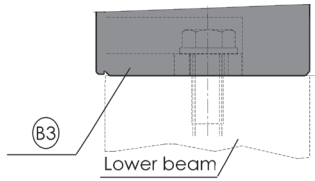
WILA New Standard Crowning systems and OB Bottom Tool Holders can be fitted to any press brake, regardless of your existing bed configuration. New Standard Crowning systems and OB Bottom Tool Holders will clamp both New Standard and American Style bottom tools.

## Common retrofit mounting options for Crowning Systems and Bottom Tool Holders

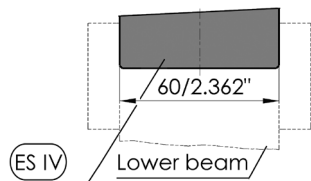
\*WILA's crowning and bottom tool holders can be configured to be easily mounted to any style press brake bed.



B2 Adaption for tang mounting to slot in lower beam



B3 Adaption for mounting to lower beam to existing bolt-hole pattern



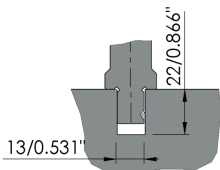
ES IV Adaption with 60mm wide flat bottom

## V-LOCK®



The V-Lock® improves the clamping and positioning of bottom tools. A groove in the tool tang allows specially designed clamping pins to automatically align and firmly clamp bottom tools in both X and Y directions. All newly manufactured New Standard Crowning and Bottom Tool Holders are supplied with specially designed clamping pins for use with the V-Lock® feature.

## BOTTOM ADAPTION



NSCR Crowning Systems and OB Bottom Tool Holders will clamp bottom tools with 13mm / 0.512" or 12.7mm / 0.500" wide tangs.

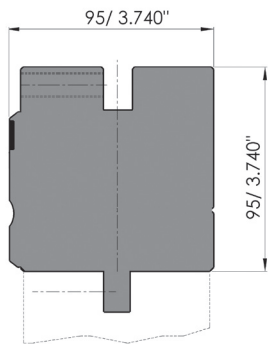


Patented 'WILA Wave' Wedge Technology

## NSCR-I New Standard Pro Crowning System



Shown with Mechanical Clamping (MC)

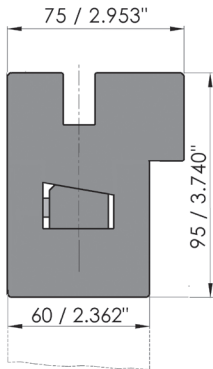


Shown with 3.74" width. Other widths available.

## OB-I-HC BOTTOM HOLDER (HYDRAULIC)



Shown with optional, localized TY adjustment dials every 200mm / 8" for initial fine tuning to compensate for localized machine tolerances



Height may vary depending on options and bed mounting method

WILA Crowning Systems and Bottom Holders can be configured for use with any style ram. To view more options, please reference our Press Brake Productivity Catalog.



NSCR-I-HC/B3



NSCR-I-MC/B2



OB-I-MC-TY/ES IV



OB-I-HC-ES IV

## "HF" Frontside



Manual centralized crowning adjustment from front side.

## "H" HAND CRANK

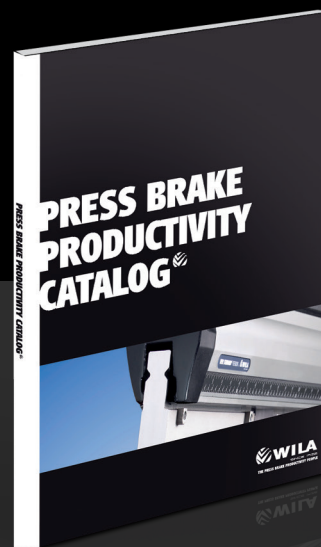


Manual centralized adjustment at the end of the crowning unit.



## PRESS BRAKE PRODUCTIVITY CATALOG

The products featured in this Press Brake Retrofit Program flyer serve as a representative sample of WILA's available options for retrofit projects. To view all available WILA products, please reference the Press Brake Productivity Catalog. The Press Brake Productivity Catalog offers a complete listing of all WILA products, including New Standard Premium, New Standard Pro, American Style, and American Style Vintage tooling, clamping, crowning, and bottom tool holders, as well as specialty tooling and accessory products.



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