



The "Hemmer"



Eliminate Die **Stations and Operations**;
Use in Progressive Dies, **Automated** Machines

This patented tool can form a slightly open bend completely flat in one vertical press stroke. Use it to form UP or DOWN in high **production** stamping dies and automated machines. Eliminate the cam action "**pre-hem**" operation and do hems in two stations instead of three.

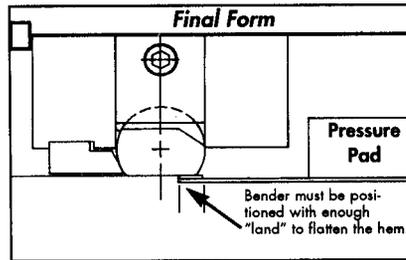
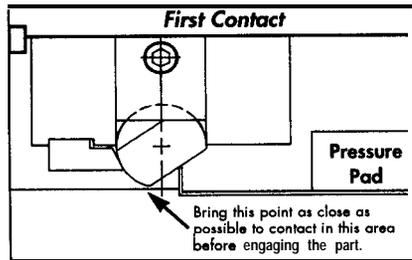
We use full hard D-2 rockers and special READY-2000 style saddles. This is a special bender, yet attractively priced.

All hem applications should be quoted by READY. Fax prints and the worksheet on the back cover. We usually suggest a

test-bend using your material to accurately predict results and select the right hemmer design. We charge a modest fee for this service, based upon the application.

Important Hemmer Functions

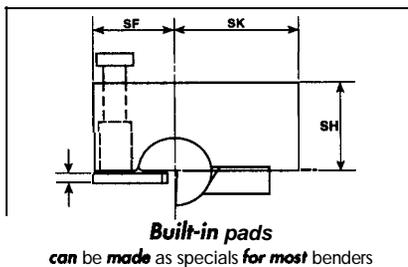
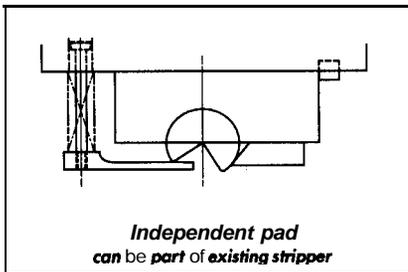
1. Diameter may be chosen more by leg height than material thickness.
2. Testing is highly recommended on **all** hem applications to help determine proper positioning.
3. Pressure pad needed to avoid sliding as hemmer contacts and flattens.
4. Maximum hemmer length is 12". For longer lengths, butt end-to-end with .010" gap between saddles.



Pad Benders

Not Just for Elimination of Tool Marks

Pads can help in many bender applications. By activating the bender on top of a pad, you isolate the rocker from the part on the critical **holddown** surface. NO CONTACT = NO MARK.



Important Pad Functions

1. Pads can be designed to match a part's "irregular" shape on one side yet be flat and parallel on the surface that the bender contacts.
2. Eliminates rocker contact and impact on part **holddown** surface.
3. To protect a part cutout or hole from distortion due to its proximity to the bend line.
4. To eliminate humping of the material when the application dictates **upsizing** the rocker diameter. The pad provides **hold-down** pressure close to the bend radius.
5. To match a standard rocker diameter to the Zee bend or offset vertical height. Allows use of standard rockers versus making specials.

When Using Pads, READY Technology Recommends:

1. locate the pad and its shoulder screws/spools as close as possible to the tangency point of the radius. This location and bushings or guides will prevent the pad from tipping.
2. Springs to **lift** the pad should work separately from the spring return of the bender.
3. Additional part **holddown** may be required in some applications (pilots, die springs or nitrogen cylinders).

The "Hemmer"
Pad Benders
Eliminate Tool Marks

America's
prepaint
authority
recommends
**READY
Benders®**



Irv Venger, LTV Steel Company's
Metallurgical Services Supervisor -
Prepainted Products says -

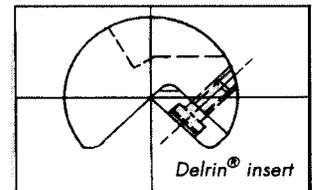
"READY Benders® provide **gentle forming and are kind to the surface.** They are ideal for high production: **virtually all our customers who use prepaint have READY Benders® on-line**"

Bending Without Tool Marks

READY Benders® normally leave a slight burnish or shine mark on both part surfaces. This is a big improvement over wipe tool scrapes and gouges.

Elimination of tool marks is not just for prepainted metal - one of our big success areas. Use of pads (bottom, left) and highly polished steel rockers are very successful on prepaint and other decorative surfaces.

Depending on acceptable tool mark criteria, we have the solution to most situations. Test-bending is the safe approach. For a modest fee, we will form your material using our benders and send you a report with your sample for evaluation.



Solid Delrin® Rockers or Delrin® Inserted Rockers are used **without** pads on low to **medium** production applications.

Delrin® is a registered trademark of E.I. DuPont.