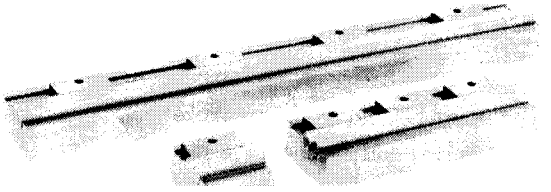
INCH
Hard Inch Benders

- **Designed to produce up to one million parts, ideal for most stamping dies.**
- In **stock lengths: 12", 24" and** up **to36" long.**
- segment **stock lengths to reduce** your tooling **budget;** quick **delivery.**
- **Custom lengths available, specify.**

READY

Introducing the Hard **Inch** Bender

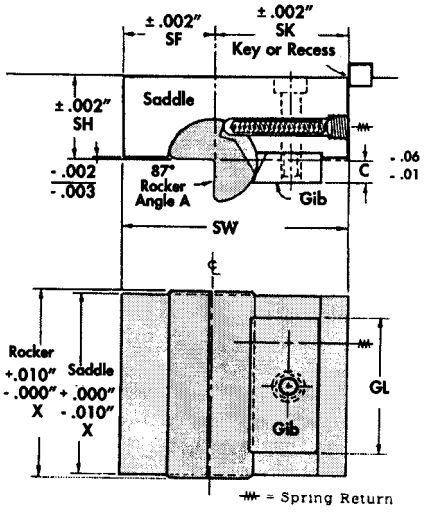
Benders am now less expensive than wipe tooling.



Features:

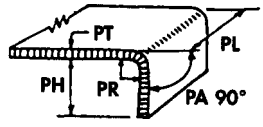
1. Rockers: fully hardened (Rc 58), cryogenically tempered S-7 tool steel.
2. Saddles: machinable thru hardened steel; mounting holes left for diemaker to locate where needed. See mounting hole patterns on READY-2000 series, pages 6 to 8 for suggestions.
3. Saddle socket is coated for lubrication and long life. Saddle has flush mount lube fittings.
4. Rockers and saddles are CNC ground for precision and interchangeability.
5. Rocker angle is 87" on all standard benders. This allows for 3" of overbend to produce consistent 90" forms in mild steel. Harder steel or larger part radii may require more overbend. Rocker angles can be specified at time of order or altered by the diemaker. See page 10 about oversquare bends.
6. CAUTION: Some materials that "flake" during bending may cause READY Benders" to gall, seize, or develop excessive wear. Frequent cleanings are suggested when running these materials. READY can reapply the "moly" coating for a nominal fee if needed.

Standard Hard Inch Bender



Selecting Standard Benders:

1. Find the PT you are forming in top row of chart below. Read down (vertically) for all data. Verify the PH check (specials can bend shorter PH's).
2. Note minimum and maximum lengths (X) in chart below. Custom lengths are available. Use in stock lengths whenever possible for quick delivery. longer lengths achieved by butting units end-to-end, ,010" gap between.
3. If you have questions or need a special quotation, please fax the worksheet on back cover with prints.



PT = part thickness
PH = part height
PR = part radius
PA = port angle
PL = port length

Standard benders form a 90" bend in mild steel The PR should roughly equal the PT.

Part Thickness (PT)	.010"-.042"	.043"-.075"	.076"-.120"	.121"-.164"	.165"-.209"	.210"-.250"	Extended Range Available
Gage Thickness	25 to 19	19 to 14	14 to 11	11 to 8	8 to 5	5 to 1/4"	
Part Height Check (PH)	.250"	.390"	.580"	.775"	.970"	1.160"	
	To use standard benders, PH should exceed these dimensions. Fax prints for specials.						
In Stock Lengths, X =	12", 24", *	12", 24", *	12", 24", 36"	12", 24", 36"	12", 24", 36"	12", 24", 36"	
Minimum Length (X) (Gib Length - GL)	1.125"	1.500"	2.000"	2.500"	3.000"	3.500"	
Maximum Length (X)	24", *	24", *	36"	36"	36"	36"	
MODEL CAUOUT	HIB 62	HIB 100	HIB 150	HIB 200	HIB 250	HIB 300	We Make Specials

Rocker Diameter 87° Angle	.625"	1.000"	1.500"	2.000"	2.500"	3.000"	Extended Range Available
Saddle Width (SW)	2.125"	2.875"	3.875"	4.875"	5.875"	6.875"	
Saddle to Front (SF)	.750"	1.125"	1.500"	1.875"	2.250"	2.750"	
Saddle to Key (SK)	1.375"	1.750"	2.375"	3.000"	3.625"	4.125"	We Specialize In:
Saddle Height (SH)	.875"	1.375"	1.875"	2.375"	2.875"	3.375"	• High Strength Steel
Gib length (GL)	1.125"	1.500"	2.000"	2.500"	3.000"	3.500"	• Aluminum
Rocker Dimensions (B)	.212"	.339"	.508	.678"	.848"	1.017"	
(C)	.195"	.312"	.468"	.624"	.780"	.936"	
(J)	.242"	.387"	.581"	.774"	.968"	1.161"	

* *Future units may be available 36" long, call READY*