



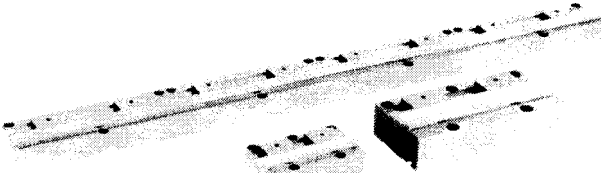
**INCH**  
**READY-2000**



# READY-2000

Our highest production bender - now available up to 36"

- Use when production exceeds a million parts, ideal for most stamping dies.
- In stock lengths. Now available up to 36" long.
- For custom lengths, see page 106.



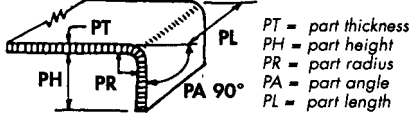
**Features:**

1. **Rockers:** fully hardened (Rc 58), cryogenically tempered S-7 tool steel.
2. **Saddles:** fully hardened, (Rc 50) A-2 tool steel. Counterbored mounting holes per patterns on pages 7 and 8. Flush mount lube fittings.
3. Rockers and saddles are CNC ground for precision and interchangeability.
4. 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.

**Selecting Standard Benders:**

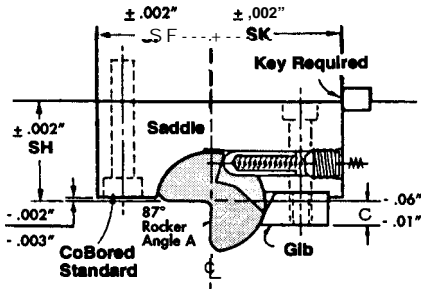
1. Find the PT you are forming in top row of chart below. Read down (vertically) for all data. Verify the PH check (specials can bend shorter PH's).
2. Note minimum and maximum lengths (X) in chart below. Custom lengths are available. Use in stock lengths whenever possible for quick delivery. longer 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.



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

**Standard READY-2000 Bender**



• Tapped mounting holes available as specials.

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"	
In Stock Lengths, X = (see page 7)	1.125" 3.500" 6.000"	1.500" 4.000" 6.000" 9.000"	2.000" 5.000" 8.000"	2.500" 7.000"	3.000" 7.000"	3.500" 6.000"	
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 CALLOUT	REC62	REC 100	REC 150	REC 200	REC 250	REC 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"	• Prepaint
Rocker Dimensions							• Aluminum
(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