

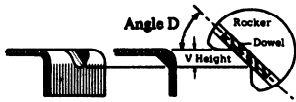


## Bender Options

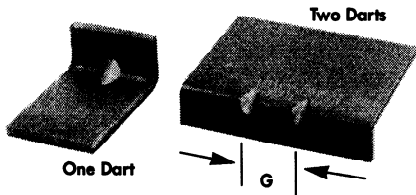
"Wipe Tooling" darts are high maintenance - Benders make it simple.

### Eliminate:

- galling and maintenance
- unattractive parts
- secondary operations



**V Height** - The only dimension darts can hold because material thickness varies.



## Popular Bender Options



### 1. Dart Stiffeners ... Benders Make it Easy

Standard darts are shown below or you can specify your own angle and dowel size. Darts are rolled into the part during bending, reducing springback and stiffening the part. Darts are produced using dowels through the rocker and require relief grooves in the anvil. The side angles of the darts are a function of the angle and size of the dowel.

Darts are available as specifiable extras on all READY Benders®. Darts are central on a 45° angle unless detailed.

#### How to Specify

Add your selection of Dart Spec. No. after Catalog Number:

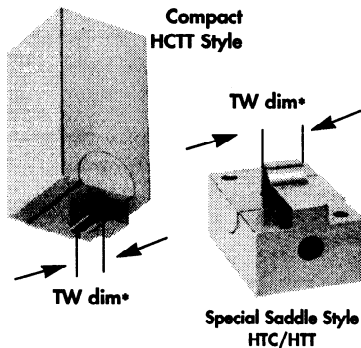
<u>2</u>	<u>REC 150</u>	<u>X = 2"</u>	<u>2 V3, Darts, G = 1"</u>
Qty	Cat. No.	Length	Dart Callout

Vee Height	Rocker Diameters					
	5/8	1	1-1/2	2	2-1/2	3
.100"	V1	V1	--	--	--	--
.200"	V2*	V2	V2	--	--	--
.350"	--	V3*	V3	V3	--	--
.500"	--	--	V5*	V5*	V5	V5
Dowel	.093	.156	.250	.312	.375	.500

\*Dowel may be upsized to avoid a gap between the rocker and the dowel.

**Benders gently roll stiffening "darts" into a wide range of formed parts.**

### Tooth Benders



### 2. Tooth Benders ... Eliminate Part/Die Interferences

Tooth benders use special rockers to eliminate die/part interferences. Often the saddle needs to be made special without gibs in one piece. Send prints for a quotation.

#### How to Specify

Add TW dimension after Catalog Number:

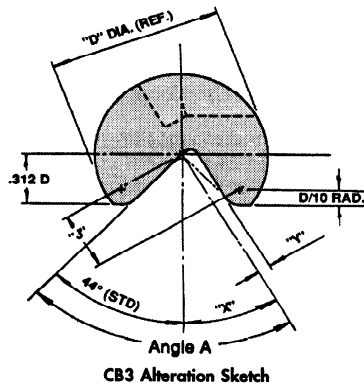
2	HCTT 62	TW.400
1	HTT 100	TW.500
2	HTC 100	TW.500
Qty	Cat. No.	TW dim.

Rocker Dia. D	Compact Style HCTT	Special Saddle Style, HTC/HTT
	Minimum TW	Dimension
.625	.312	.312
1.000	.500	.438
1.500	---	.500
2.000	---	.625
2.500	---	.688
3.000	---	.750

\*TW central unless detailed.

Please note: The saddle is special (gib built-in) to accept a narrow rocker tooth width. Tooth benders are available on all types of READY Benders® as specials.

### Over Square Bends

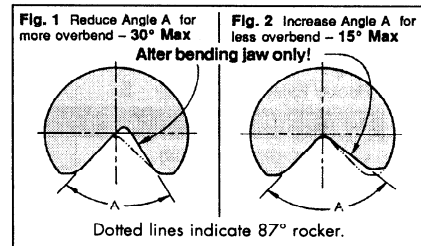


### 3. Over Square Bends ... up to 120° in one press stroke

The READY Bender's® ability to bend 30° beyond ninety (120° PA) is one of its greatest features. Customers buy standards and do this simple alteration themselves, adding a degree or two of overbend to the rocker. This easy alteration is done by grinding the bending jaw of the rocker, while not disturbing the working radius of the bending lobe (grind past centerline).

**For assistance, call READY Technology and we will give you the necessary dimensions to make this alteration.**

**Note:** Severe overbend (over 109° PA) with a small radius (less than PT) can create a situation where the rocker may catch on the anvil.



READY will check your application and advise if a pad or special rocker design is needed.

It's easy to alter rockers for more or less overbend. Example shows standard 87° rocker. Check to make sure the Anvil has more relief angle than the rocker angle A. Rockers are easy to alter.