



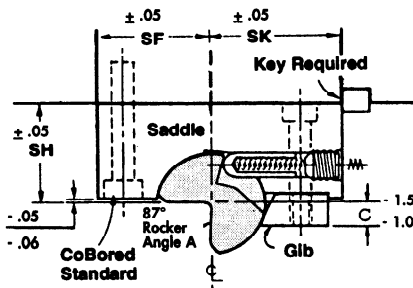
METRIC READY-MET

- Use whenever production exceeds a million parts, ideal for most stamping dies.
- In stock lengths Now available up to 915 mm long.

Features:

- 1. Rockers:** fully hardened (Rc 58), cryogenically tempered S-7 tool steel.
- 2. Saddles:** fully hardened, (Rc 50) A-2 steel. Counterbored mounting holes per patterns on pages 17 and 18. 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. See page 10 about oversquare bends.

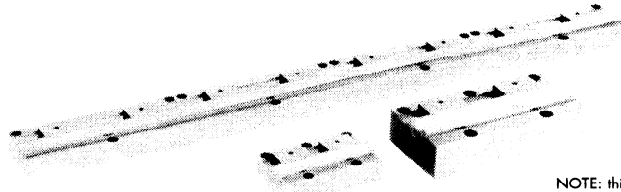
Standard READY-MET Bender



- Tapped mounting holes available as specials.

READY READY-MET™

Our highest production bender - now available up to 915 mm long.

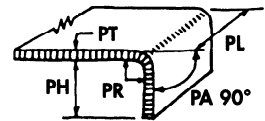


NOTE: this is an inch product, the same as READY-2000 on pages 6 to 8, except with metric mounting holes.

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, .25mm 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 = part angle
PL = part length

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

All dimensions are in millimeters.

Part Material Thickness (PT)	0.3 - 0.9	0.9 - 1.7	1.7 - 2.8	2.8 - 3.8	3.8 - 4.9	4.9 - 6.0	Extended Range Available
Part Height Check (PH)	6.15	9.9	14.8	19.7	24.6	29.5	
To use standard benders, PH should exceed these dimensions. Fax prints for specials.							
In Stock Lengths, X = (see page 17)	28.58 88.90 152.40	38.10 101.60 152.40 228.60	50.80 127.00 203.20	63.50 177.80	76.20 177.80	88.90 152.40	
Minimum Length (X) (Gib Length - GL)	29	39	51	64	77	89	
Maximum Length (X)	610, *	610, *	915	915	915	915	
MODEL CALLOUT	RMC 62	RMC 100	RMC 150	RMC 200	RMC 250	RMC 300	We Make Specials

Parameter	15.9	25.4	38.1	50.8	63.5	76.2	Extended Range Available
Rocker Diameter (87° Angle)							
Saddle Width (SW)	53.975	73.025	98.425	123.825	149.225	174.625	
Saddle to Front (SF)	19.050	28.575	38.100	47.625	57.150	69.850	
Saddle to Key (SK)	34.925	44.450	60.325	76.200	92.075	104.775	
Saddle Height (SH)	22.225	34.925	47.625	60.325	73.025	85.725	We Specialize In:
Gib Length (GL)	29	39	51	64	77	89	• High Strength Steel
Rocker Dimensions (B)	5.39	8.61	12.90	17.22	21.54	25.83	• Prepaint
(C)	4.95	7.93	11.89	15.85	19.81	23.77	• Large Radii
(J)	6.15	9.83	14.76	19.66	24.59	29.49	• Aluminum

*Future units may be available 915 mm long, call READY