



READY

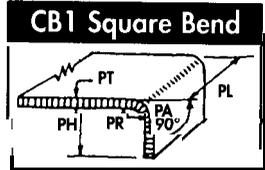
Application Parameters

Reduce Die Costs. . . Increase **Productivity** The Easy Way
(See Back Cover for **Faxable Worksheet** for Quick Quotes)

A. Short Leg – CB2

Short leg bends occur when Part Height (PH) is too small (in the flat) to be contacted by the bending lobe of the rocker. When $(BA+PH)-PR-K$ is less than "B" (designer dimensions), the bend is short leg. (Bend Allowance = BA) Short leg limits are:

1. Generally $2.6(PT)+PR$ is the minimum leg possible, chart available.
2. Part Radius (PR) is equal to or less than PT, chart available.
3. The "kicker" style can do even shorter legs. Fax prints.



B. Over Square – CB3

Over square bends for Part Angles (PA) to 120° can be made by altering the bending lobe of a standard rocker for the additional overbend. The bending lobe radius stays constant with the new angle A tangent to that radius. **Please note:** the K dimension changes as a result of this alteration. Severe (over 109°) overbends over a sharp radius (less than 1/2 PT) can cause problems. Consult READY Technology for assistance.

Over square benders are excellent for stainless and high strength materials and on prehem applications.

C. Zee Bend – CB5

Zee bends are common READY Bender® applications. They require two settings and generally require no springback allowance. Part Thickness (PT) and Part Height (PH) determine the diameter rocker needed to produce the part. Oftentimes a pad will be required to avoid material humping between the jaws of the rocker. READY recommends a two-piece anvil assembly to ease setting of Zee Bends. [See sketch C] Additional holddown or pilots may be required to keep the part stationary during bending. Please consult READY Technology with your Zee Bend needs.

D. Hat Bend – CB8

Hat bends can be done in one hit with two special Zee Benders or two hits with two sets of Channel Benders (one set to bend up and one set to bend down). Part information will determine which method is best for your application. If Zee Benders are used, please review the recommendations in the CB5 section, letter C – Zee Bend.

E. Adjustable Channel – CB7

Channel and hat bends are paired benders to produce the complete bend in one stroke. Part Channel (PC), inside spread, must be greater than SF (unit to front) x 2 to use standard benders. Minimum spread (PC) for special READY Benders® is 120% of rocker diameter unless you interlace the units. See letter F – Interlaced Channel.

F. Interlaced Channel

This option is for channels so narrow the saddle and/or rocker needs 'interlacing.' Narrow channels are big cost savers with benders. The web stays flat, improving part quality. The minimum PC is rocker diameter multiplied by .6 with this special option. Fax prints for a quote.

G. One-hit Boxes

Boxes and large panels formed on all sides in one hit are very popular. The saddles are mitered, the rockers are notched to fit the corners. A gap is suggested to allow overbending. Add sections of benders to do a range of similar boxes with minor tool changes.

H. READY Hemmer – CB22

Folding material back upon itself is called a hem. This usually presents a difficult tooling challenge. The simple vertical action of the hemmer can take slightly underbent parts (less than 90° square), as well as 90° forms and hem them into flat hems, open hems, or a wide range of special "tear drop" configurations. **Holddown pressure is required to eliminate part sliding.** This simple and inexpensive tool will save operations and speed production. The 1" diameter size, full hard rocker, works for a wide range of hems. Call or fax prints for a quote.

Avoid **Downtime** . . . Specify **Benders**® We **Make Specials**, Fax Prints
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(Note area code change to 937 in October 1996)

