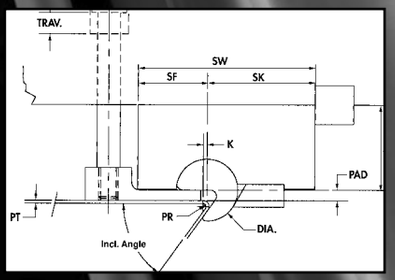
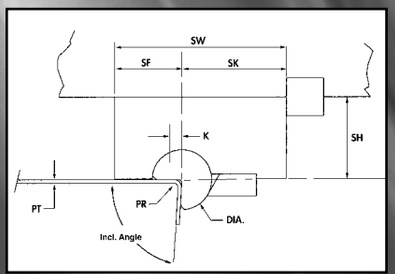
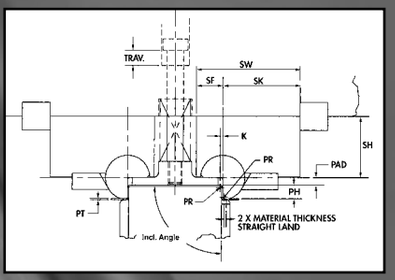
READY Bender®

Concept Sketches

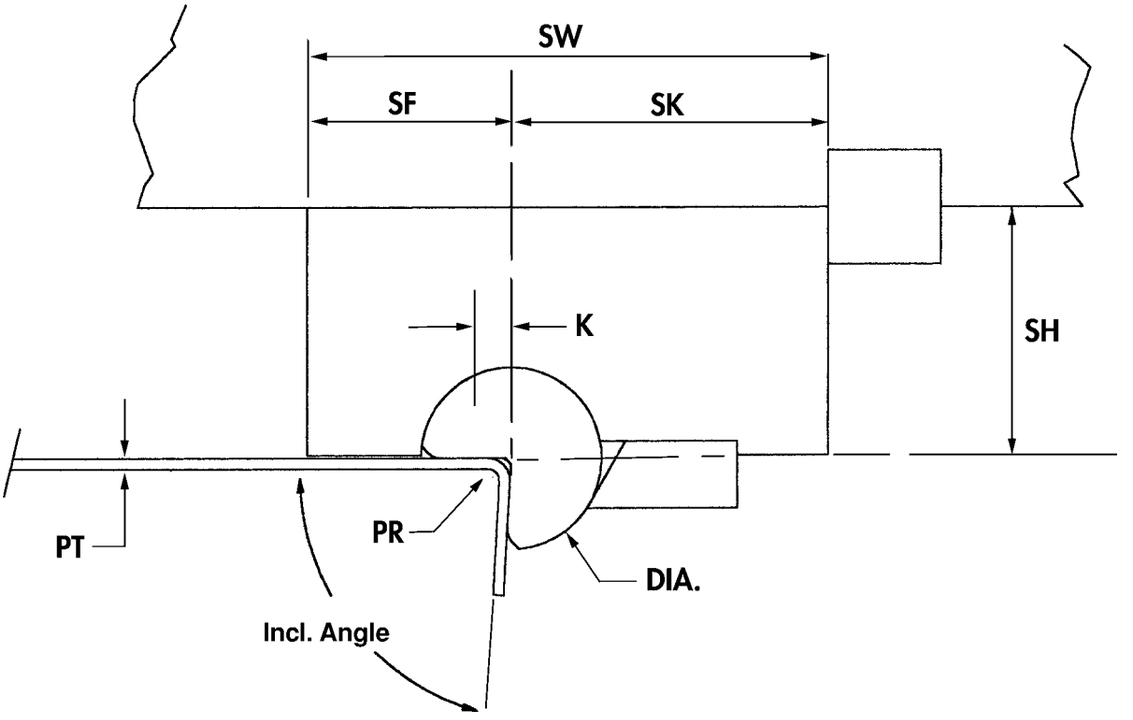




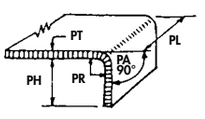


READY Bender®

CB1 Concept Sketch



*A READY Bender® is a CB1 tool when **PT, PR** and **PH** are within the proper parameters to use standard tooling.*

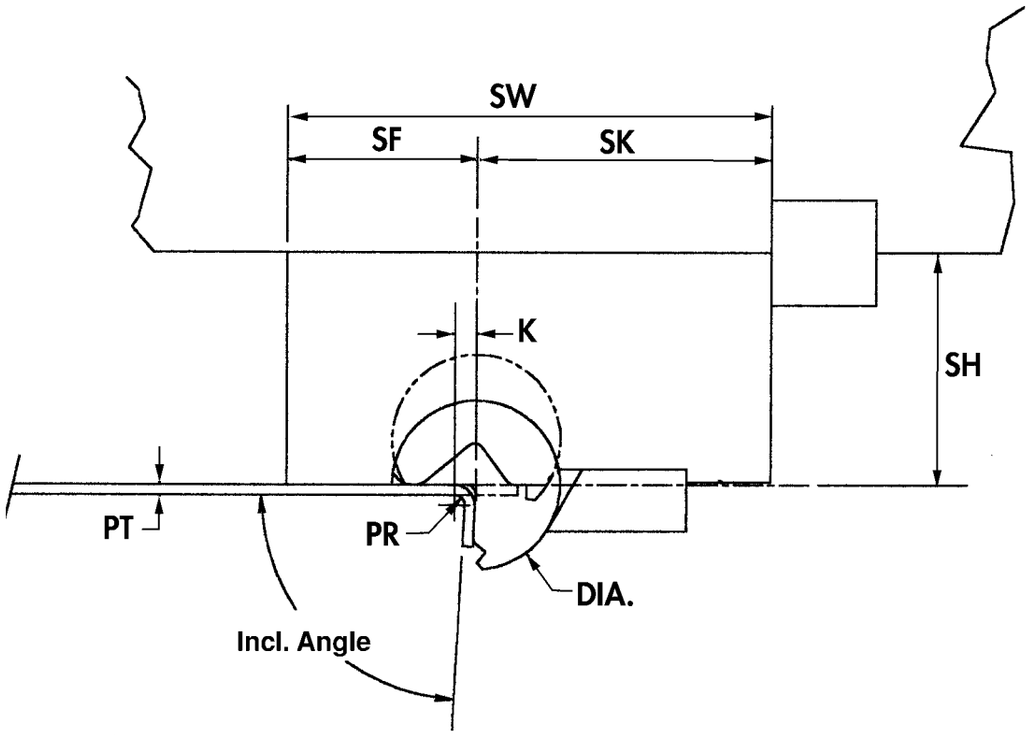


CB1
Square Bend

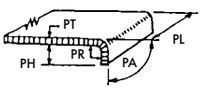
CB = **C**lassified **B**end #
PT = **P**art Material **T**hickness
PL = **P**art **L**ength (bent leg)
PA = **P**art **A**ngle (degrees of bend)
PH = **P**art **H**eight (bent leg)
PR = **P**art **R**adius
PC = **P**art **C**hannel (inside)
K = see catalog
Incl. Angle = Included Angle

READY Bender®

CB2 Concept Sketch



A READY Bender® is a CB2 tool when the PH dimension is too short to utilize a standard tool. Generally 2.8 (PT) + PR is the minimum leg possible. Part radius (PR) is equal to or less than PT. (Call READY for minimum dimensions)

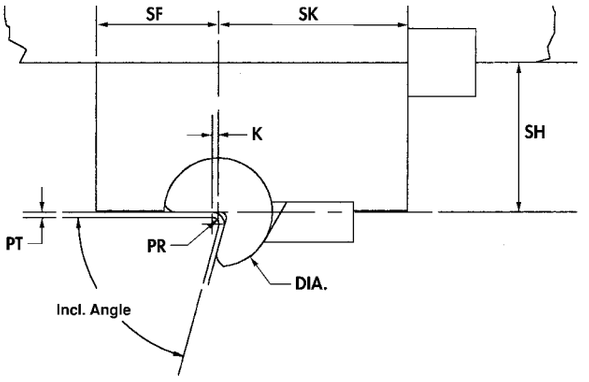


CB2
Short Leg

CB = Classified Bend #
PT = Part Material Thickness
PL = Part Length (bent leg)
PA = Part Angle (degrees of bend)
PH = Part Height (bent leg)
PR = Part Radius
PC = Part Channel (inside)
K = see catalog
Incl. Angle = Included Angle

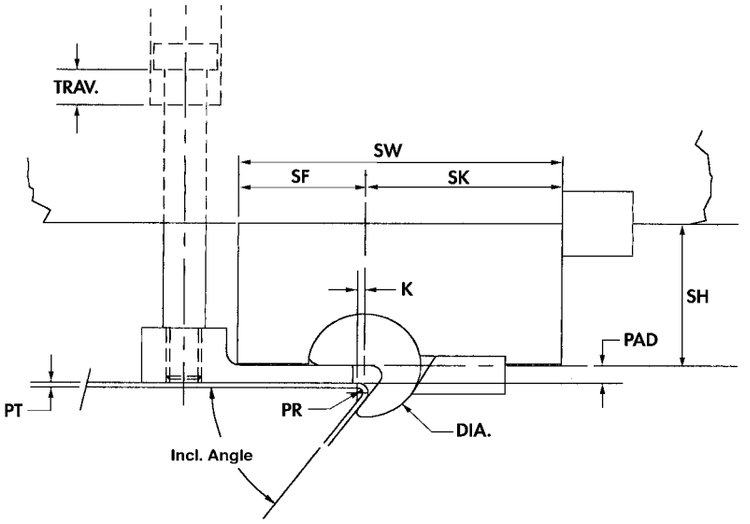
READY Bender®

CB3 Concept Sketch

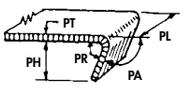


A READY Bender® CB3 bends where the bend angle is over 90° (120° max.).

CB3 Extreme Concept Sketch



A READY Bender® CB3 Extreme (over 110°) will most likely need to run off of a pad. This is to keep the tool from sticking on the part.

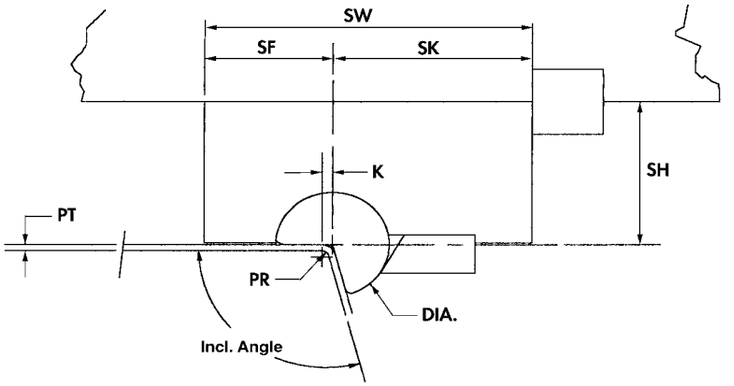


CB3
Over Square

CB = **C**lassified **B**end #
PT = **P**art Material **T**hickness
PL = **P**art **L**ength (bent leg)
PA = **P**art **A**ngle (degrees of bend)
PH = **P**art **H**eight (bent leg)
PR = **P**art **R**adius
PC = **P**art **C**hannel (inside)
K = see catalog
Incl. Angle = Included Angle

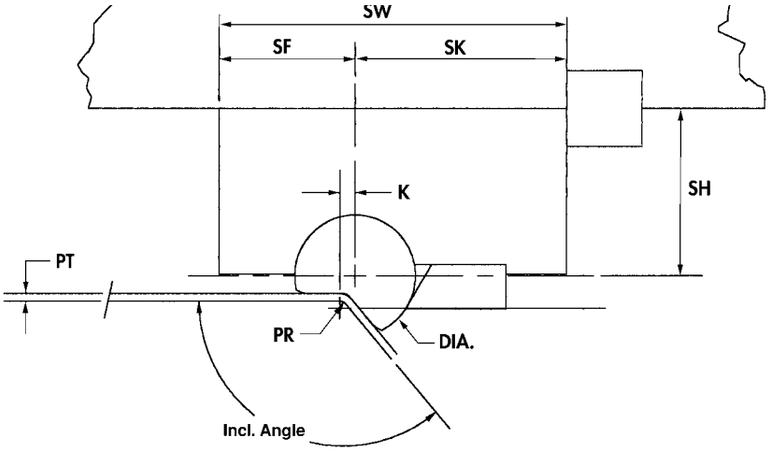
READY Bender®

CB4 Concept Sketch (on centerline)

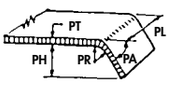


A READY Bender® CB4 (on centerline) - the maximum angle remaining on centerline is 105° included.

CB4 Concept Sketch (above centerline)



A READY Bender® CB4 (above centerline) includes angles over 105° will be above centerline.

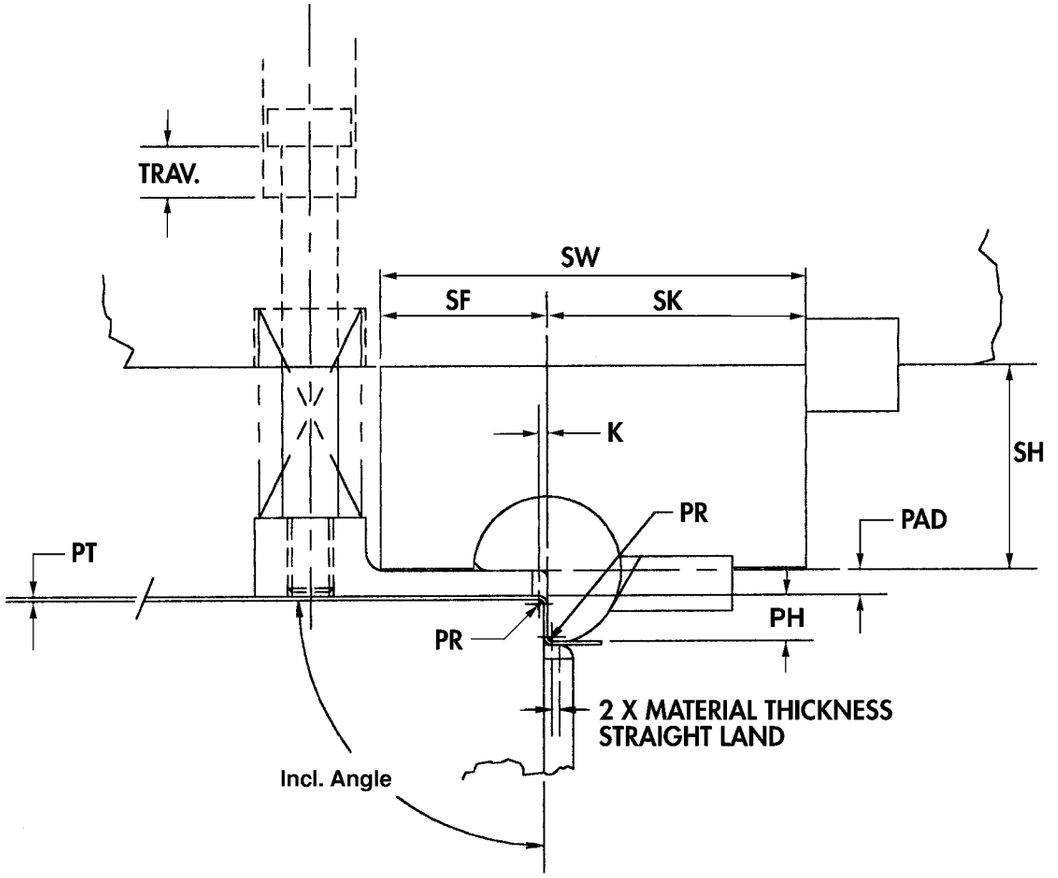


CB4
Under Square

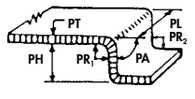
CB = **C**lassified **B**end #
PT = **P**art Material **T**hickness
PL = **P**art **L**ength (bent leg)
PA = **P**art **A**ngle (degrees of bend)
PH = **P**art **H**eight (bent leg)
PR = **P**art **R**adius
PC = **P**art **C**hannel (inside)
K = see catalog
Incl. Angle = Included Angle

READY Bender®

CB5 Concept Sketch



READY Bender® CB5 bends will most likely need to run off of a pad. This is to maintain rocker retention in the saddle.Zee Benders require more tonnage as you are forming two legs in one stroke.

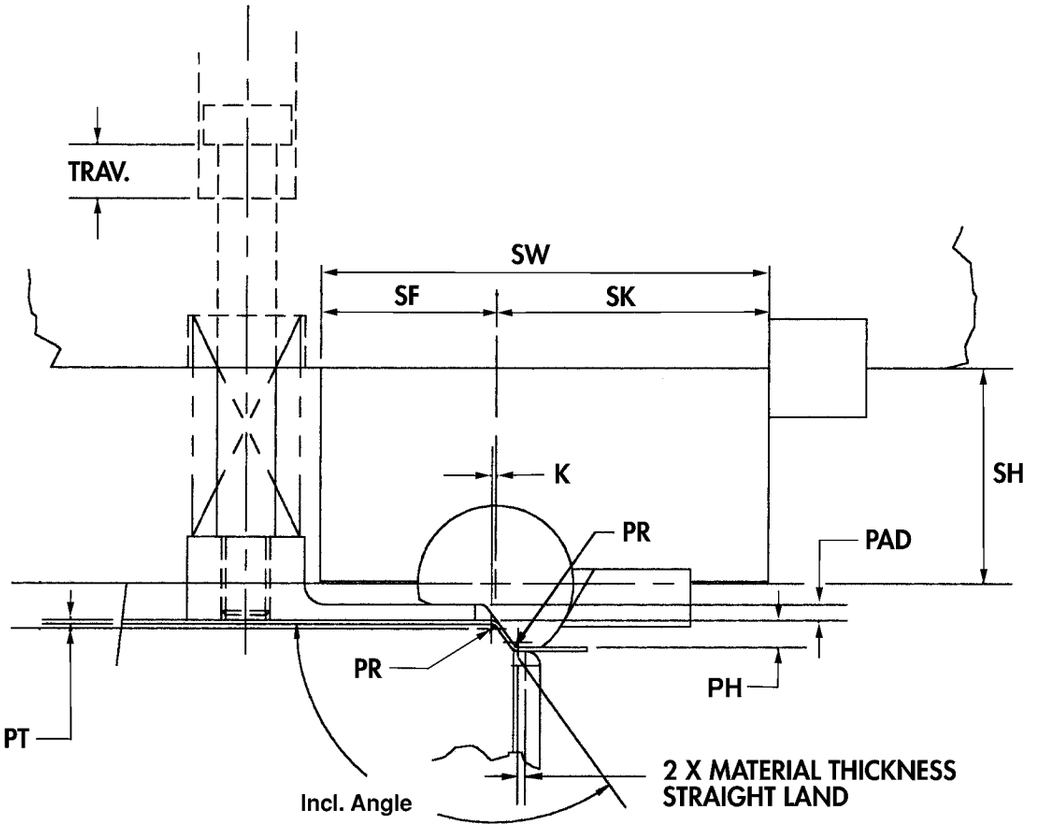


CB5
Zee Bend

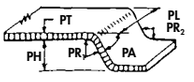
CB = **C**lassified **B**end #
PT = **P**art Material **T**hickness
PL = **P**art **L**ength (bent leg)
PA = **P**art **A**ngle (degrees of bend)
PH = **P**art **H**eight (bent leg)
PR = **P**art **R**adius
PC = **P**art **C**hannel (inside)
K = see catalog
Incl. Angle = Included Angle

READY Bender®

CB6 Concept Sketch



READY Bender® CB6 bends will most likely need to run off of a pad. This is to maintain rocker retention in the saddle. Zee Benders require more tonnage as you are forming two legs in one stroke.

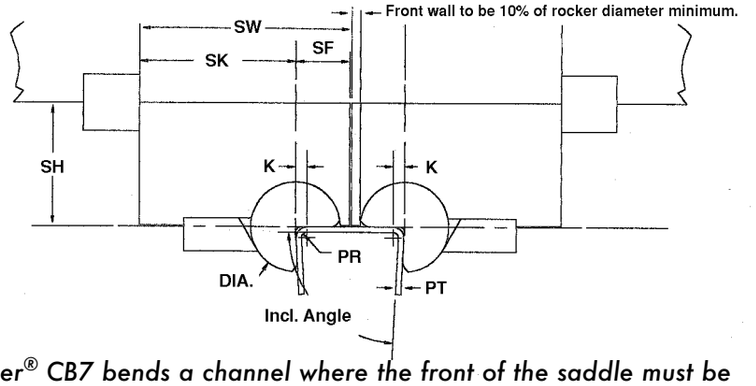


CB6
Open Zee

CB = **C**lassified **B**end #
PT = **P**art Material **T**hickness
PL = **P**art **L**ength (bent leg)
PA = **P**art **A**ngle (degrees of bend)
PH = **P**art **H**eight (bent leg)
PR = **P**art **R**adius
PC = **P**art **C**hannel (inside)
K = see catalog
Incl. Angle = Included Angle

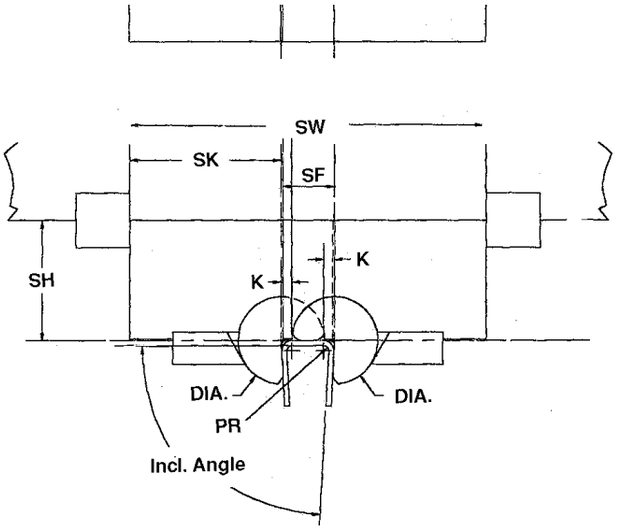
READY Bender®

CB7 Concept Sketch (not interlaced)

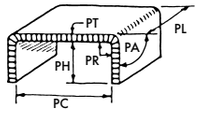


READY Bender® CB7 bends a channel where the front of the saddle must be smaller than standard.

CB7 Concept Sketch (interlaced)



READY Bender® CB7 bends a channel where the front of the saddle must be smaller than standard. Tooling can also be interlaced. Rockers and saddles are notched.

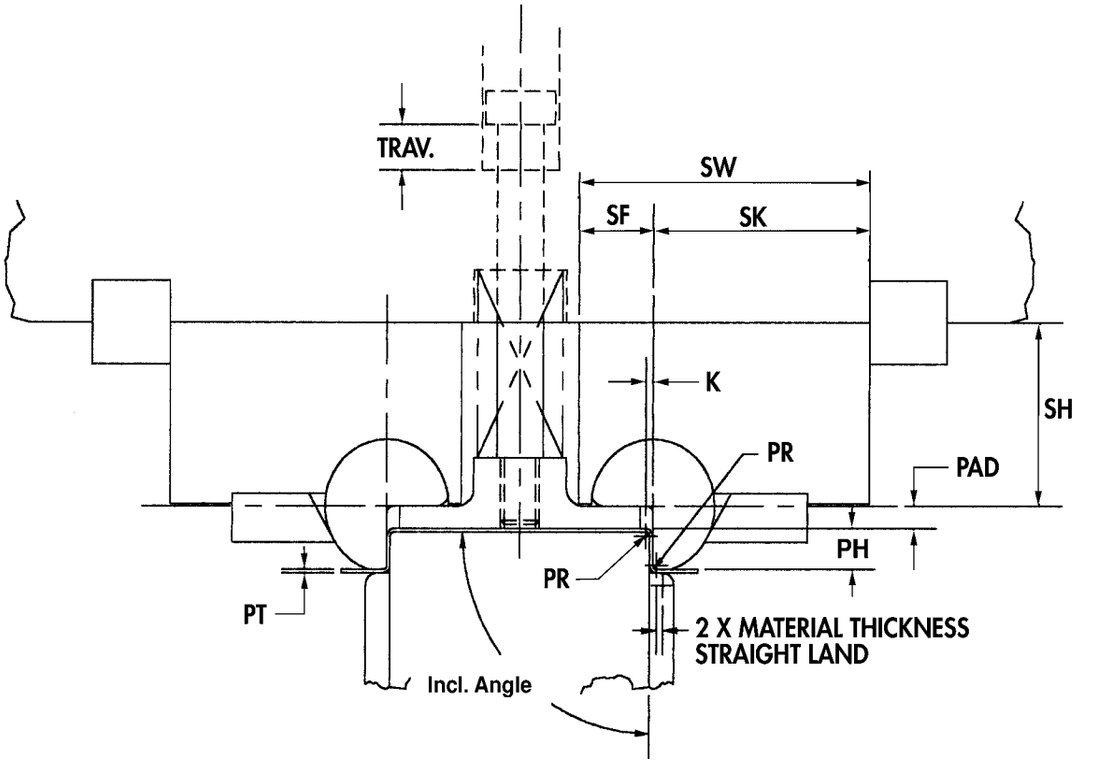


CB7
Channel Bend

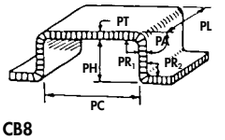
CB = Classified Bend #
PT = Part Material Thickness
PL = Part Length (bent leg)
PA = Part Angle (degrees of bend)
PH = Part Height (bent leg)
PR = Part Radius
PC = Part Channel (inside)
K = see catalog
Incl. Angle = Included Angle

READY Bender®

CB8 Concept Sketch



READY Bender® CB8 has two CB5 bends where the front of the saddle is shorter than standard. Note: CB8 bends will most likely need to run off of a pad. This is to maintain rocker retention in the saddle. CB8 benders can also be interlaced. Max tonnage Ready Bender application.

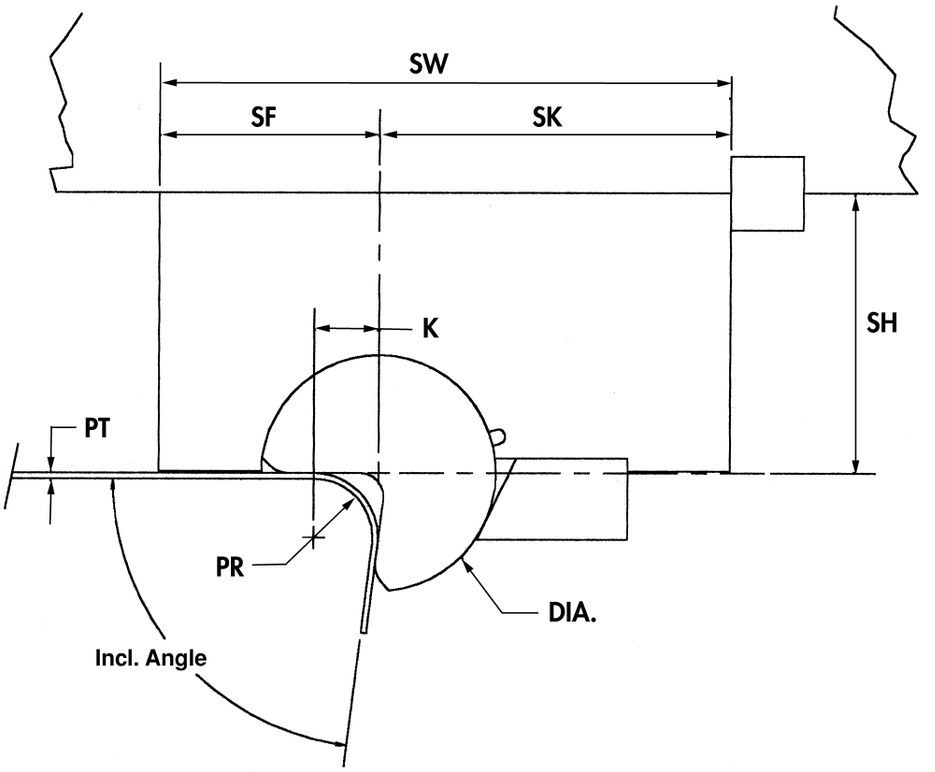


CB8
Hat Bend

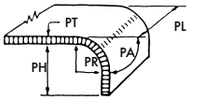
CB = **C**lassified **B**end #
PT = **P**art Material **T**hickness
PL = **P**art **L**ength (bent leg)
PA = **P**art **A**ngle (degrees of bend)
PH = **P**art **H**eight (bent leg)
PR = **P**art **R**adius
PC = **P**art **C**hannel (inside)
K = see catalog
Incl. Angle = Included Angle

READY Bender®

CB13 Concept Sketch (large radius)



READY Bender® CB13 - the bend is a Large Radius bend when the inside bend radius becomes too large to use the rocker diameter designated by the material thickness. Extra overbend will be needed to end up with the proper bend angle.

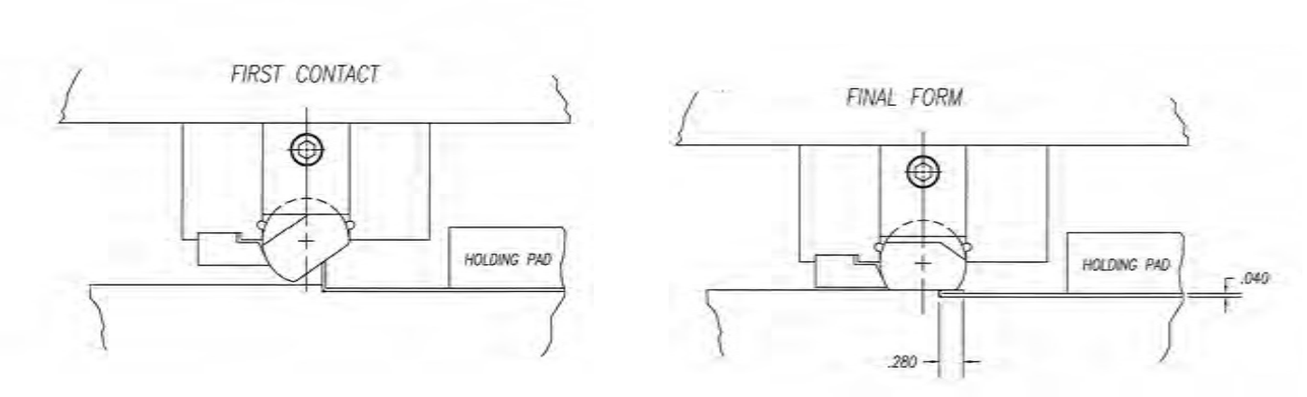


CB13
Large Radius Bend

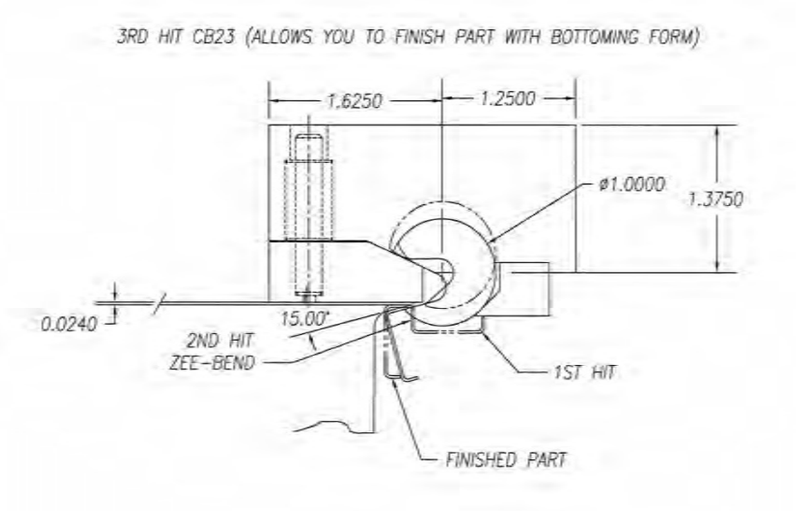
CB = Classified Bend #
PT = Part Material Thickness
PL = Part Length (bent leg)
PA = Part Angle (degrees of bend)
PH = Part Height (bent leg)
PR = Part Radius
PC = Part Channel (inside)
K = see catalog
Incl. Angle = Included Angle

READY Bender®

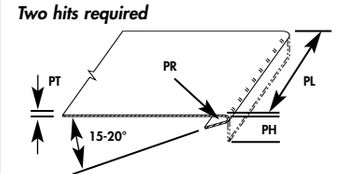
CB 22 Concept Sketch



CB 23 Concept Sketch

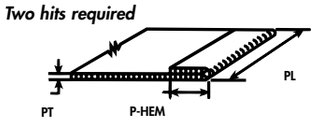


Two hits required



CB23 Precision Open Hem

Two hits required



CB 22 Full Hem

CB = **C**lassified **B**end #
PT = **P**art Material **T**hickness
PL = **P**art **L**ength (bent leg)
PA = **P**art **A**ngle (degrees of bend)
PH = **P**art **H**eight (bent leg)
PR = **P**art **R**adius
PC = **P**art **C**hannel (inside)
K = see catalog
Incl. Angle = Included Angle