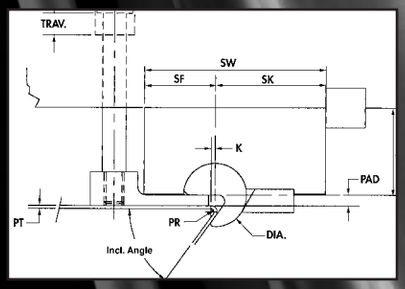
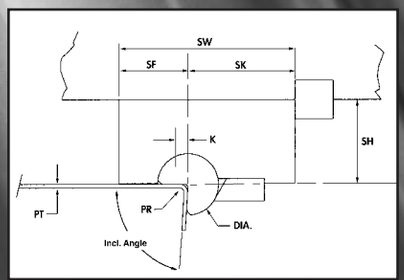
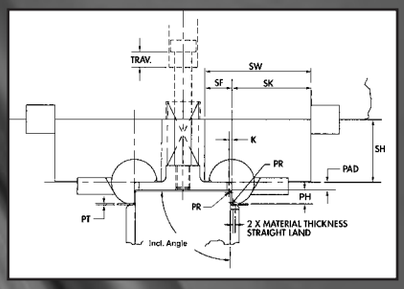
READY

READY Bender®

Concept Sketches



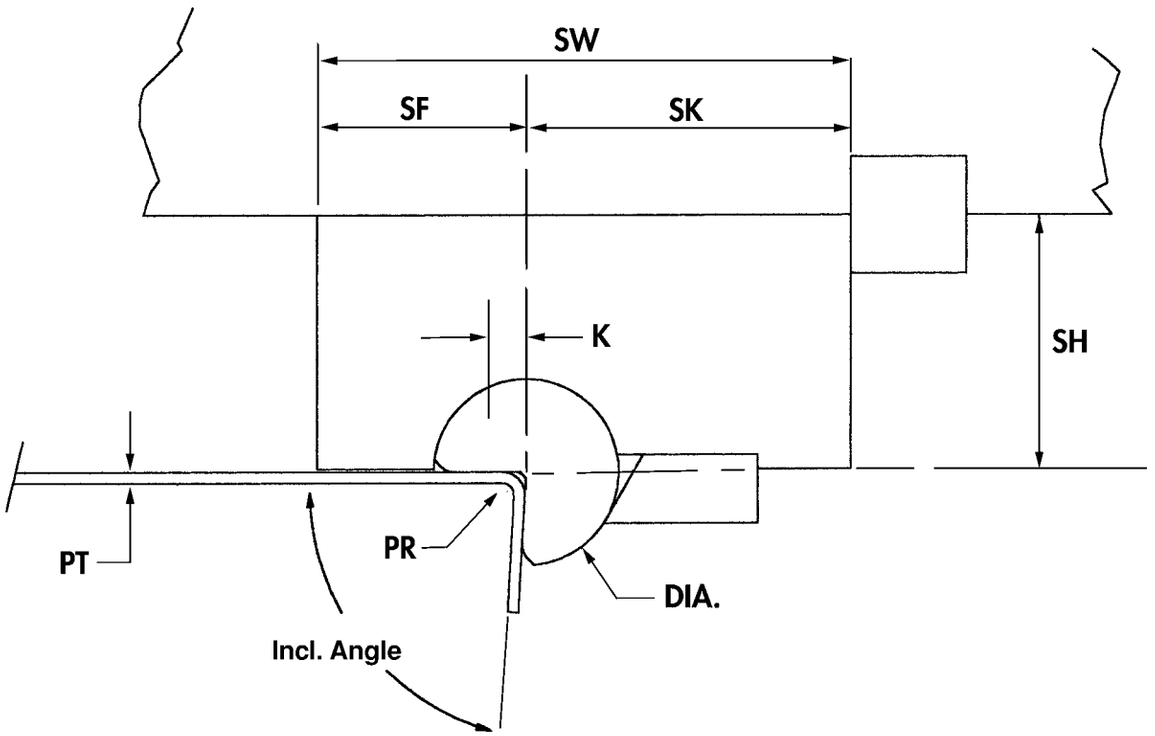




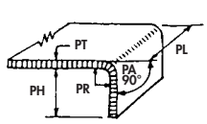
READY

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.*



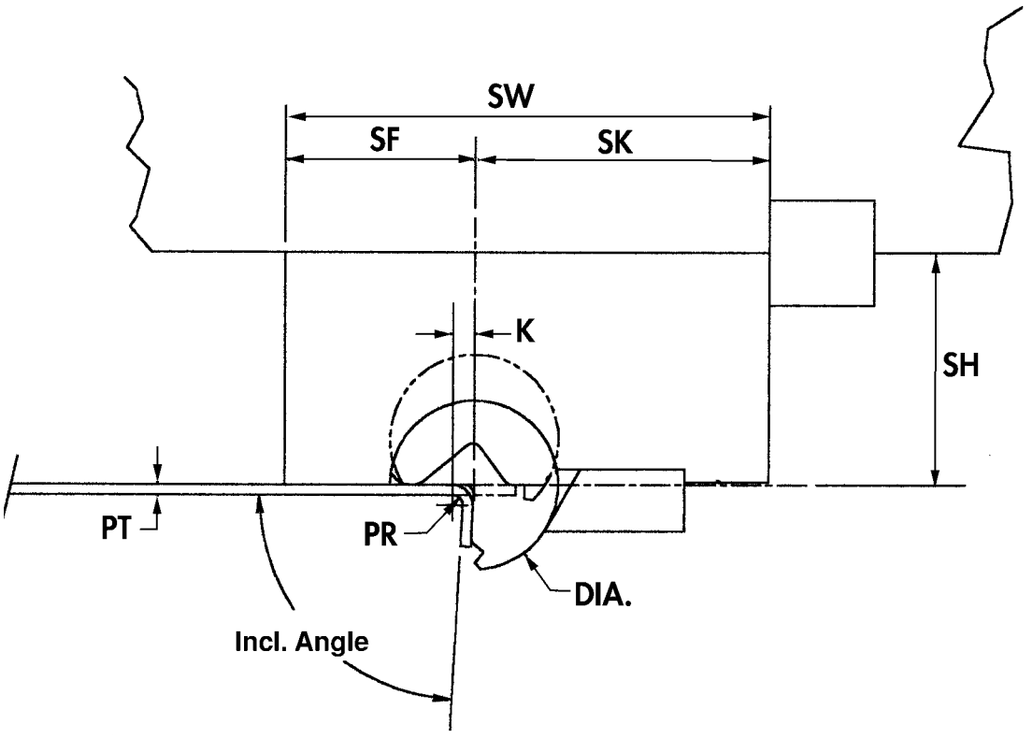
CB1
Square Bend

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

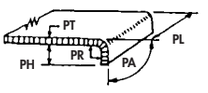
READY

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)



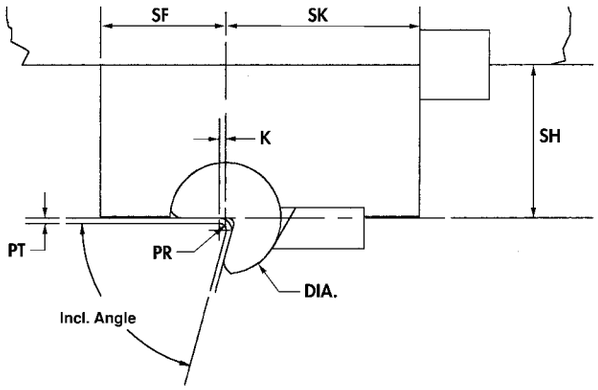
CB2
Short Leg

CB = **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

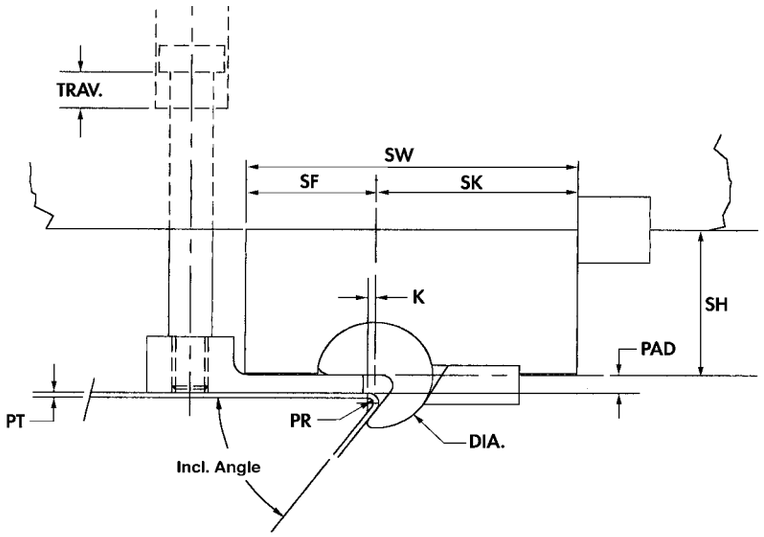
READY Bender®

CB3 Concept Sketch

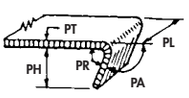


A READY Bender® CB3 bends where the bend angle is over 90° (120° max.).

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.



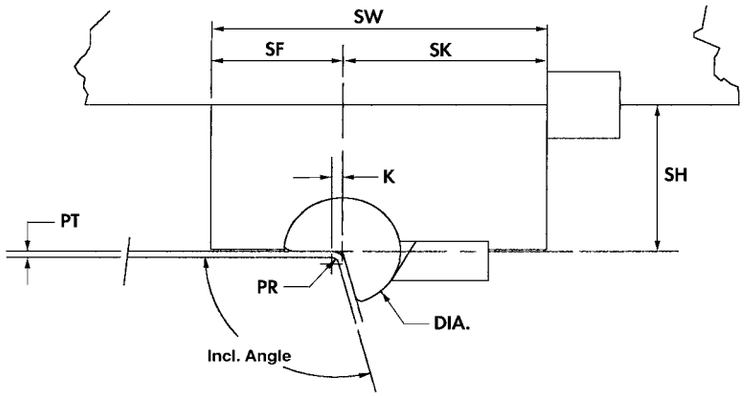
CB3
Over Square

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

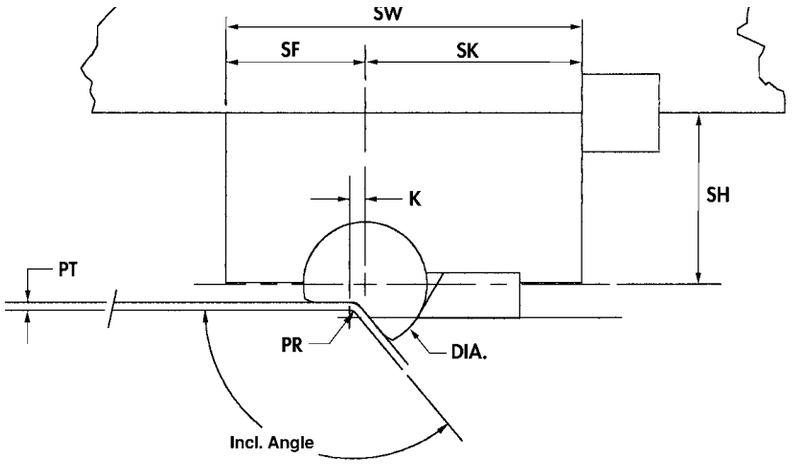
READY Bender®

CB4 Concept Sketch (on centerline)

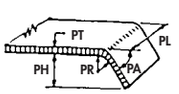


A READY Bender® CB4 (on centerline) - the maximum angle remaining on centerline is 105° included.

CB4 Concept Sketch (above centerline)



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

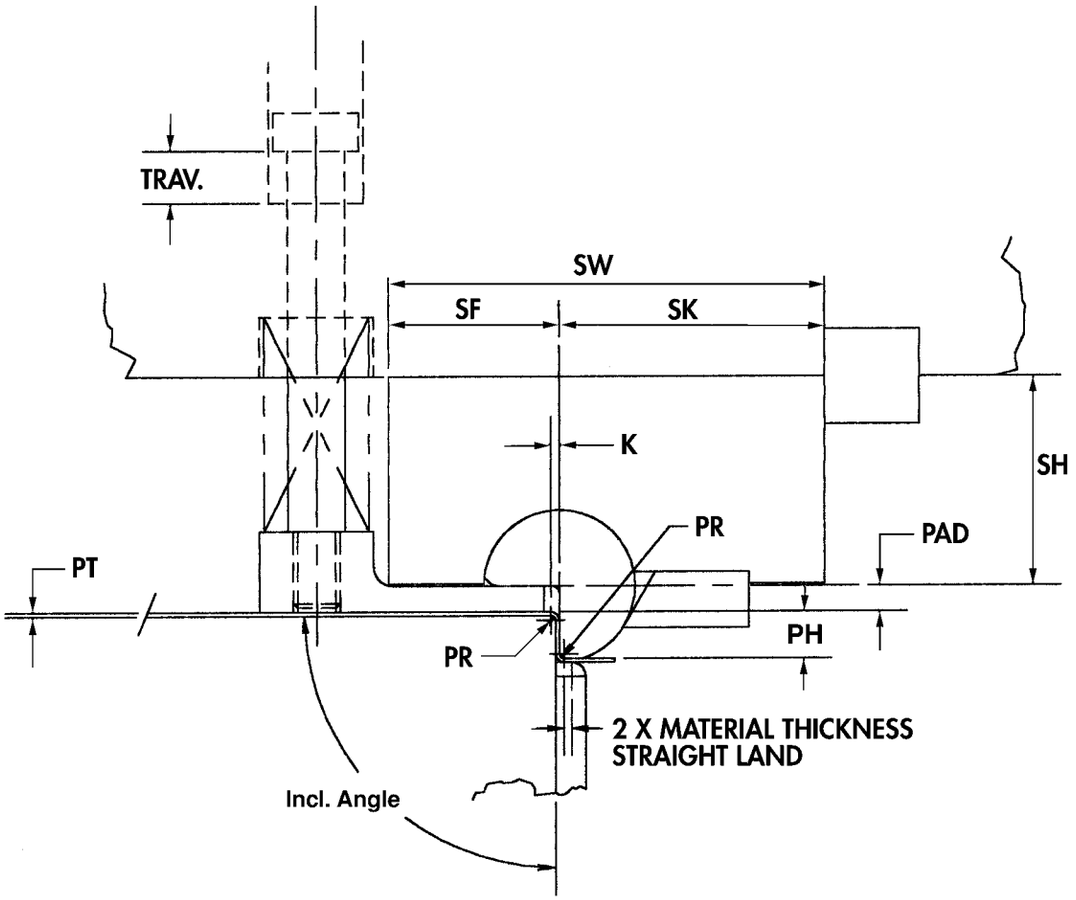


CB4
Under Square

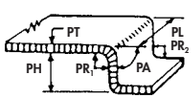
CB = **C**lassified **B**end #
PT = **P**art Material **T**hickness
PL = **P**art **L**ength (bent leg)
PA = **P**art **A**ngle (degrees of bend)
PH = **P**art **H**eight (bent leg)
PR = **P**art **R**adius
PC = **P**art **C**hannel (inside)
K = see catalog
Incl. Angle = Included Angle

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.



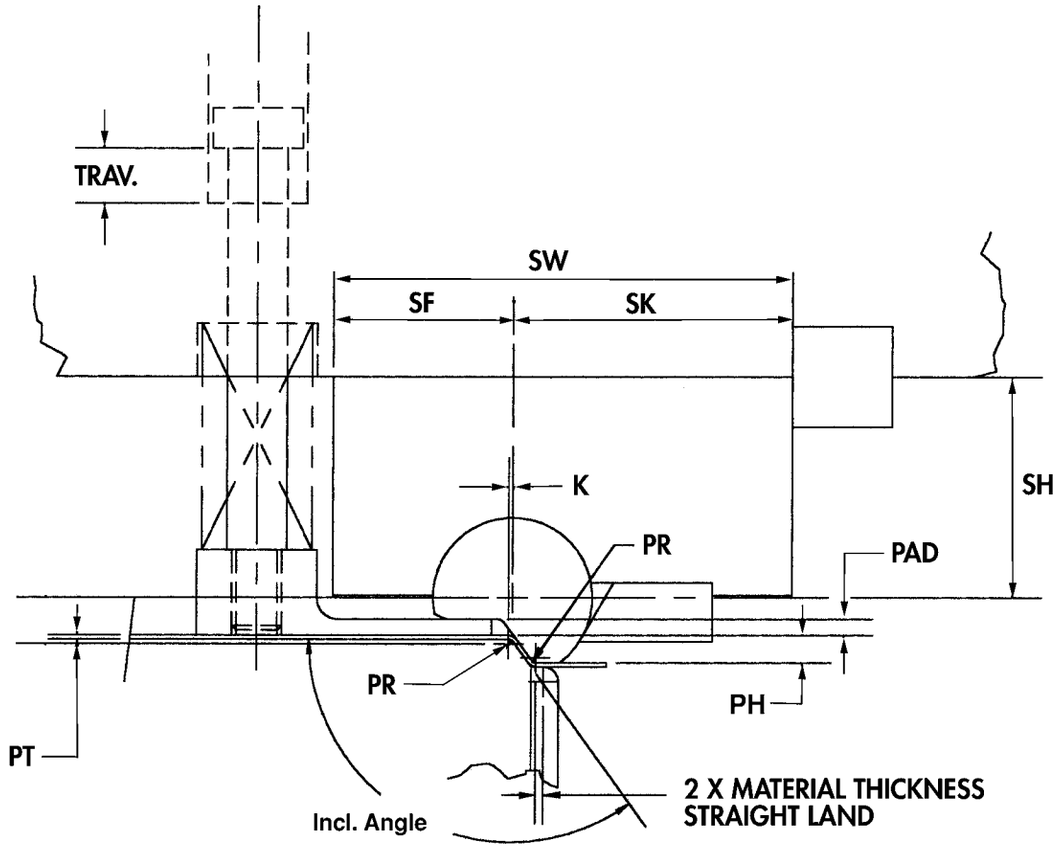
CB5
Zee Bend

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

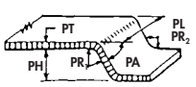
READY

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.



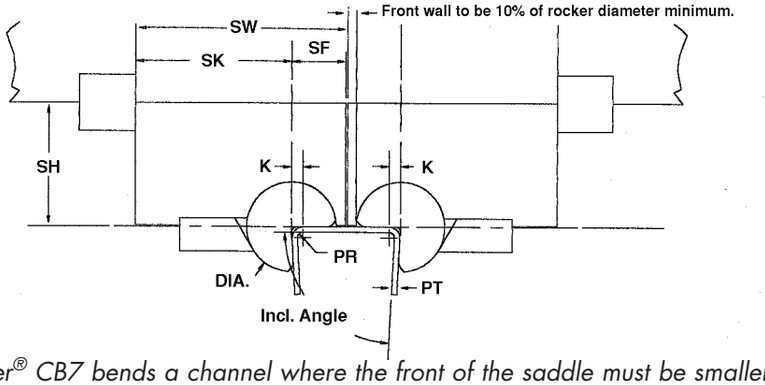
CB6
Open Zee

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

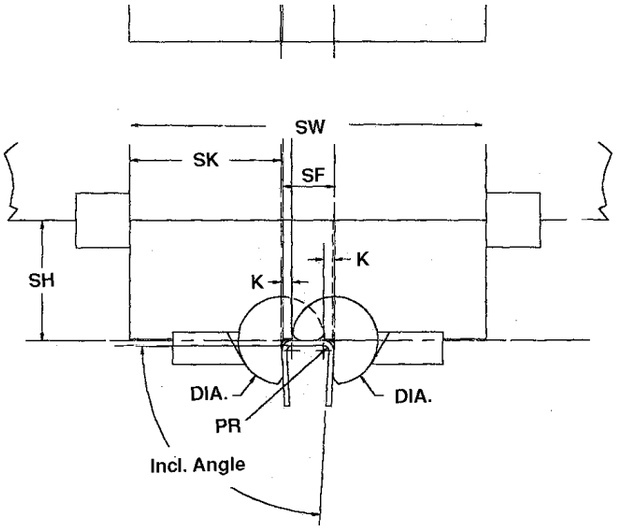
READY Bender®

CB7 Concept Sketch (not interlaced)

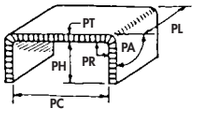


READY Bender® CB7 bends a channel where the front of the saddle must be smaller than standard.

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.

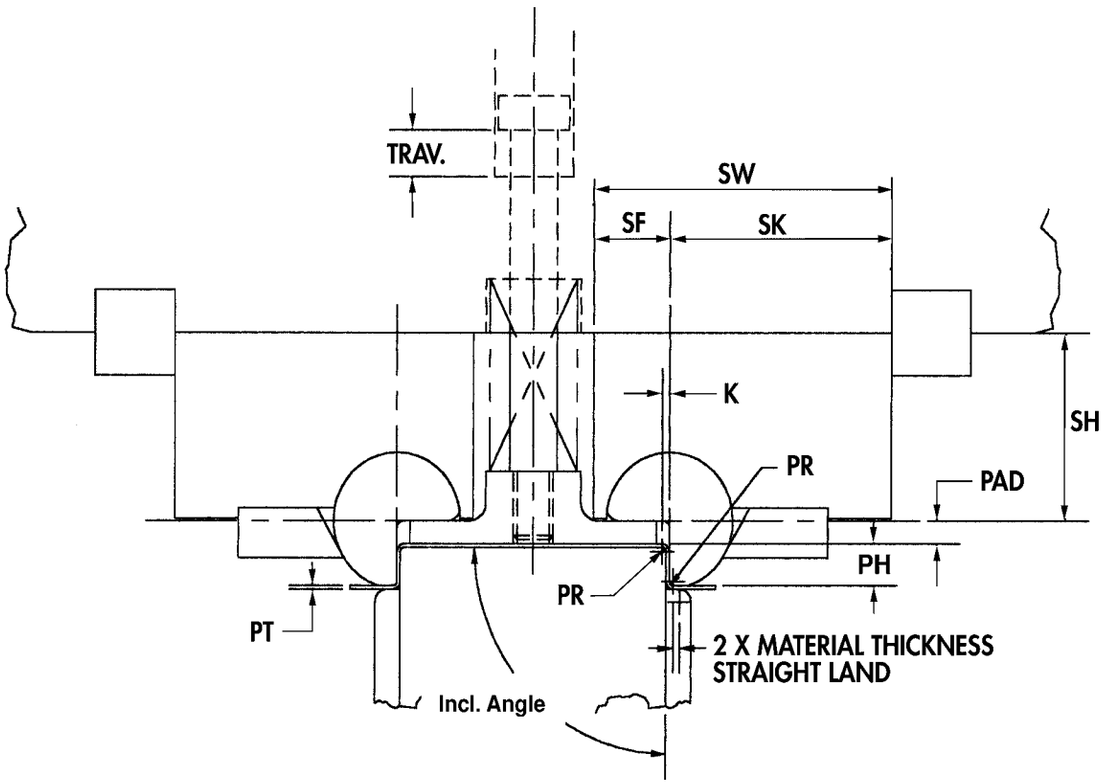


CB7
Channel Bend

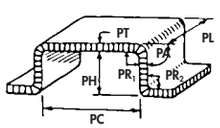
CB = **C**lassified **B**end #
PT = **P**art Material **T**hickness
PL = **P**art **L**ength (bent leg)
PA = **P**art **A**ngle (degrees of bend)
PH = **P**art **H**eight (bent leg)
PR = **P**art **R**adius
PC = **P**art **C**hannel (inside)
K = see catalog
Incl. Angle = Included Angle

READY Bender®

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.

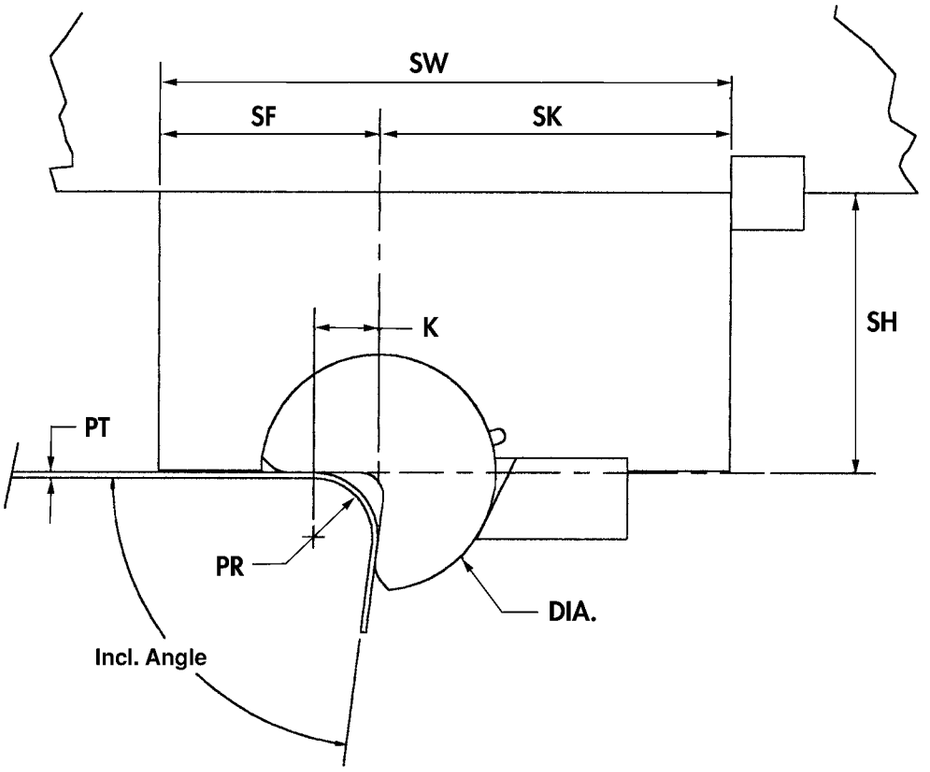


CB8
Hat Bend

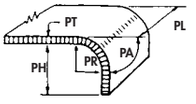
CB = **C**lassified **B**end #
PT = **P**art Material **T**hickness
PL = **P**art **L**ength (bent leg)
PA = **P**art **A**ngle (degrees of bend)
PH = **P**art **H**eight (bent leg)
PR = **P**art **R**adius
PC = **P**art **C**hannel (inside)
K = see catalog
Incl. Angle = Included Angle

READY Bender®

CB13 Concept Sketch (large radius)



READY Bender® CB13 - the bend is a Larger 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. Due to additional springback, Anvil Radius may need to be smaller than final Part Radius (PA).



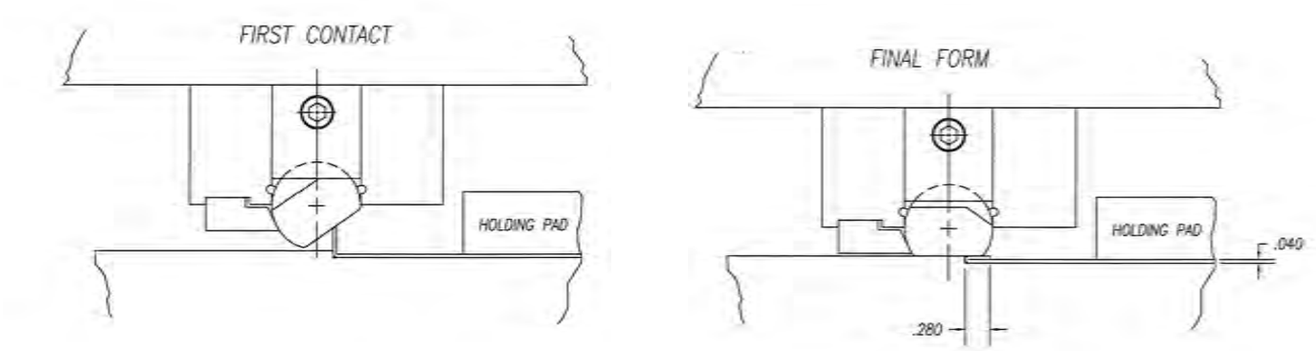
CB13
Large Radius Bend

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

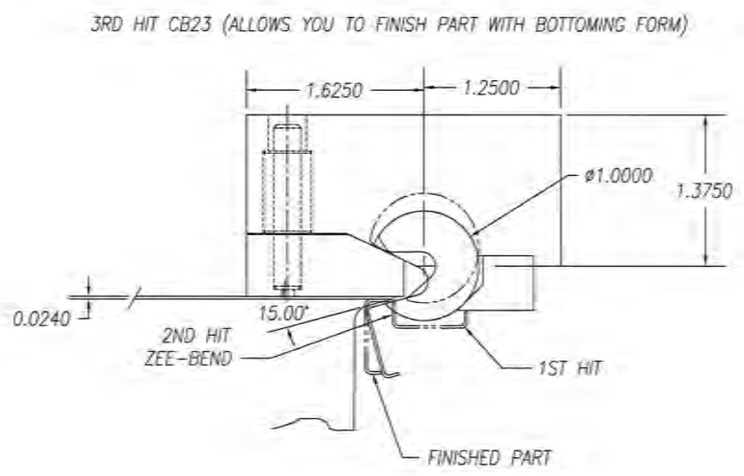
READY

READY Bender®

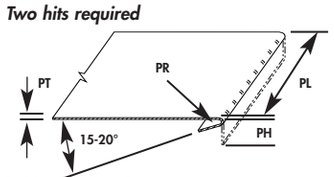
CB 22 Concept Sketch



CB 23 Concept Sketch

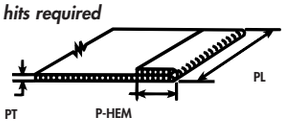


Two hits required



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

READY

Selecting the right Bender is as easy as 1 . . . 2 . . . 3
Fax or email this worksheet for *FAST QUOTES*

benders@readytechnology.com

1 Company: _____

Contact Name: _____ Title: _____

Address: _____

City, State, Zip: _____

Telephone: _____ Fax: _____

Email Address: _____

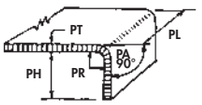
2 Please describe your application

This will be formed in (please check)

❑ Stamping Die ❑ Automated Machine ❑ Press Brake, tonnage of press brake _____

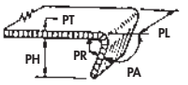
Here are some of the most popular applications:

Square Bend CB1



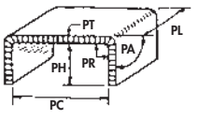
90° Bend

Over Square CB3



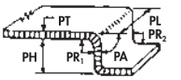
Form 135° In One Hit

Channel Bend CB7



Even Narrow Channels

Zee Bend CB5



Form Offsets In One Hit

Annual production _____

Type of material formed _____

Tensile strength _____

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) _____

Are tool marks* on part acceptable\ _____

We specialize in forming even prepaint without tool marks.

Notes

3 Please Quote:

Stamping Dies

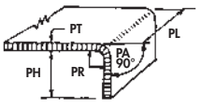
❑ Ready makes determination
❑ The READY Bender
❑ Ready High Production Bender
❑ Ready Bender - Metric
❑ Ready High Production Bender - Metric
❑ Compact Benders

Press Brake Tooling

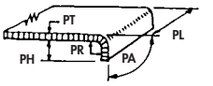
❑ Rotary Bender Press Brake Tools
❑ Conventional Vee Die Brake Tools
❑ Special Brake Tooling per print

Classified Bends (CB)

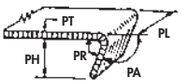
Square Bend CB1



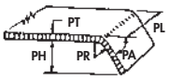
Short Leg CB2



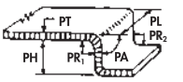
Over Square CB3
prehem



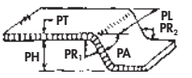
Under Square CB4



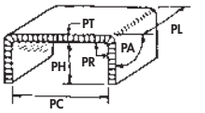
Zee Bend CB5



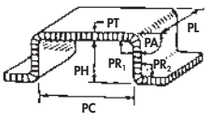
Open Zee CB6



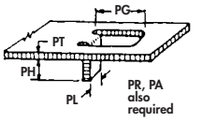
Channel Bend CB7



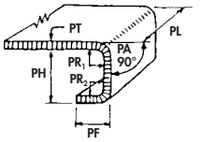
Hat Bend CB8



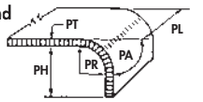
Gutted Bend CB11



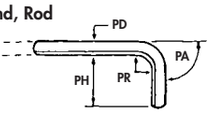
Return Bend CB12
Two hits required



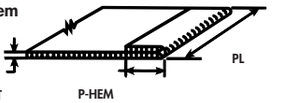
Large Radius Bend CB13



Square Bend, Rod CB21

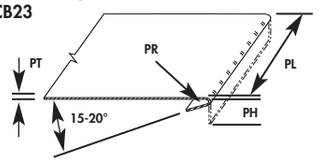


Full Hem CB22



Two hits required

Precision Open Hem CB23 *Two hits required*



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