



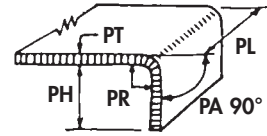
READY High Production Benders - Metric

- Use whenever production exceeds a million parts, ideal for most stamping dies.
- In stock lengths, see page 17. Now available up to 914.4 mm long.
- For custom lengths, see page 18.

- Our highest production bender - now available up to 914.4 mm long.
- This is an inch product, the same as READY High Production Benders - Inch, 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, .254 mm gap between.



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. If you have questions or need a special quotation, please fax the worksheet on back cover with prints.

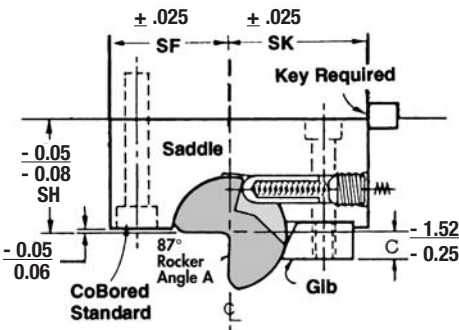
Features:

1. **Rockers:** fully hardened (Rc 56 to 62), S-7 tool steel.
2. **Saddles:** fully hardened (Rc 48 to 52) 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.

All dimensions are in millimeters.

Part Material Thickness (PT)	0.25 - 1	1 - 1.19	1.9 - 3	3 - 4.1	4.1 - 5.3	5.3 - 6.4
Part Height Check (PH)	6.35	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)	28.6 88.90 152.40	38.1 101.60 152.40 228.60	50.8 127.00 203.20	63.5 177.80	76.2 177.80	88.9 152.40
Minimum Length (X) (Gib Length - GL)	28.6	38.1	50.8	63.5	76.2	88.9
Maximum Length (X)	609.6	609.6	914.4	914.4	914.4	914.4
MODEL CALLOUT	RMC 62	RMC 100	RMC 150	RMC 200	RMC 250	RMC 300

Standard READY High Production Bender - Metric

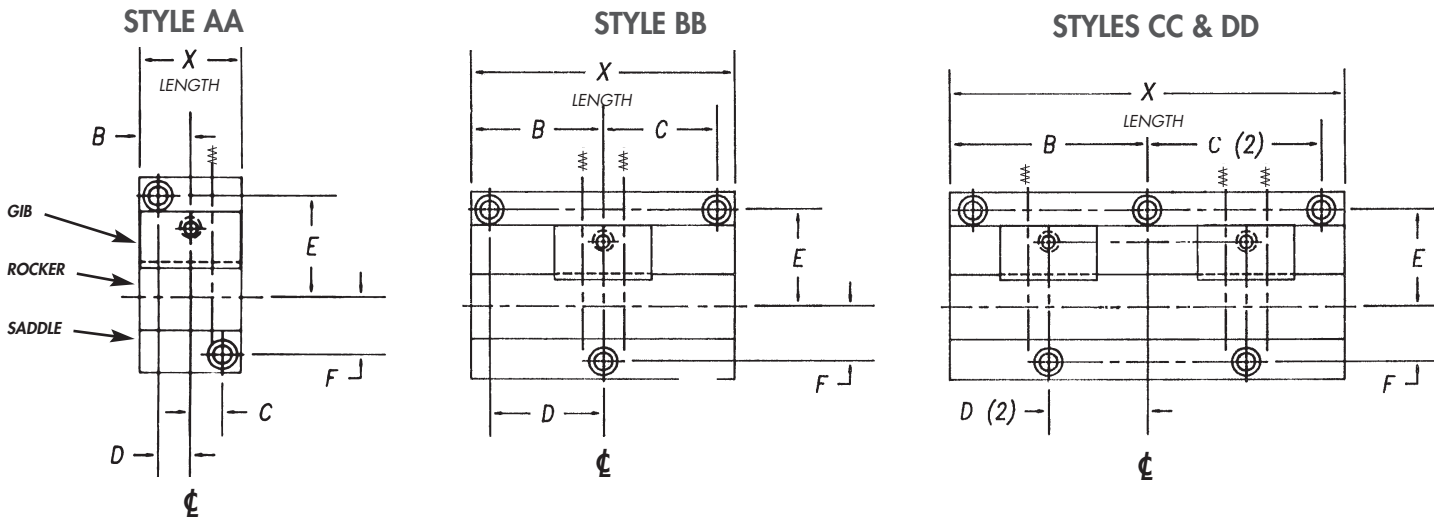


- Tapped mounting holes available as specials.

Rocker Diameter (87° Angle)	15.88	25.4	38.1	50.8	63.5	76.2
Saddle Width (SW)	53.98	73.03	98.42	123.83	149.23	174.63
Saddle to Front (SF)	19.05	28.58	38.10	47.63	57.15	69.85
Saddle to Key (SK)	34.93	44.45	60.33	76.20	92.08	104.78
Saddle Height (SH)	22.23	34.93	47.63	60.33	73.03	85.73
Gib Length (GL)	28.6	38.1	50.8	63.5	76.2	88.9
Rocker Dimensions						
(B)	5.39	8.61	12.90	17.22	21.54	25.83
(C)	4.95	7.93	11.89	15.85	19.81	23.77
(J)	6.24	9.98	14.97	19.96	24.95	29.94

READY High Production Benders - Metric: in stock lengths

- Our highest production bender.
- Custom lengths up to 609.6 or 914.4 mm long available, see page 18.
- This is an inch product, the same as READY High Production Benders - Inch, on pages 6 to 8, except with metric mounting holes.



Mounting Hole Locations

Model Callout	Length Style	X Length	B	C	D	E	F	SHCS size
RMC 62	AA	28.58	14.29	9.00	9.00	30.00	14.00	M4
	CC	88.90	44.45	38.46	22.23	30.00	14.00	M4
	DD	152.40	76.20	70.21	38.10	30.00	14.00	M4
RMC 100	AA	38.10	19.05	12.00	12.00	37.50	21.50	M6
	BB	101.60	50.80	44.25	44.25	37.50	21.50	M6
	CC	152.40	76.20	67.18	38.10	37.50	21.50	M6
	DD	228.60	114.30	105.31	57.15	37.50	21.50	M6
RMC 150	AA	50.80	25.40	17.00	17.00	50.00	30.00	M8
	BB	127.00	63.50	51.51	51.51	50.00	30.00	M8
	CC	203.20	101.60	86.59	50.80	50.00	30.00	M8
RMC 200	AA	63.50	31.750	21.50	21.50	65.00	37.50	M10
	BB	177.80	88.90	73.89	73.89	65.00	37.50	M10
RMC 250	AA	76.20	38.10	25.00	25.00	79.00	44.00	M12
	BB	177.80	88.90	70.89	70.89	79.00	44.00	M12
RMC 300	AA	88.90	44.45	32.50	32.50	92.50	57.00	M12
	BB	152.40	76.20	58.19	58.19	92.50	57.00	M12

Tolerances Held
 X = saddle length
 +0mm / -0.25mm;
 X = rocker length
 +0.25mm / -0mm;
 Screw locations held
 ± 0.13mm;

Order Example:

RMC	100	X = DD
READY Model Callout	Rocker Diameter 25.4 mm	Specify Length Bender

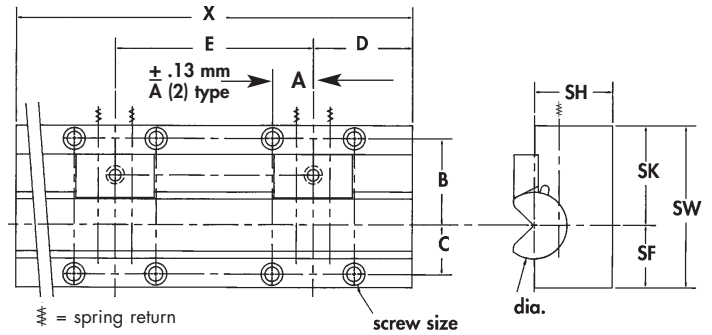
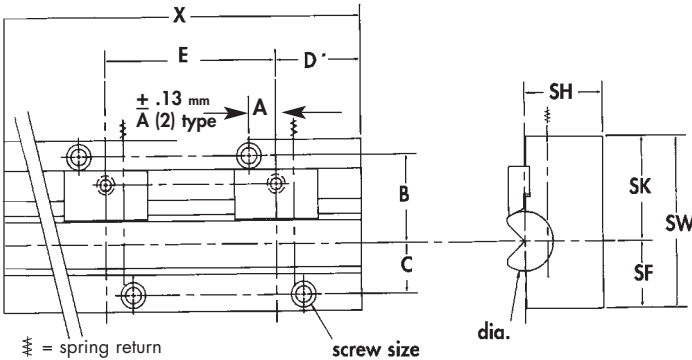
READY High Production Benders - Metric: Custom Lengths

- READY's CNC grinding technology, delivers lengths up to 914.4 mm long at attractive prices.
- Longer lengths achieved by butting two or more units end-to-end, .25 mm gap.

- Now available up to 914.4 mm long.
- Specify your desired length (X) and READY will deliver.
- This is an inch product, the same as READY High Production Benders - Inch on pages 6 to 8, except with metric mounting holes.

RMC 62, 100 and 150 Repeating Hole Patterns
(for 15.88, 25.4 and 38.1 mm Diameter Rockers)

RMC 200, 250 and 300 Repeating Hole Patterns
(for 50.8, 63.5, 76.2 mm Diameter Rockers)



All dimensions are in millimeters, unless noted otherwise.

Minimum/Maximum Lengths:

- Charts and drawings showing hole locations, etc., start at nominal lengths. Custom lengths start very short, at catalog Gib Length (GL) dimensions.
- Mounting hole patterns for shorter, custom lengths are available upon request by application.
 - RMC 62** Minimum 29 mm (GL) Maximum 609.6 mm
 - RMC 100** Minimum 39 mm (GL) Maximum 609.6 mm
 - RMC 150** Minimum 51 mm (GL) Maximum 914.4 mm
 - RMC 200** Minimum 64 mm (GL) Maximum 914.4 mm
 - RMC 250** Minimum 77 mm (GL) Maximum 914.4 mm
 - RMC 300** Minimum 89 mm (GL) Maximum 914.4 mm

3. PLEASE NOTE: Standard in stock lengths of READY High Production Benders are cataloged on page 17. These ship fast and cost less. The READY Bender® - Metric, pages 14 and 15, is available in custom lengths and can further reduce your tooling budget.

NOTE:

- Counterbored holes standard, tapped available as specials.

Model and Rocker Diameter	X Length	A	B	C	D	E	SHCS size
RMC 62 15.88mm dia.	lengths 152.4 - 305 mm	9.00	30.00	14.00	X / 8	X / 4	M4
RMC 100 25.4mm dia.		12.00	37.50	21.50	X / 8	X / 4	M6
RMC 150 38.1mm dia.		17.00	50.00	30.00	X / 6	X / 3	M8
RMC 62 15.88mm dia.	lengths 317.5 - 609.6 mm	9.00	30.00	14.00	X / 12	X / 6	M4
RMC 100 25.4mm dia.		12.00	37.50	21.50	X / 12	X / 6	M6
RMC 150 38.1mm dia.		17.00	50.00	30.00	X / 10	X / 5	M8
RMC 62 15.88mm dia.	lengths 622.3 - 914.4 mm	9.00	30.00	14.00	X / 16	X / 8	M4
RMC 100 25.4mm dia.		12.00	37.50	21.50	X / 16	X / 8	M6
RMC 150 38.1mm dia.		17.00	50.00	30.00	X / 14	X / 7	M8
RMC 200 50.8mm dia.	lengths 203.2 - 305 mm	31.50	66.00	37.50			M10
RMC 250 63.5mm dia.		35.00	79.00	44.00	X / 4	X / 2	M12
RMC 300 76.2mm dia.		40.00	92.50	57.00			M12
RMC 200 50.8mm dia.	lengths 317.5 - 609.6 mm	31.50	66.00	37.50			M10
RMC 250 63.5mm dia.		35.00	79.00	44.00	X / 6	X / 3	M12
RMC 300 76.2mm dia.		40.00	92.50	57.00			M12
RMC 200 50.8mm dia.	lengths 622.3 - 914.4 mm	31.50	66.00	37.50			M10
RMC 250 63.5mm dia.		35.00	79.00	44.00	X / 10	X / 5	M12
RMC 300 76.2mm dia.		40.00	92.50	57.00			M12