

READY Benders® - Inch

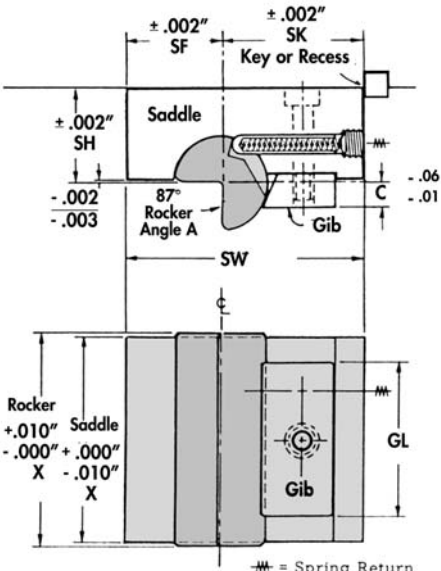
Benders are now less expensive than wipe tooling.

- Designed to produce up to one million parts, ideal for most stamping dies.
- In stock lengths: 12", 24" and up to 36" long.
- Segment stock lengths to reduce your tooling budget; quick delivery.
- Custom lengths available, specify.

Features:

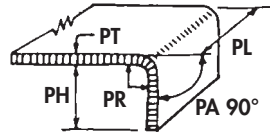
- 1. Rockers:** fully hardened (Rc 56 to 62), S-7 tool steel.
- 2. Saddles:** machinable thru hardened steel; mounting holes left for diemaker to locate where needed. Contact Ready Engineering for suggestions.
- 3.** Saddle socket is coated for lubrication and long life. Saddle has flush mount lube fittings.
- 4.** Rockers and saddles are CNC ground for precision and interchangeability.
- 5.** 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 Bender® - Inch



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, .010" 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.

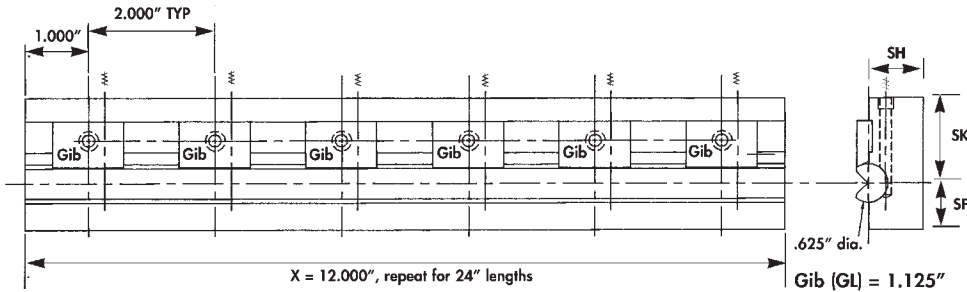
	Part Thickness (PT)	.010"-.042"	.043"-.075"	.076"-.120"	.121"-.164"	.165"-.209"	.210"-.250"
	Gage Thickness	25 to 19	19 to 14	14 to 11	11 to 8	8 to 5	5 to 1/4"
	Part Height Check (PH)	.250"	.390"	.580"	.775"	.970"	1.160"
		To use standard benders, PH should exceed these dimensions. Fax prints for specials.					
	In Stock Lengths, X =	12", 24"	12", 24"	12", 24", 36"	12", 24", 36"	12", 24", 36"	12", 24", 36"
	Minimum Length (X) (Gib Length - GL)	1.125"	1.500"	2.000"	2.500"	3.000"	3.500"
	Maximum Length (X)	24"	24"	36"	36"	36"	36"
	MODEL CALLOUT	HIB 62	HIB 100	HIB 150	HIB 200	HIB 250	HIB 300

	Rocker Diameter 87° Angle	.625"	1.000"	1.500"	2.000"	2.500"	3.000"
	Saddle Width (SW)	2.125"	2.875"	3.875"	4.875"	5.875"	6.875"
	Saddle to Front (SF)	.750"	1.125"	1.500"	1.875"	2.250"	2.750"
	Saddle to Key (SK)	1.375"	1.750"	2.375"	3.000"	3.625"	4.125"
	Saddle Height (SH)	.875"	1.375"	1.875"	2.375"	2.875"	3.375"
	Gib Length (GL)	1.125"	1.500"	2.000"	2.500"	3.000"	3.500"
	Rocker Dimensions						
	(B)	.212"	.339"	.508"	.678"	.848"	1.017"
	(C)	.195"	.312"	.468"	.624"	.780"	.936"
	(J)	.246"	.393"	.590"	.786"	.983"	1.179"

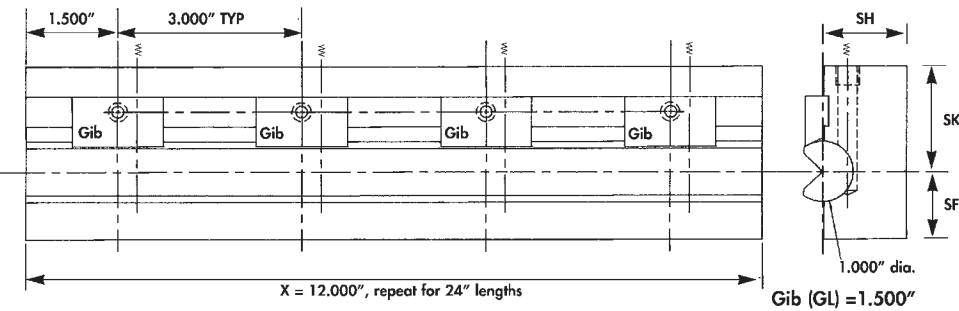
READY Benders® - Inch: in stock lengths 12", 24" and in some styles 36" long.

- Designed so you can segment to shorter custom lengths.
- Minimum segment size is the Gib Length (GL).
- Custom lengths available, specify.

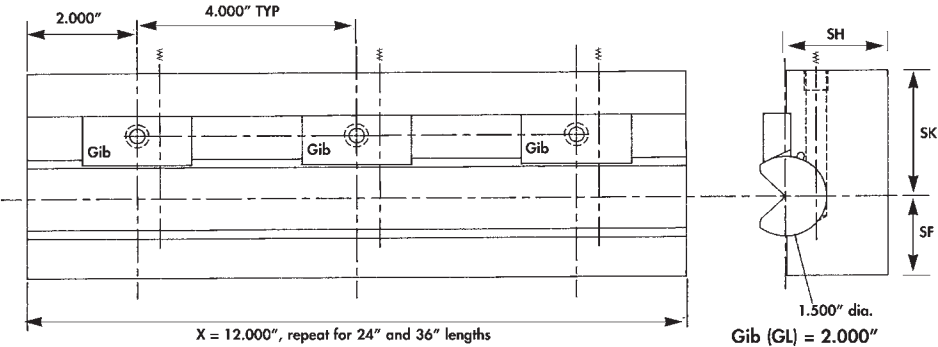
HIB 62: 12" and 24" lengths in stock, 5/8" Diameter Rocker



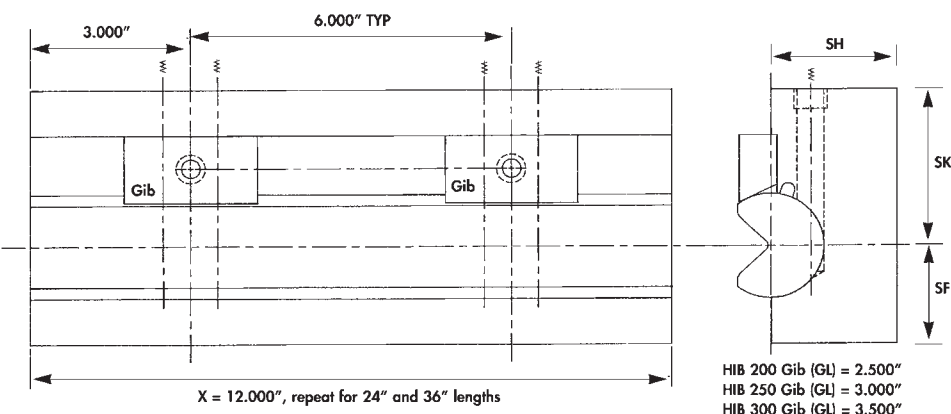
HIB 100: 12" & 24" lengths in stock, 1" Diameter Rocker



HIB 150: 12", 24" & 36" lengths in stock, 1 1/2" Diameter Rocker



HIB 200, 250 and 300: 12", 24" & 36" lengths in stock, 2", 2 1/2" and 3" Diameter Rockers



Length Segmenting:

1. 12" lengths are shown (left). 24" and 36" lengths are a repeating pattern of the 12" length.
2. Minimum segmenting size is the GL (gib length) dimension. Each segment needs a gib to retain rocker. Spring returns are marked by $\frac{1}{4}$ and are under gibs.

How to Segment:

1. Remove rocker by taking out set screw/lube fitting. Rotate rocker to remove the spring return plunger mechanism and rocker.
2. Rocker is fully hardened (Rc 56-62). Cut with wire machine or best way to precise length/size.
3. Saddle is machinable. Cut with wire machine or best way to precise length.
4. CAUTION: Thoroughly de-burr and clean saddle and rocker. Make sure no chips or dirt remain in saddle/rocker spring return pockets before reassembly.
5. Reassemble and check to make sure rocker returns easily when rotated.

READY Can Segment:

1. You must purchase the entire 12", 24" or 36" length and specify the segment dimensions. The remaining pieces are shipped with the tooling unless specified otherwise. No rebates on unused pieces.
2. For precision cuts, call READY for pricing - 1-800-543-4355.

Order Example:		
HIB	100	X = 24"
READY Model Callout	Rocker Diameter 1"	Specify Length of Bender

$\frac{1}{4}$ = spring return
GL = gib length

Flush mount lube fittings at end of spring return.