

READY Benders® - Metric

Metric Benders are now less expensive than wipe tooling.

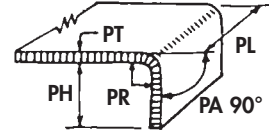
- Designed to produce up to one million parts, ideal for most stamping dies.
- In stock lengths: 304.8, 609.6 and up to 914.4 mm long.
- Segment stock lengths to further reduce your tooling budget; quick delivery.
- Custom lengths available, specify.

Features:

- 1. Rockers:** fully hardened (Rc 56 - Rc 62), S-7 tool steel. Rockers and gibs are held to inch dimensions.
- 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.

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.



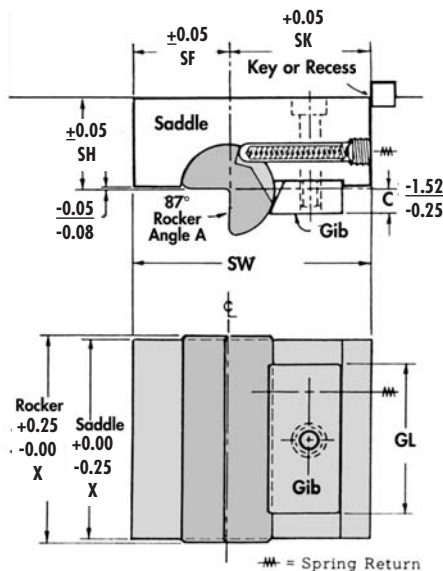
PT = part thickness
PH = part height
PR = part radius
PA = part angle
PL = part length

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.

All dimensions are in millimeters.

Part Material Thickness (PT)	0.25-1	1-1.9	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 =	304.8 609.6	304.8 609.6	304.8 609.6 914.4	304.8 609.6 914.4	304.8 609.6 914.4	304.8 609.6 914.4
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	RBM 62	RBM 100	RBM 150	RBM 200	RBM 250	RBM 300

Standard READY Bender® - Metric

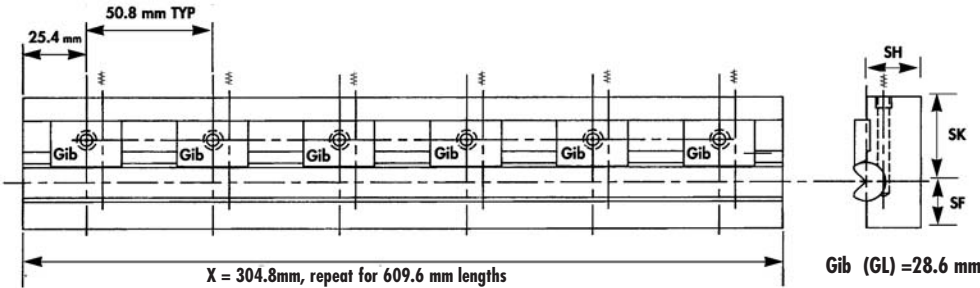


Rocker Diameter (87° Angle)	15.88	25.4	38.1	50.8	63.5	76.2
Saddle Width (SW)	53.98	73.03	98.42	123.83	149.23	174.63
Saddle to Front (SF)	19.05	28.58	38.10	47.63	57.15	69.85
Saddle to Key (SK)	34.93	44.45	60.33	76.20	92.08	104.78
Saddle Height (SH)	22.23	34.93	47.63	60.33	73.03	85.73
Gib Length (GL)	28.6	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

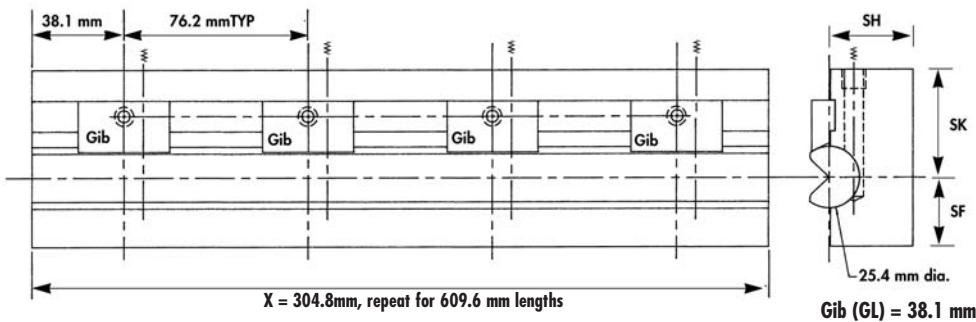
READY Benders® - Metric: in stock lengths 304.8, 609.6, and some styles 914.4 mm long

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

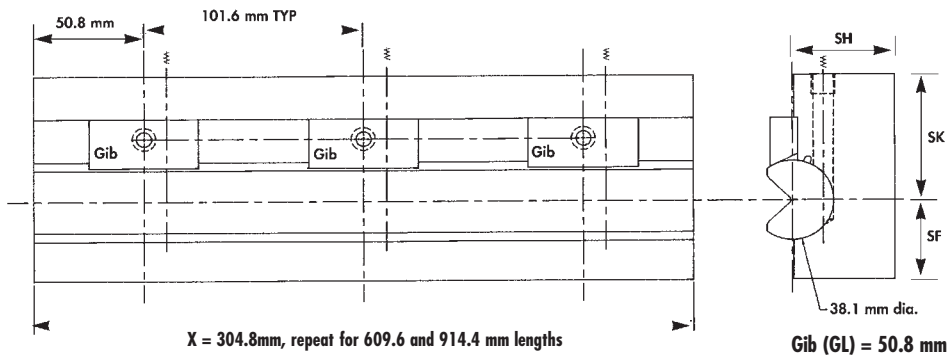
RBM 62: 304.8 & 609.6 mm lengths in stock, 15.88 mm diameter rocker



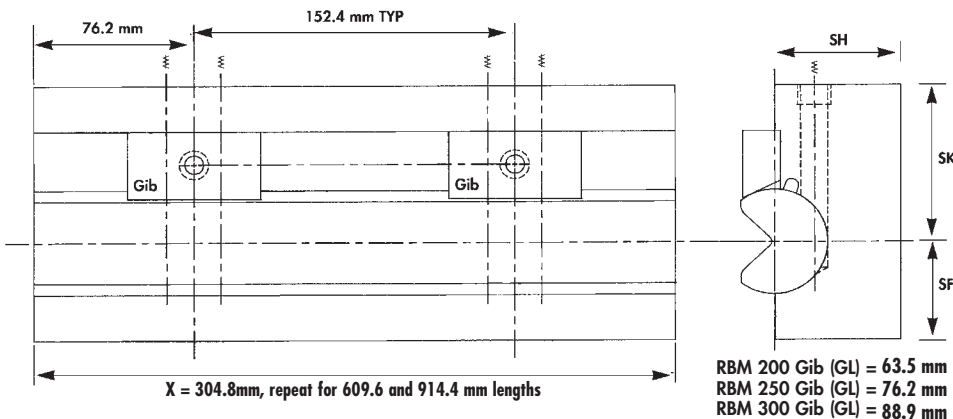
RBM 100: 304.8 & 609.6 mm lengths in stock, 25.4 mm diameter rocker



RBM 150: 304.8, 609.6 and 914.4 mm lengths in stock, 38.1 mm diameter rocker



RBM 200, 250 and 300: 304.8, 609.6 and 914.4 mm lengths in stock, 50.8, 63.5 and 76.2 mm dia rockers



Length Segmenting:

1. 304.8 mm lengths are shown (left). 609.6 and 914.4 mm lengths are a repeating pattern of the 304.8 mm length.

2. Minimum segmenting size is the GL (gib length) dimension. Each segment needs a gib to retain rocker. Spring returns are marked by ⦿ 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 304.8, 609.6 or 914.4 mm 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:

READY Model Callout	RBM 100 Rocker Diameter 25.4 mm	X = 609.6mm Specify Length of Bender 609.6 mm
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⦿ = spring return

GL = gib length

Flush mount lube fittings at end of spring return.