



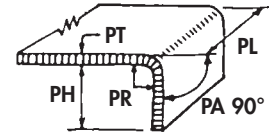
# READY High Production Benders - Metric

- 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.

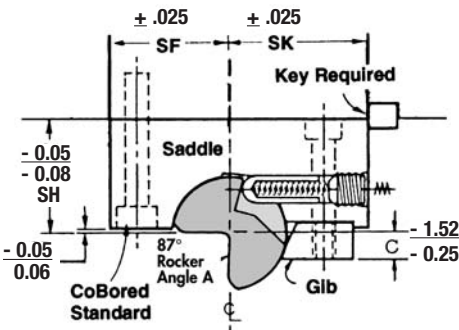
### Features:

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
<b>MODEL CALLOUT</b>	<b>RMC 62</b>	<b>RMC 100</b>	<b>RMC 150</b>	<b>RMC 200</b>	<b>RMC 250</b>	<b>RMC 300</b>

## Standard READY High Production Bender - Metric

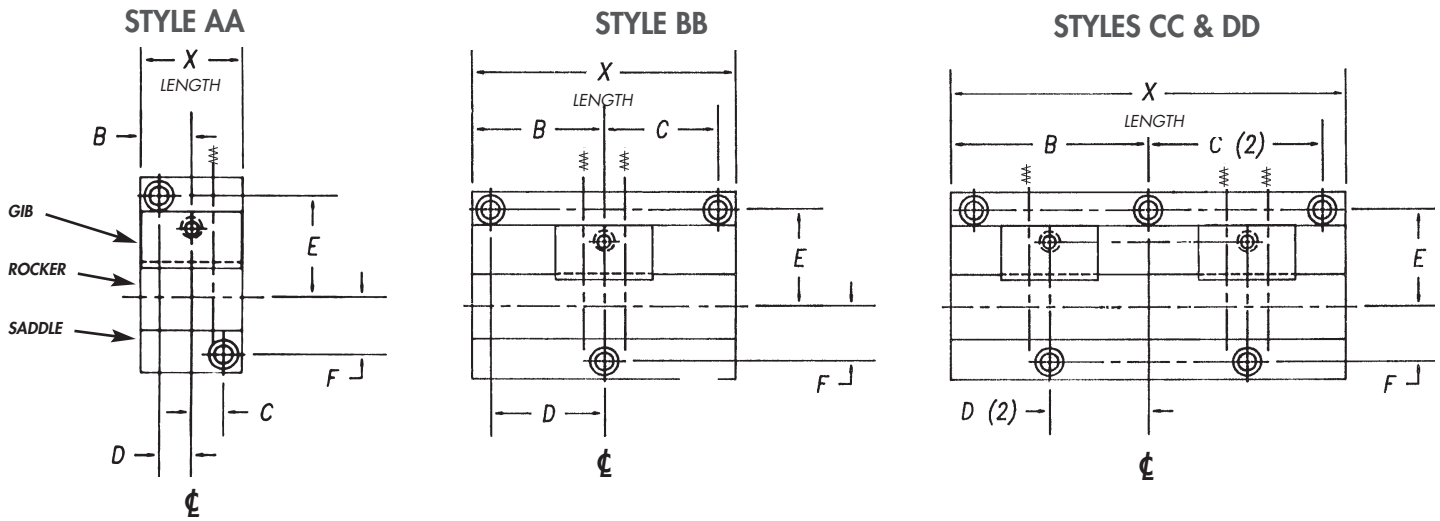


- Tapped mounting holes available as specials.

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
<b>Rocker Dimensions</b>						
(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**

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- Custom lengths up to 609.6 or 914.4 mm long available, see page 18.
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**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