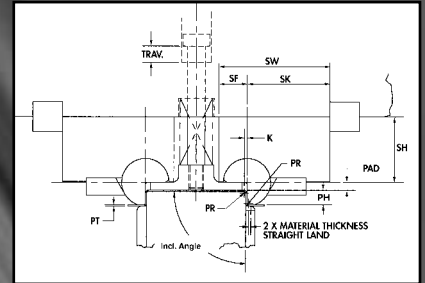
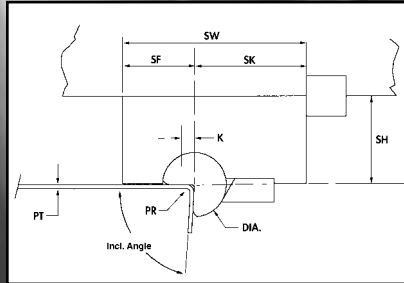
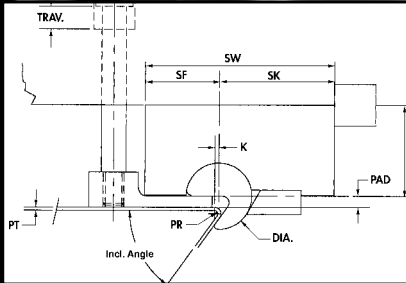
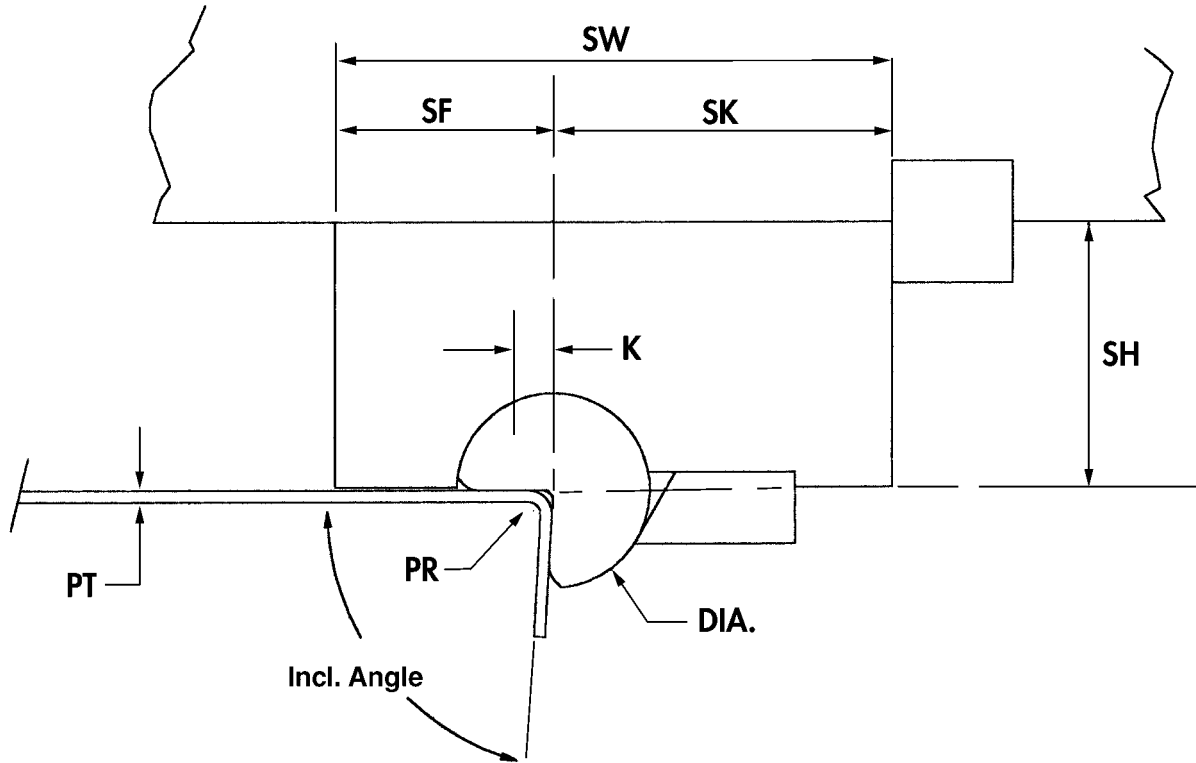


READY Bender[®]

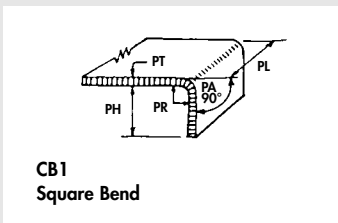
Concept Sketches



READY Bender® CB1 Concept Sketch

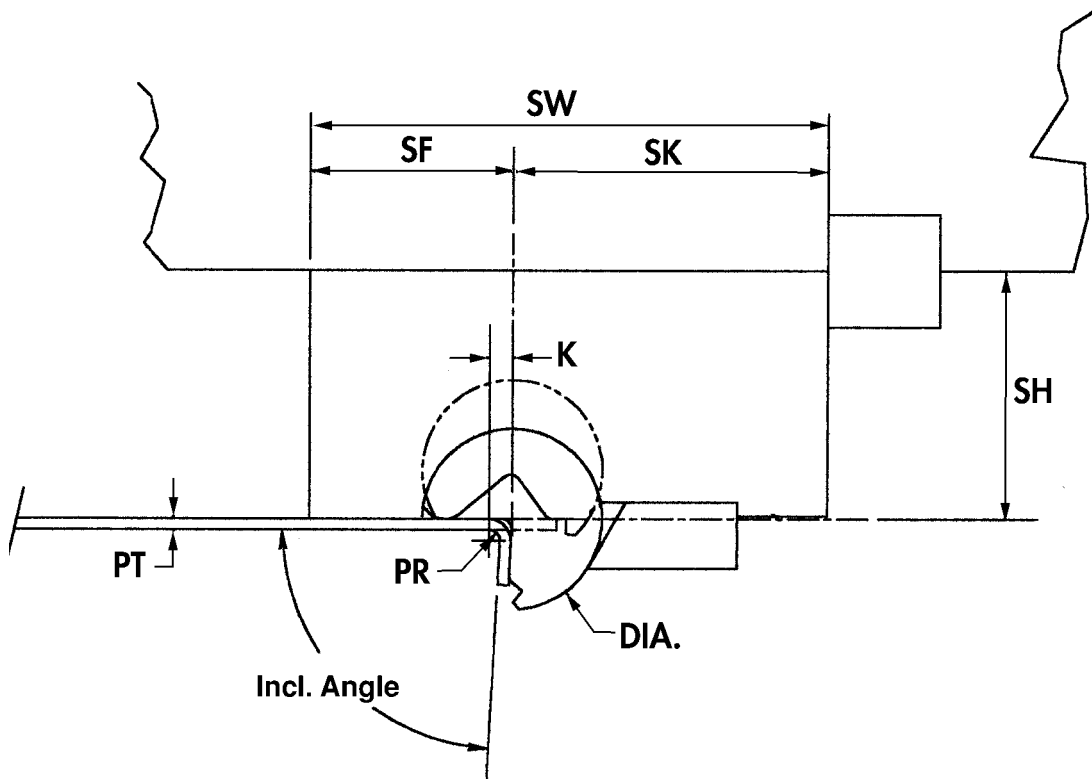


A READY Bender® is a CB1 tool when **PT**, **PR** and **PH** are within the proper parameters to use standard tooling.

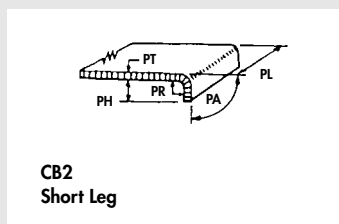


- CB = Classified Bend #
- PT = Part Material Thickness
- PL = Part Length (bent leg)
- PA = Part Angle (degrees of bend)
- PH = Part Height (bent leg)
- PR = Part Radius
- PC = Part Channel (inside)
- K = see catalog
- Incl. Angle = Included Angle

READY Bender® CB2 Concept Sketch

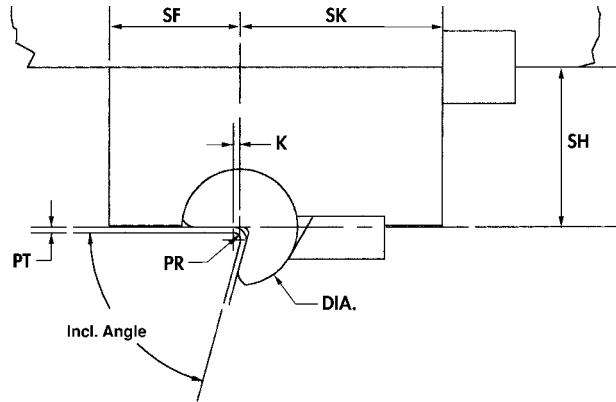


A READY Bender® is a CB2 tool when the **PH** dimension is too short to utilize a standard tool.
(Call READY for minimum dimensions)



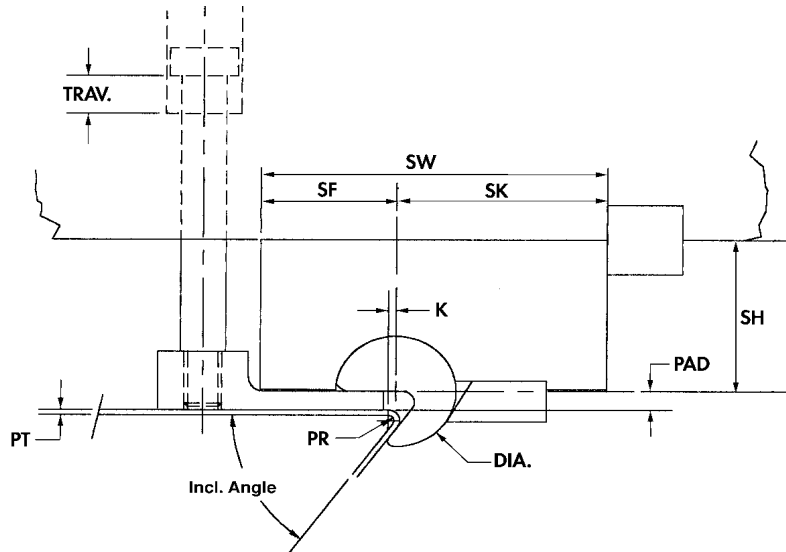
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- PR = Part Radius
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- K = see catalog
- Incl. Angle = Included Angle

READY Bender® CB3 Concept Sketch

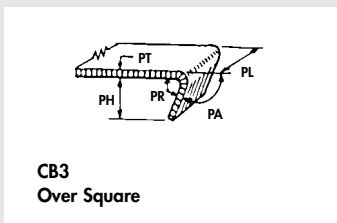


A READY Bender® CB3 bends where the bend angle is over 90° (120° max.).

CB3 Extreme Concept Sketch

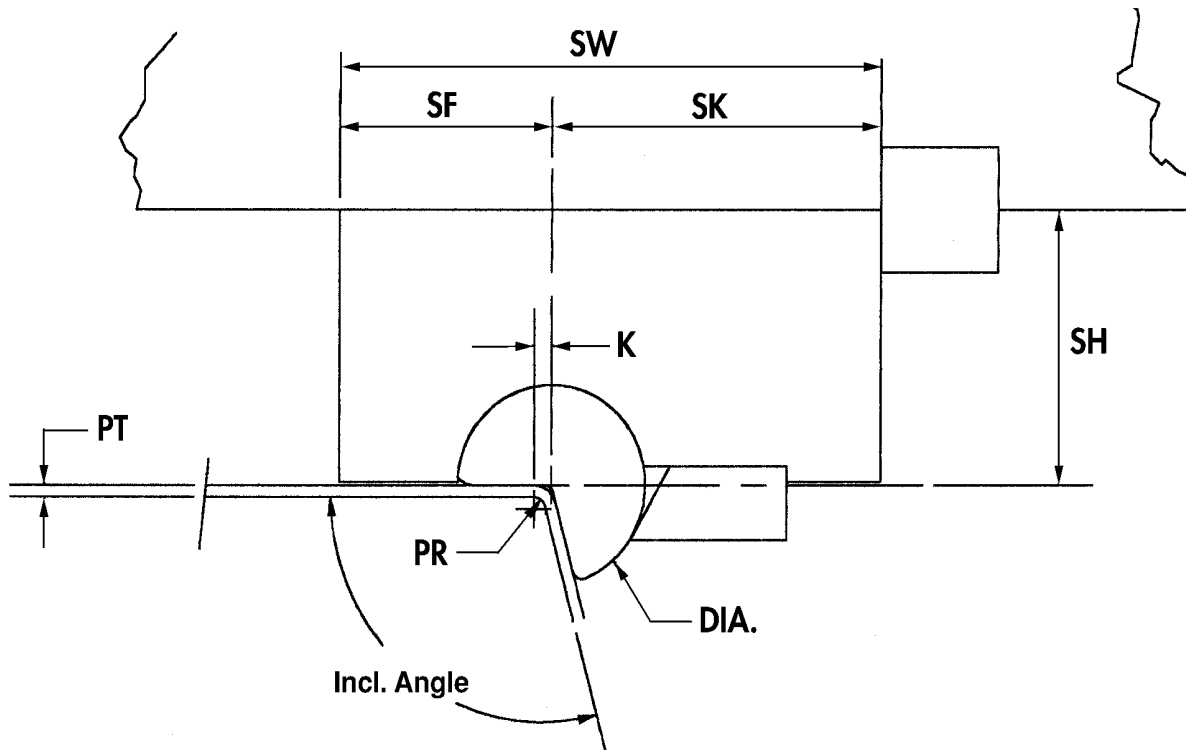


A READY Bender® CB3 Extreme (over 110°) will most likely need to run off of a pad. This is to keep the tool from sticking on the part.

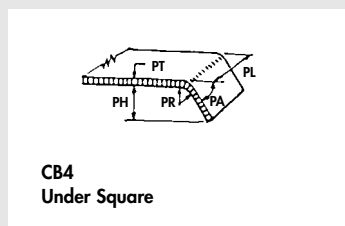


- CB = Classified Bend #
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- PA = Part Angle (degrees of bend)
- PH = Part Height (bent leg)
- PR = Part Radius
- PC = Part Channel (inside)
- K = see catalog
- Incl. Angle = Included Angle

READY Bender[®]
CB4 Concept Sketch (on centerline)

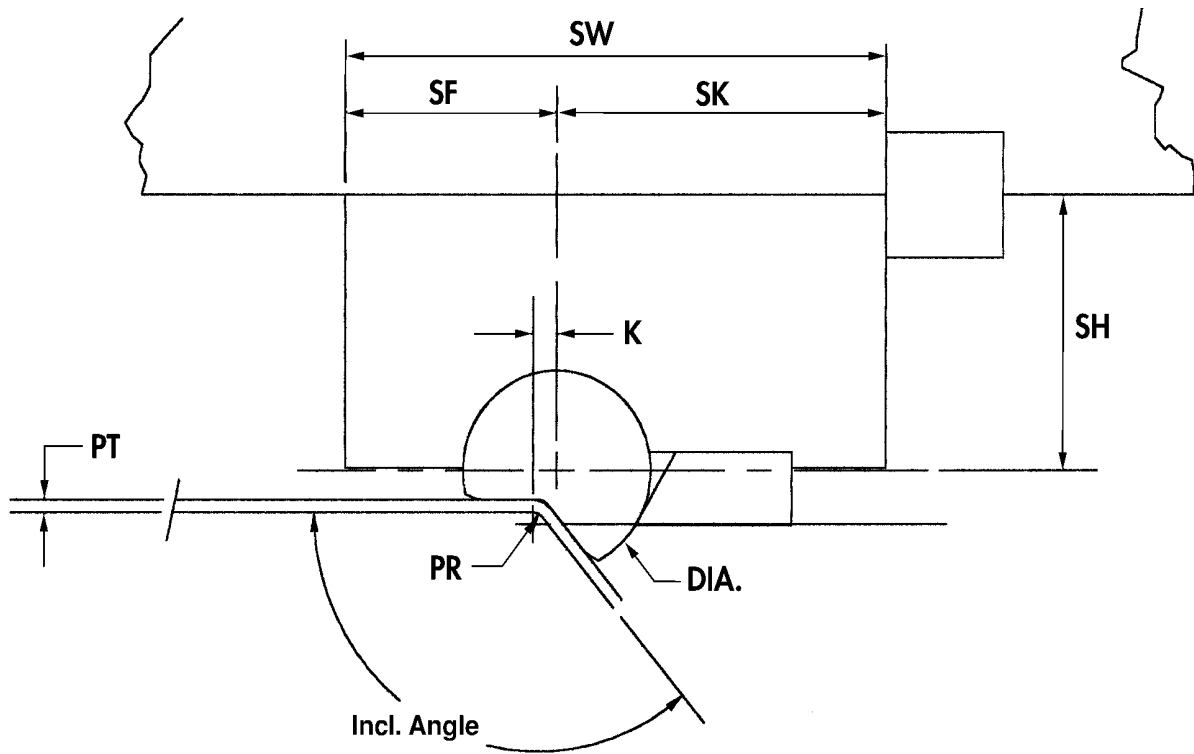


A READY Bender[®] CB4 (on centerline) - the maximum angle remaining on centerline is 105° included.

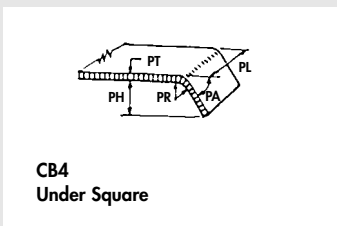


- CB = Classified Bend #
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- PA = Part Angle (degrees of bend)
- PH = Part Height (bent leg)
- PR = Part Radius
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- K = see catalog
- Incl. Angle = Included Angle

READY Bender[®]
CB4 Concept Sketch (above centerline)

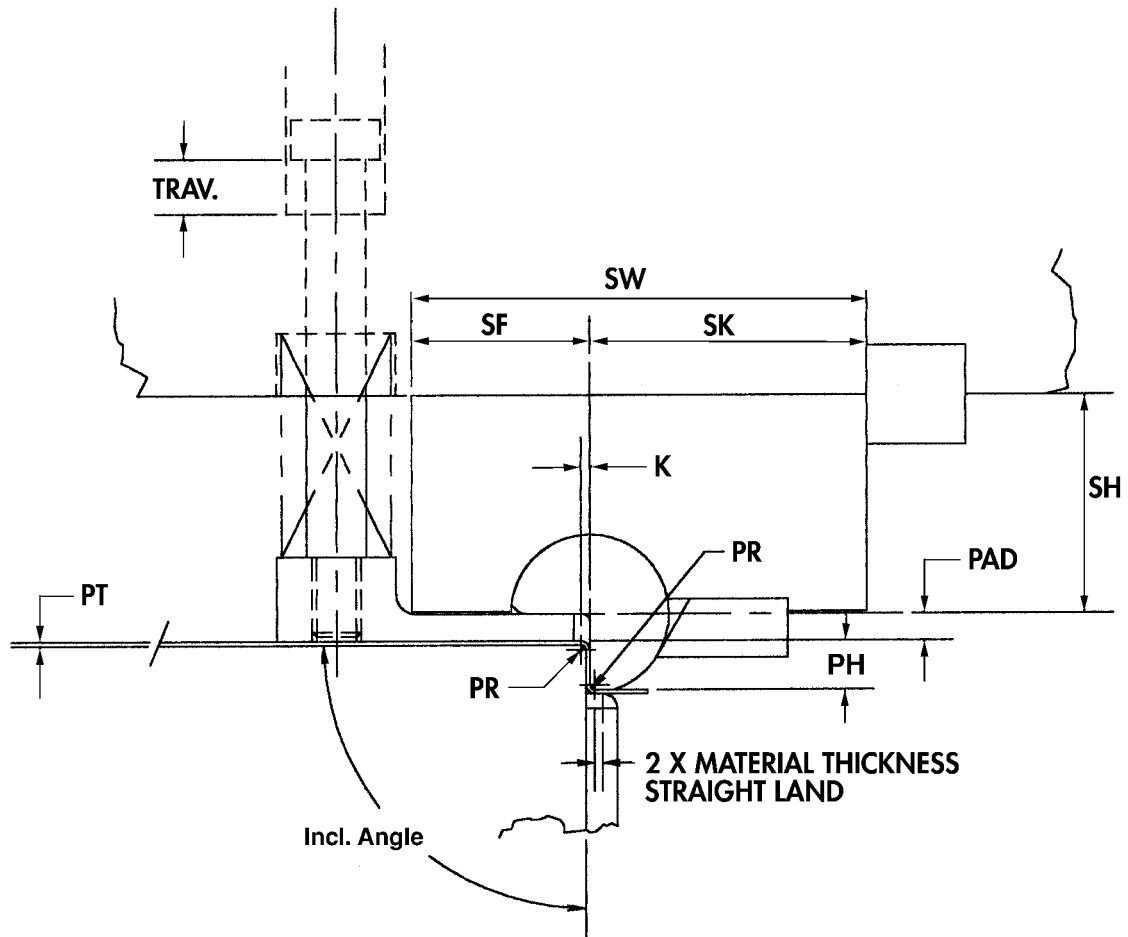


A READY Bender[®] CB4 (above centerline) includes angles over 105° will be above centerline.

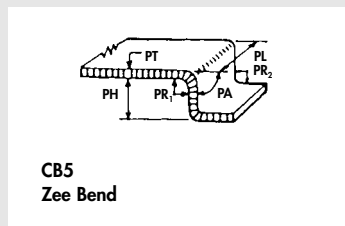


- CB = Classified Bend #
- PT = Part Material Thickness
- PL = Part Length (bent leg)
- PA = Part Angle (degrees of bend)
- PH = Part Height (bent leg)
- PR = Part Radius
- PC = Part Channel (inside)
- K = see catalog
- Incl. Angle = Included Angle

READY Bender[®] CB5 Concept Sketch

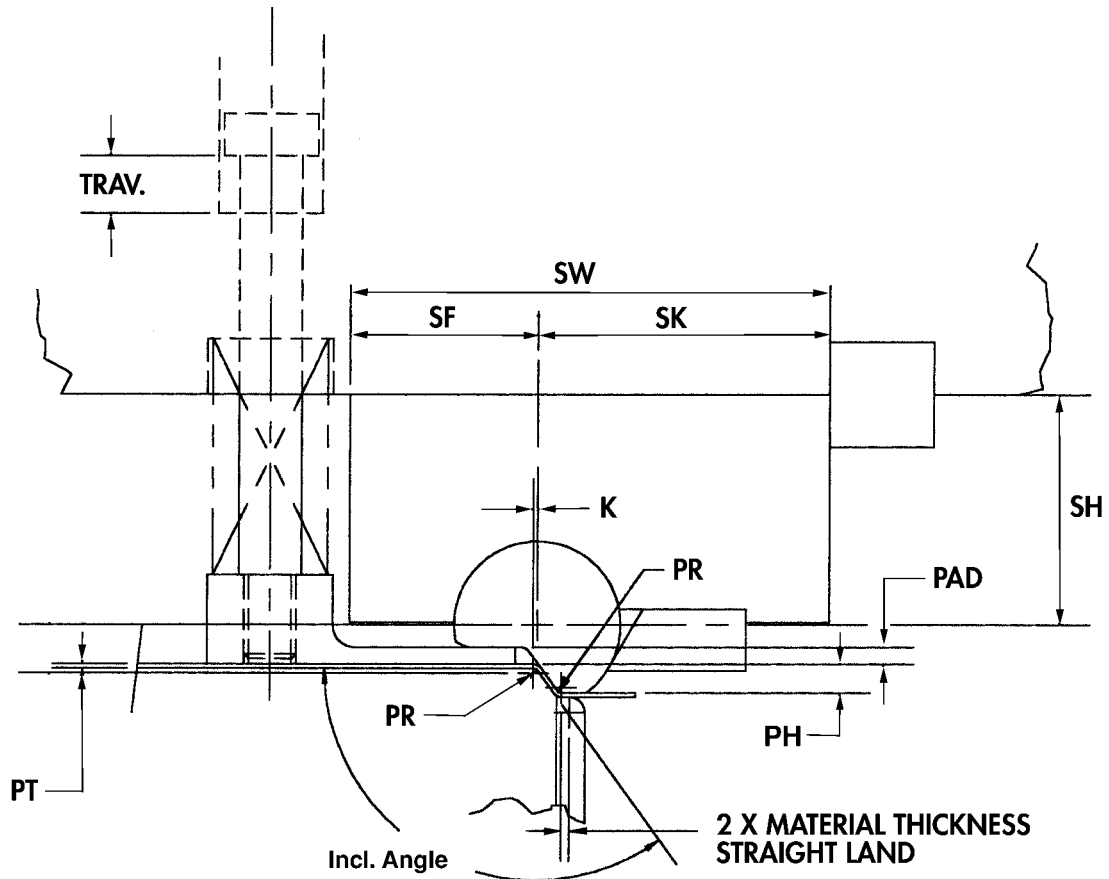


READY Bender[®] CB5 bends will most likely need to run off of a pad. This is to maintain rocker retention in the saddle.

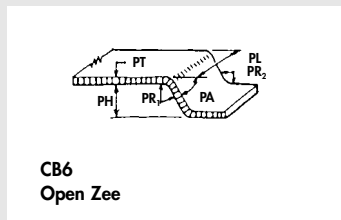


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- PT = Part Material Thickness
- PL = Part Length (bent leg)
- PA = Part Angle (degrees of bend)
- PH = Part Height (bent leg)
- PR = Part Radius
- PC = Part Channel (inside)
- K = see catalog
- Incl. Angle = Included Angle

READY Bender® CB6 Concept Sketch

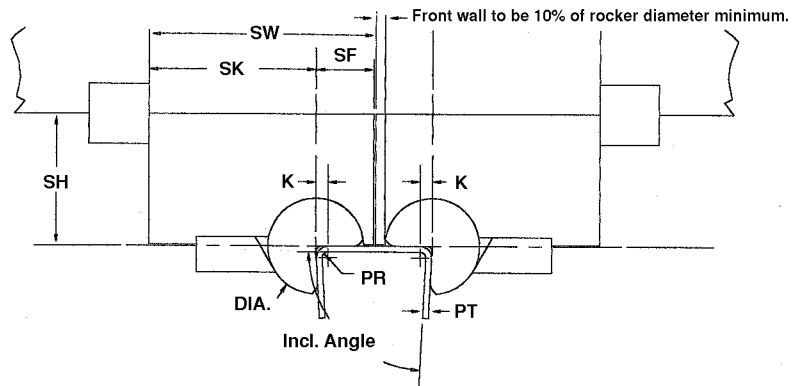


READY Bender® CB6 bends will most likely need to run off of a pad. This is to maintain rocker retention in the saddle.



- CB = Classified Bend #
- PT = Part Material Thickness
- PL = Part Length (bent leg)
- PA = Part Angle (degrees of bend)
- PH = Part Height (bent leg)
- PR = Part Radius
- PC = Part Channel (inside)
- K = see catalog
- Incl. Angle = Included Angle

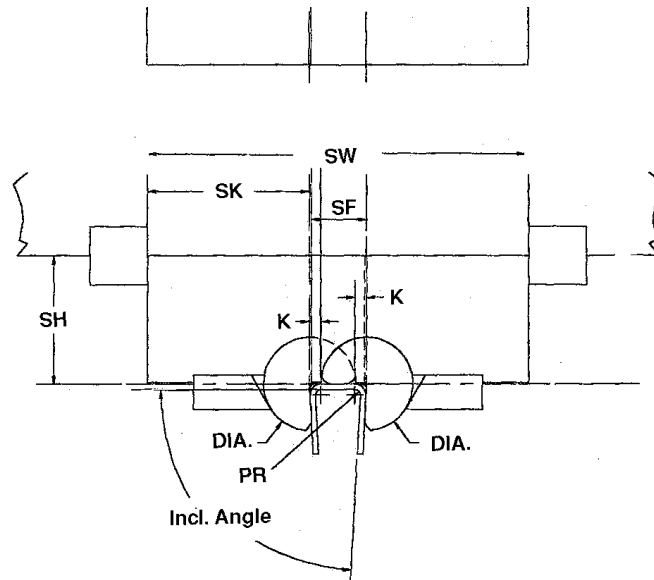
CB7 Concept Sketch (not interlaced)



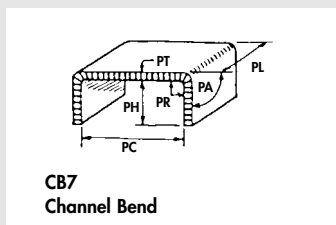
READY Bender® CB7 bends a channel where the front of the saddle must be smaller than standard.

READY Bender®

CB7 Concept Sketch (interlaced)

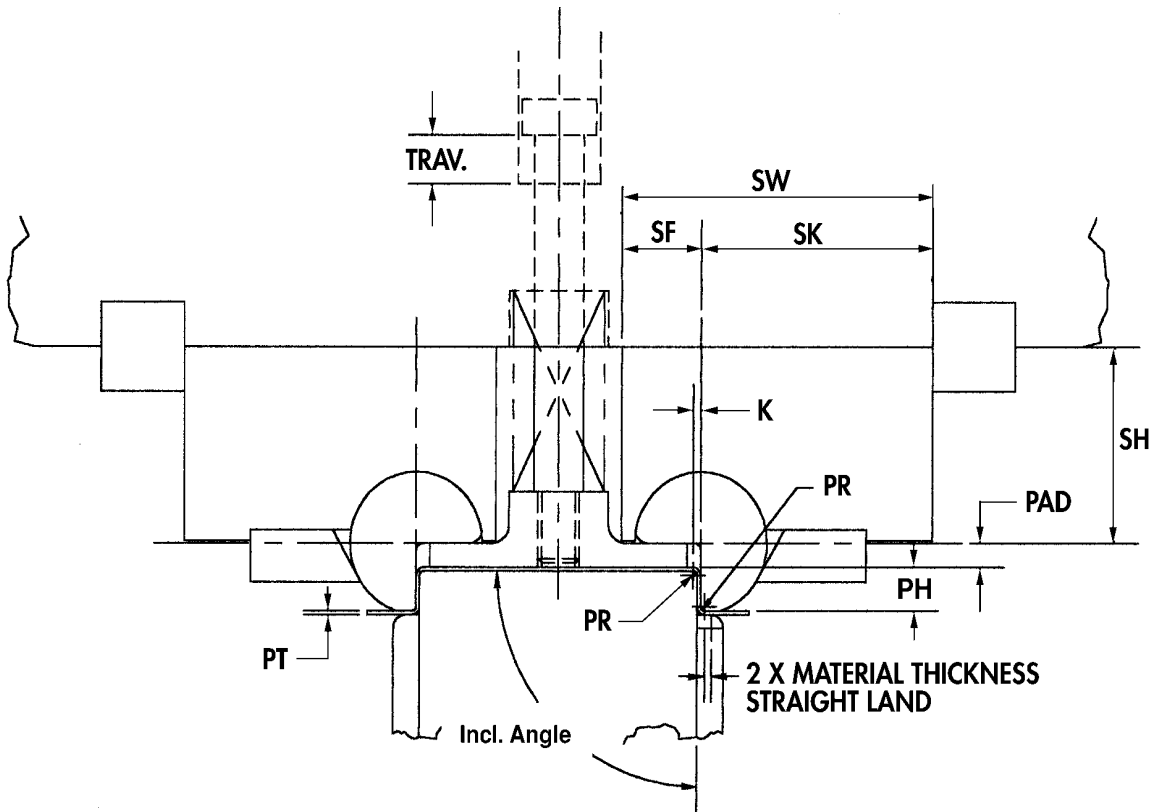


READY Bender® CB7 bends a channel where the front of the saddle must be smaller than standard. Tooling can also be interlaced.

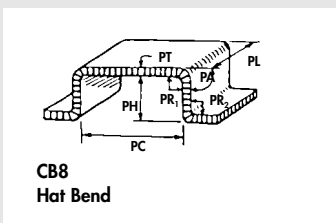


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 PH = Part Height (bent leg)
 PR = Part Radius
 PC = Part Channel (inside)
 K = see catalog
 Incl. Angle = Included Angle

READY Bender® CB8 Concept Sketch

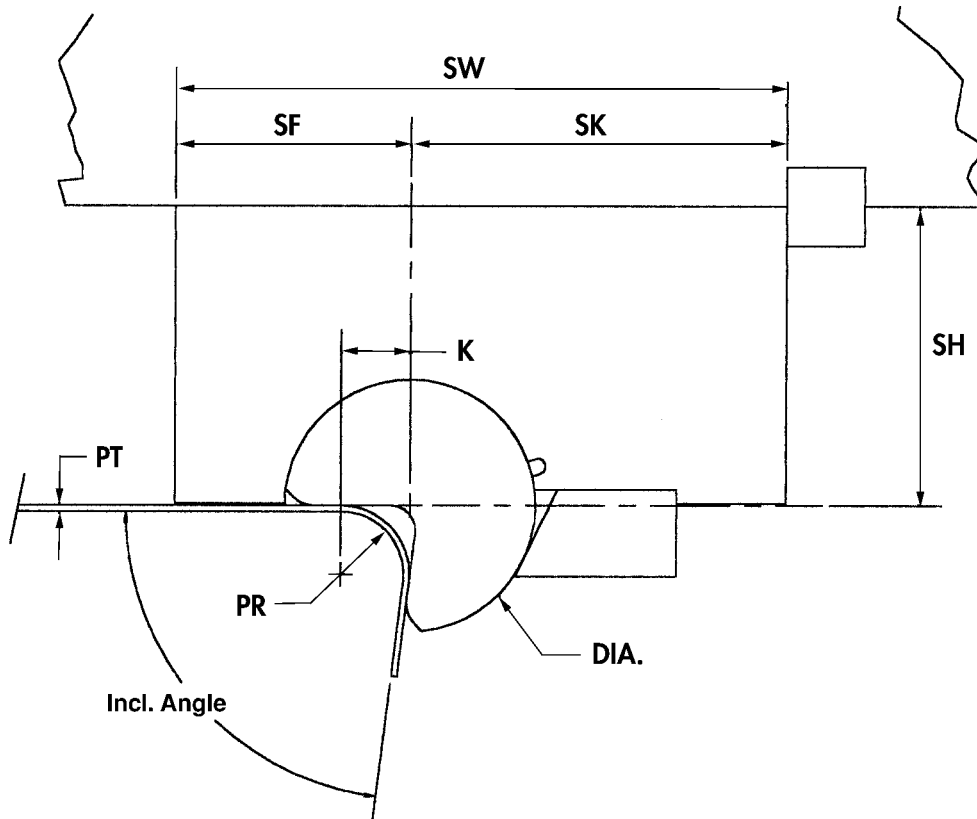


READY Bender® CB8 has two CB5 bends where the front of the saddle is shorter than standard. Note: CB8 bends will most likely need to run off of a pad. This is to maintain rocker retention in the saddle. CB8 benders can also be interlaced.

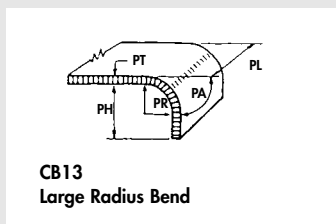


- CB = Classified Bend #
- PT = Part Material Thickness
- PL = Part Length (bent leg)
- PA = Part Angle (degrees of bend)
- PH = Part Height (bent leg)
- PR = Part Radius
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- K = see catalog
- Incl. Angle = Included Angle

READY Bender® CB13 Concept Sketch (large radius)



READY Bender® CB13 - the bend is a CB13 Large 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.



- CB = Classified Bend #
- PT = Part Material Thickness
- PL = Part Length (bent leg)
- PA = Part Angle (degrees of bend)
- PH = Part Height (bent leg)
- PR = Part Radius
- PC = Part Channel (inside)
- K = see catalog
- Incl. Angle = Included Angle

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

Fax: 937-866-7226 - send part prints

Quote Reference #

Date

Distributor

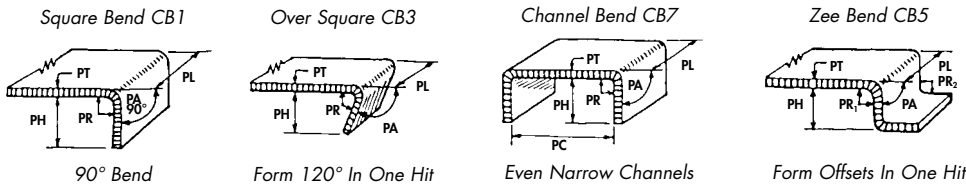
1 Company: _____
 Contact Name: _____ Title: _____
 Address: _____
 City, State, Zip: _____
 Telephone: _____ Fax: _____
 Other Contacts: _____

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:



Annual production _____

Type of material formed _____

Tensile strength _____

CB = Classified Bend # _____

PT = Part Material Thickness _____

PL = Part Length (bent leg) _____

PA = Part Angle (degrees of bend) _____

PH = Part Height (bent leg) _____

PR = Part Radius _____

PC = Part Channel (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 Hard Inch Bender
- READY-2000
- The Hard Metric Bender
- READY-MET
- Compact Benders

Press Brake Tooling

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

READY TECHNOLOGY, INC.

333 Progress Rd. • Dayton, OH 45449 • 937-866-7200 • 800-0543-4355

Fax 937-866-7226

Classified Bends (CB)

