



## The Five Most Often Asked Questions About Operating READY Benders®.

1. **Question:** " My forms are inconsistent. What is wrong?"

**Answer:**

READY Benders® always produce a consistent bend, so if your parts are inconsistent, the benders in your die are set improperly. Check the setting instructions and reset the benders.

2. **Question:** "I am having trouble maintaining a 90-degree bend. The ends are over bent, and the center is under bent. What do I do?"

**Answer:**

First check to see if the benders are keyed. READY Benders® must be keyed especially on long bends. Dowels are locators and should not be used as staking devices. If they are keyed, then you may have to cut your bender into three pieces and actually move the center bender in towards the anvil to get a straight bend, one that is 90-degrees all along the bend.

3. **Question:** "I have a gouge on top of my bent part. Am I set too deep? "

**Answer:**

You may be, but you may have interference on the bent side or not enough over bend on the anvil. Remember the force of a READY Bender® is always equalized between the bending lobe of the rocker and the clamping lobe. Check your relief and be sure that the angle on the anvil is equal to or less than that in the rocker. If this is not the case, then check the material. You may have to increase the land area on the clamping lobe of the rocker.

4. **Question:** "Do you guarantee the bend on my part?"

**Answer:**

We do not and will not guarantee your part. We do not control your die makers, so we cannot guarantee your part. What we do guarantee is the ability of our READY Bender® to make a bend. We will assist you and your die makers if they have problems until your READY Benders® are performing properly. Please call for help.

5. **Question:** "The spread dimension on my channel is too big. How do we shrink the channel dimension?"

**Answer:**

Check to see if the anvil dimension is what you want. If it is, then you are either set too tight to the anvil, which should be obvious with two lines on the bent leg side, or you are set too loose, and you must tighten up the bender. If you are too tight, then loosen up the benders. If you are too loose, then tighten up the benders.

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