

Posi-Bend™ Special Request Quote Form

Date: _____

COMPANY INFORMATION

Company Name: _____
 Contact: _____ Title: _____
 Address: _____
 City: _____ State: _____ Zip: _____
 Phone: _____ Fax: _____
 E-mail Address: _____

APPLICATION INFORMATION

End use Method: Stamping Press Press Brake Preferred Product: Posi-Bend Accu-Bend

Order Quantity: _____ Material Type & Grade: _____

Material Tensile Strength: _____ Annual Production Volume: _____

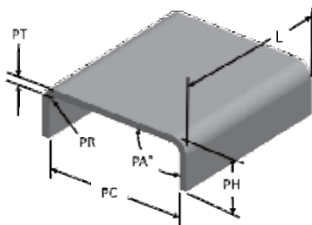
L = Length of Bend (bender length): _____ PT = Part Material Thickness: _____

PH = Part Height (bent leg): _____ PR = Part Radius (inside): _____

PC = Part Channel (inside): _____ PA = Part Angle (inside): _____

Over Bend required (30° max): _____ Check here if tool marks are not acceptable

Check here if you are interested in test bending this part No. of drawings attached: _____



Customer
comments: _____

TYPE OF BEND (check one)

Square

Under Square

Over Square

"Z" Bend

Channel

"Hat" Bend

Short Leg

"J" Bend
(requires two hits)

Note: For "Z", "Hat" or "J" bends, please specify top of part to top of flange dimension in notes

- 1 Press Brake application may require special mounting plate to secure the Benders
- 2 Annual production volume will be assumed as 250,000, if it is not specified.
- 3 If the over bend angle is not specified by the customer, we will make a recommendation. However, this recommendation is not a guarantee and we make no warranty in final forming of material. We can perform a variety of test bending. Please contact our customer service regarding our test bending service.
- 4 Due to material characteristics we recommend the part radius should be at least equal to material thickness. The final part radius is a result of anvil geometry and material behavior.

Phone: 317-255-5668

Fax: 317-253-4486

Posi-Bend™ Installation

Installation and Adjustment

1. Do not remove gibs
2. Locate set screws at the back of the saddle. Remove using standard hex key (Fig. 1).
3. Rotate rocker slightly in clockwise/counter-clockwise motion to displace and free rocker rotation.
4. Keep springs and bullets within the saddle.
5. Position one piece of application material on landing of anvil and rocker holding face (Fig. 2).
6. Position a second piece of application material between the tangent of anvil radii and bender face of rocker. (Fig. 2)
7. The anvil should contain 2-3° extra clearance beyond the spring-back application requirement (Fig. 2).
Example material used: SAE1008-1010.
Typical spring-back: 3°
Application: 90° bend required (87° rocker used)
Anvil angle should be 5-6°.
8. Using positioning and reinforcement key, locate and adjust to the proper position and secure with mounting fasteners.
9. When producing long length bends, split into segmentations for greater adjustment.
10. Lubricate bender with 10-15wt. oil.
11. Return springs and tighten hex set screws.
12. Rotate rocker to ensure a proper assembly, free of debris.

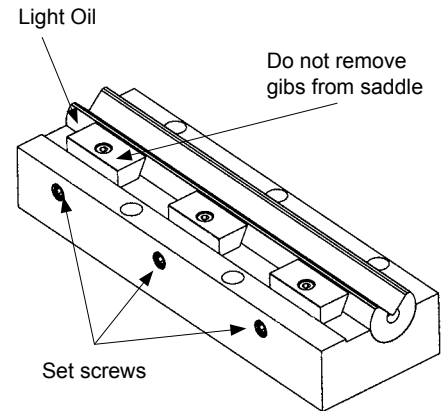


Figure 1

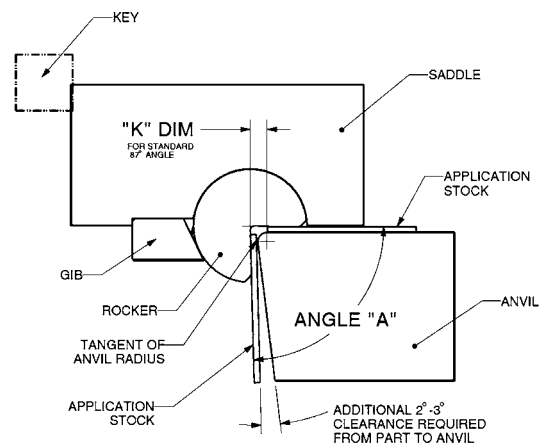


Figure 2

Preventative Maintenance

Remove and clean the saddle and rocker components within the first 50,000 cycles. Repeat the process every 100,000-200,000 cycles or as required. Increased cleaning may be necessary depending on your usage. Some materials (ex. galvanize) or excessively heavy oils may produce system degradation or may adversely affect rotation functionality.

During the cleaning process, apply a 10-15wt oil to ensure proper functionality.

Troubleshooting

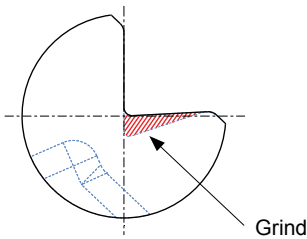


Figure 3

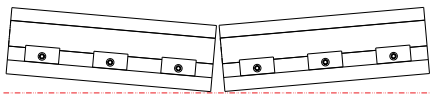


Figure 4

Toe in/out adjustment for long bend

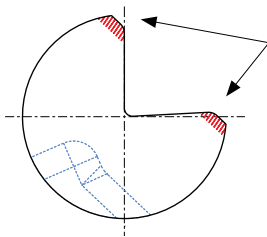
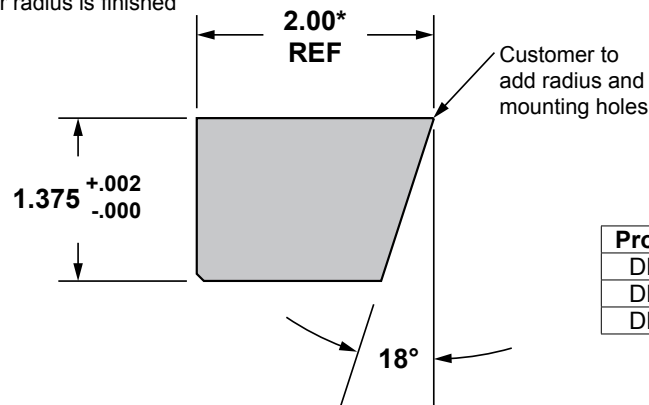


Figure 5

1. **Material under bend** – Bender set too far open or exceeds material thickness requirements. See setup instructions. Do not close the die set deeper.
2. **Material over bend** – Bender is set too tight or part radii is too small. See setup instructions. Do not coin.
3. **Material wrinkle near pinch point** – Anvil radii may be too small. Rocker diameter may be too large. Consult catalog and setup instructions.
4. **Excessive witness lines on material** – Bender is set too tight, application material yield strength is too high for rocker diameter, or there is insufficient clearance between anvil and rocker angle. Consult catalog and setup instructions.
5. **Coining or imprinting marks on part** – Bender is set excessively deep. See setup instructions. For additional over-bending, grind bending face slightly. See (Fig. 3).
6. **Bend on ends vs. center have tighter radii** – In long bend applications, the ends of material are less restrictive and forces are lower. Segmented benders in smaller lengths will provide increased adjustability. This is known as adjusting the toe-in or out. See (Fig. 4). See setup instructions.
7. **Rocker sticks during operation** – Debris or excessive buildup appears between rocker and saddle. Springs or bullets may need to be replaced. See preventative maintenance.
8. **Working with painted or sensitive surfaces** – If coining or imprint marks occur, polishing the material contact lobes (Fig. 5) will greatly reduce to eliminate any imperfections. See note #5 above for additional troubleshooting.

Additional Accessories – Bending Anvil

*Final length to be determined by customer after radius is finished



Product Code	Length
DLI-12-ANV	12.000
DLI-24-ANV	24.000
DLI-36-ANV	36.000

Commitment to Quality & Customer Satisfaction

Dayton Lamina is a leading manufacturer of tool, die and mold components for the metal-working and plastics industries. As a customer-focused, world-class supplier of choice, we provide the brands, product breadth, distribution network and technical support for all your metal forming needs.

Our goal is to give our customers the most innovative and value-added products and services.



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