

# 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.
13. Note: any time a screw is removed for service and reinstalled, please use removable Loctite® Threadlocker Blue 242.

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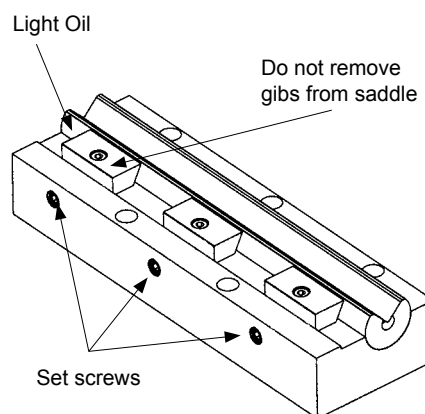


Figure 1

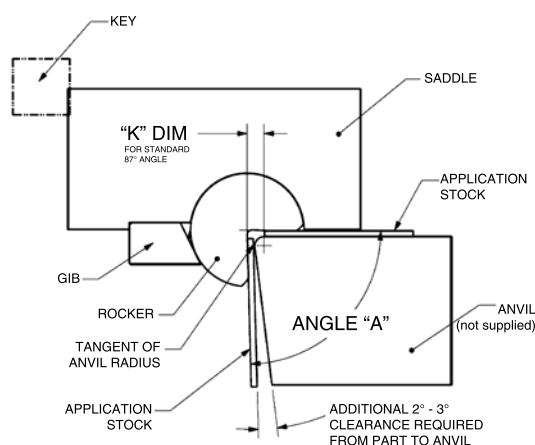


Figure 2

## 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.