

Troubleshooting

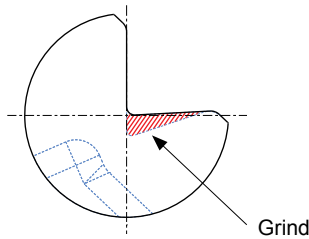


Figure 3

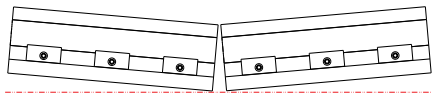


Figure 4

Toe in/out adjustment for long bend

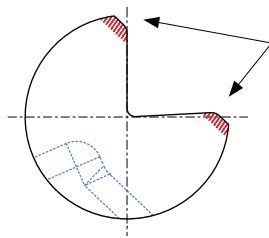


Figure 5

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.

Replacement Parts

Rocker Diameter	Kit Part Number*	Bullet Pin Part Number	Spring Part Number	Set Screw Part Number	Gib Part Number
5/8	DLI-62-KIT	DLI-62-PIN	LC-020-A-15-M	91375A532	DLI-62-GIB
1	DLI-100-KIT	DLI-100-PIN	LC-029B-18-M	94105A603	DLI-100-GIB
1-1/2	DLI-150-KIT	DLI-150-PIN	LC-035C-18-M	91375A662	DLI-150-GIB
2	DLI-200-KIT	DLI-200-PIN	LC-055E-19-M	91375A789	DLI-200-GIB
2-1/2	DLI-250-KIT	DLI-250-PIN	AA000000-0083	91375A789	DLI-250-GIB
3	DLI-300-KIT	DLI-300-PIN	AA000000-0084	91375A789	DLI-300-GIB

*Kits include bullet pins, springs, and set screws. Gibs sold separately.