

# LI'L BENDER

**Only 1.5 times thicker than material thickness can be bent.**

What used to be considered almost impossible - to bend short length ( One and a half times of the material) - can now be easily done with a press brake.

When bending other material with various thickness, you can easily do it by inserting a shim that is as thick as the material you want to bend.

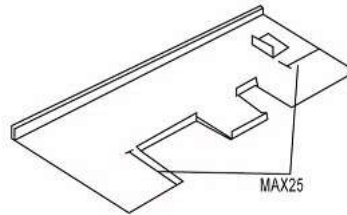
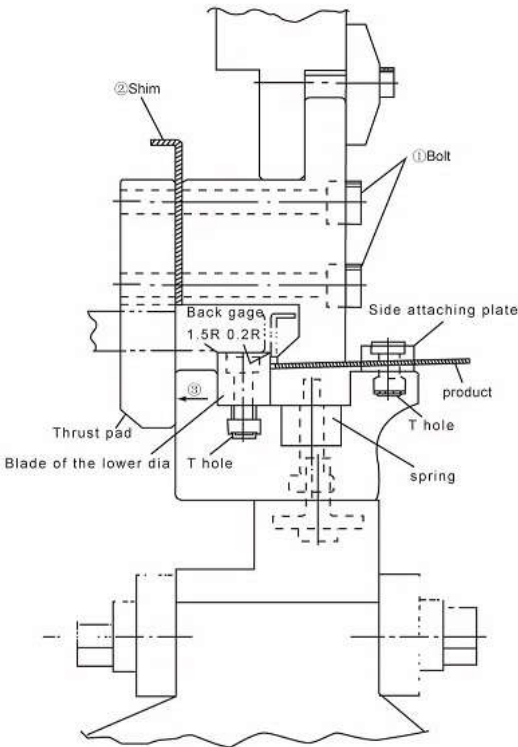
First, adjust the clearance of upper and lower dies according to the thickness of the material to be bent.

- Loosen the bolts①, and replace the shim② with one that is the same thickness as the material to be bent.
- After changing the shim, press the lower die against the thrust pad and tighten.
- With this, the clearance between the upper and the lower dies are set, and ready for operation.

The combination of the sectionalized blades will enable you to make partial bendings of any dimensions you like.

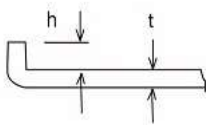
L835	15	20	25	30	40	50	100	135	415	835
S415	15	20	25	30	40	50	100	135	415	

There are T holes in both, the blade of lower die and the thrust pad. The blades of the lower die and the thrust pad can be moved freely.



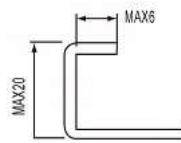
The corners of the blades of lower die are reversible; therefore, both sides of blades can be used. The R of one side is smaller, while the other is larger in order to reduce abrasion to material.

In addition to the short lengths bending, the bending like the below drawing can be done.



$$0.2R \quad h = t \times 1.5 \text{ min.}$$

$$1.5R \quad h = 2 + (t \times 1.5) \text{ min.}$$



## BENDING FORCE

Thickness mm	Tonnage t
0.6	10
0.8	12
1.0	15
1.2	19
1.6	25

## ② The Dimensions of Shim

