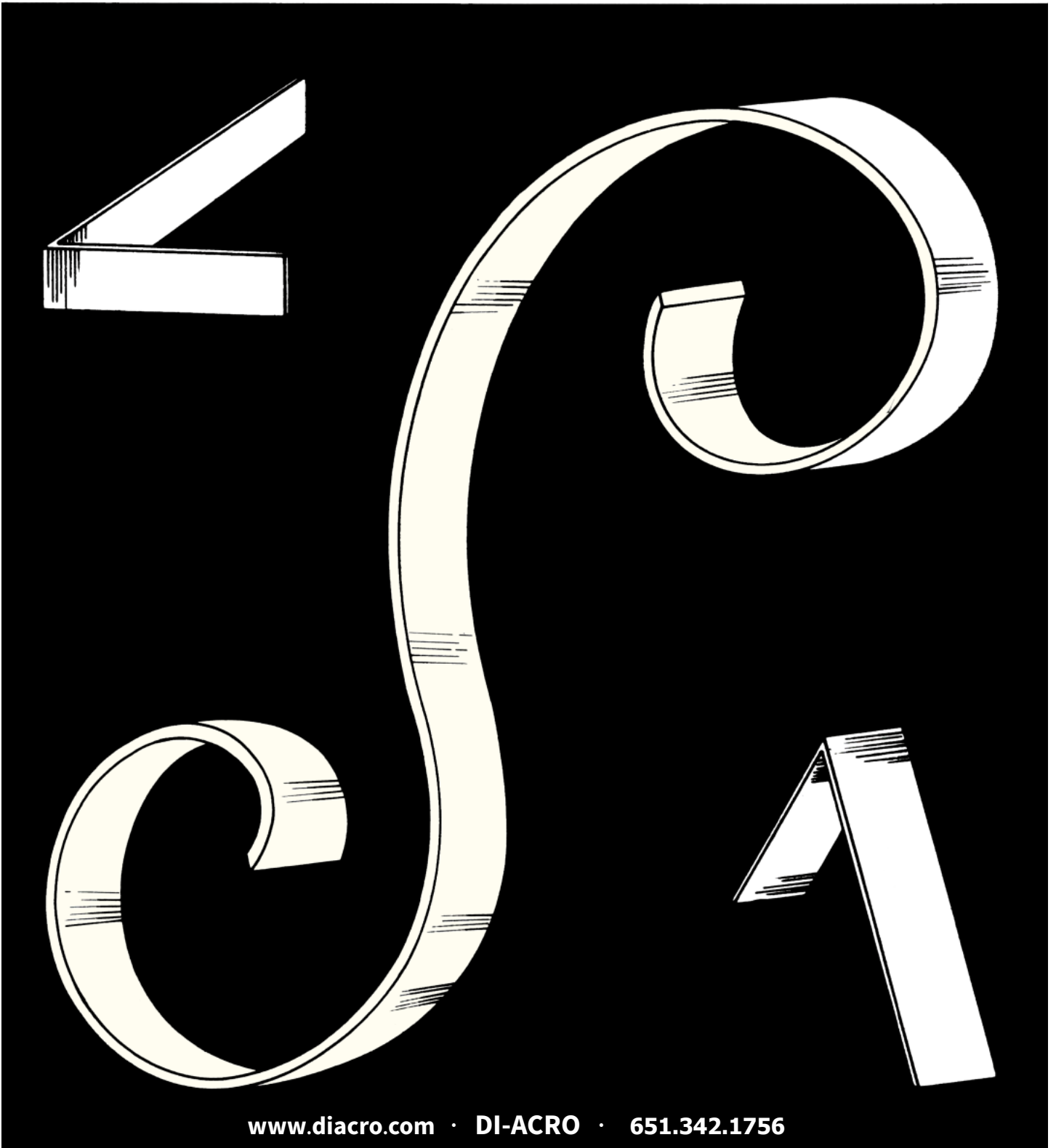
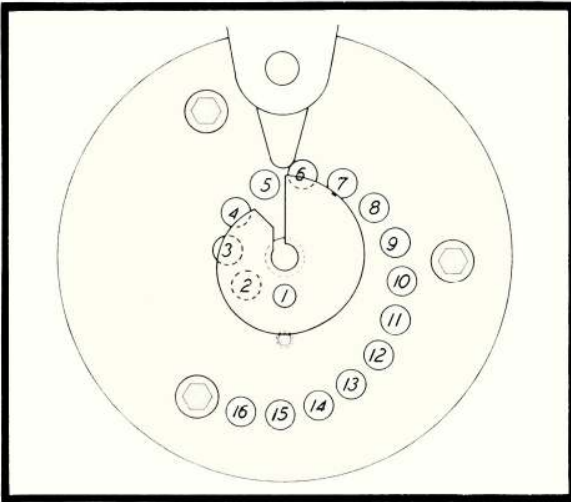


INSTRUCTIONS

Scroll Collar and Zero Radius Block

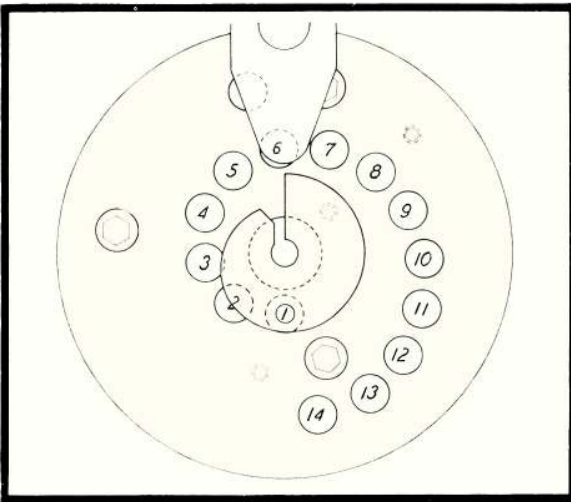


SCROLL COLLAR SET-UP INSTRUCTIONS



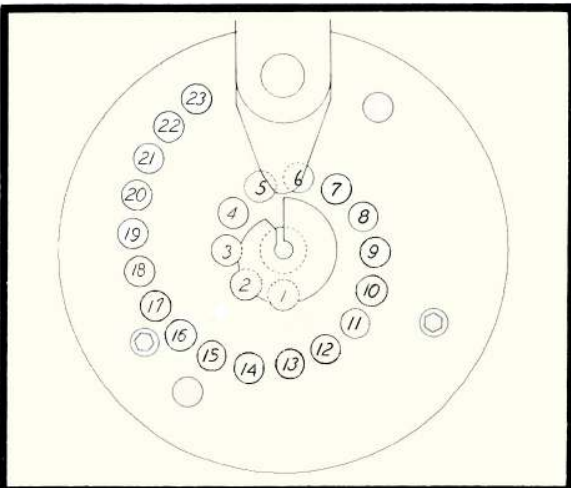
DI-ACRO #1A BENDER

Position the center hole of the scroll in the center on the mounting plate and pin in place using center pin. Line up the scroll collar so that the holding pin can be dropped into hole No. 1. Scroll collar does not have to be bolted to the mounting plate even when forming material of maximum capacity as these two pins firmly hold it in place.



DI-ACRO #2 BENDER

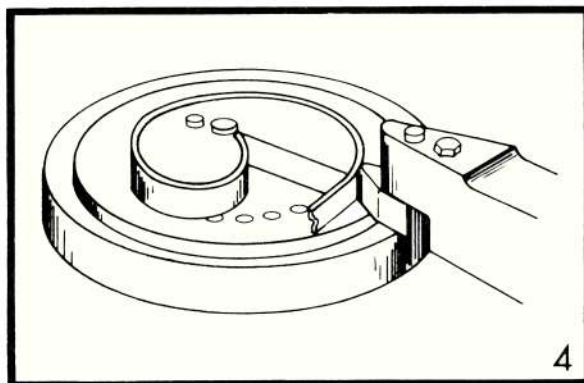
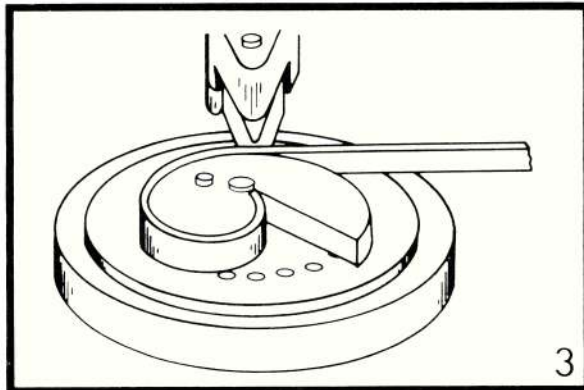
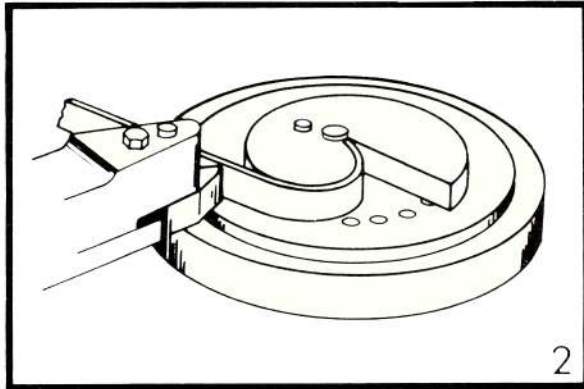
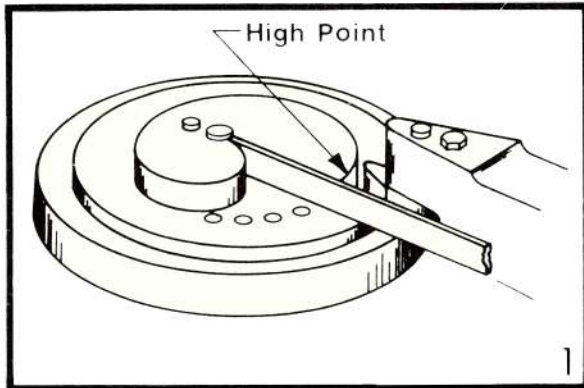
Position the center hole of the scroll in the center on the mounting plate and pin in place using center pin. Line up the scroll collar so that the holding pin can be dropped into hole No. 1. Scroll collar does not have to be bolted to the mounting plate even when forming material of maximum capacity as these two pins firmly hold it in place.



DI-ACRO #3 BENDER

Position the center hole of the scroll in the center on the mounting plate and pin in place using center pin. Line up the scroll collar so that the holding pin can be dropped into hole No. 1. Scroll collar does not have to be bolted to the mounting plate even when forming material of maximum capacity as these two pins firmly hold it in place.

SCROLL COLLAR OPERATING INSTRUCTIONS



SCROLL BENDING

Scrolls and other shapes or irregular radii can be readily formed with Di-Acro Benders in rigid materials even though the Forming Nose of the Bender revolves in a perfect circle.

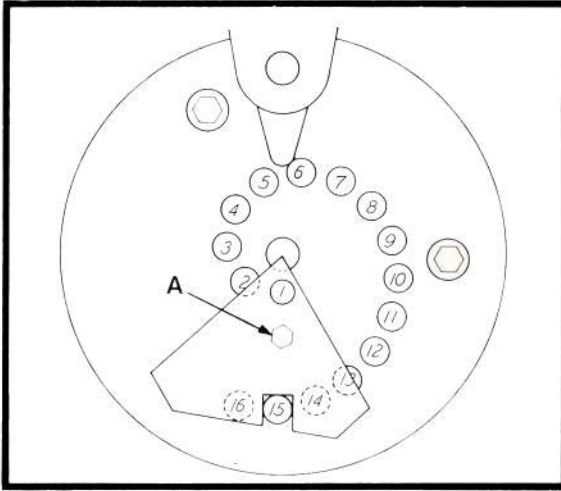
This type of forming is accomplished by using a collar having the same contour as the shape to be formed, as illustrated, and adjusting the Forming Nose so it is located only the material thickness away from the 'high point' of the collar.

As the material will only bend where this contour collar offers resistance, the Forming Nose can lead the material around until it contacts the 'high point' and exerts sufficient pressure to force it into the shape of the collar.

INSTRUCTIONS FOR IRREGULAR SHAPES

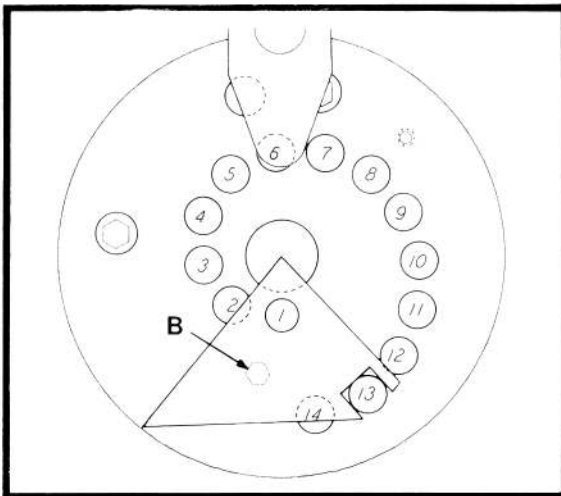
1. Adjust Forming Nose so the material will fit snugly between Nose and 'high point' of contour collar, then insert material as shown.
2. Advance the Operating Arm with a steady even pressure. Note how the material bends only where resistance is offered by the contour collar.
3. Material continues to bend and take shape of contour collar as the Operating Arm is advanced.
4. As the Forming Nose reaches the 'high point' of the contour collar, material is 'set' in the new shape.

ZERO RADIUS BLOCK SET-UP INSTRUCTIONS



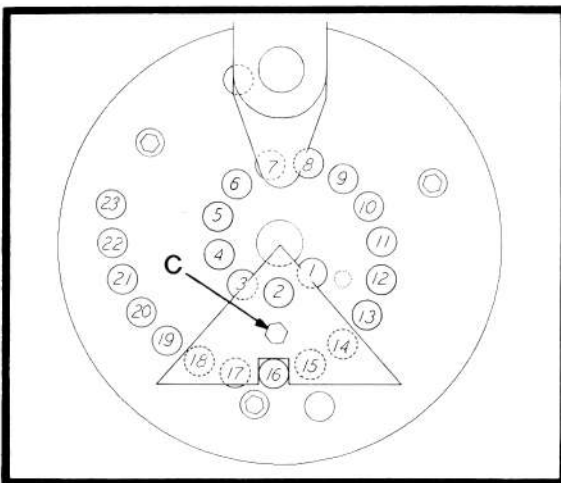
DI-ACRO #1A BENDER

Position the point of the Zero Radius Block in the center of the mounting plate and line ups the block so that the Holding Pins can be dropped in holes 1 and 15. Bolt 'A' locks the conversion to the mounting plate and is usually only used when maximum capacity material is being formed.



DI-ACRO #2 BENDER

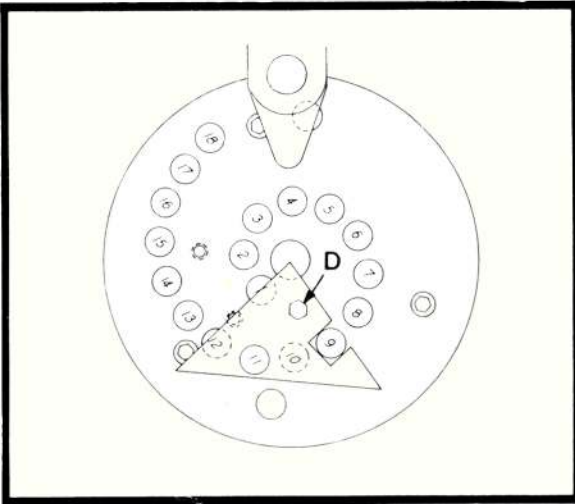
Position the point of the Zero Radius Block in the center of the mounting plate and line ups the block so that the Holding Pins can be dropped in holes 1 and 13. Bolt 'B' locks the conversion to the mounting plate and is usually only used when maximum capacity material is being formed.



DI-ACRO #3 BENDER

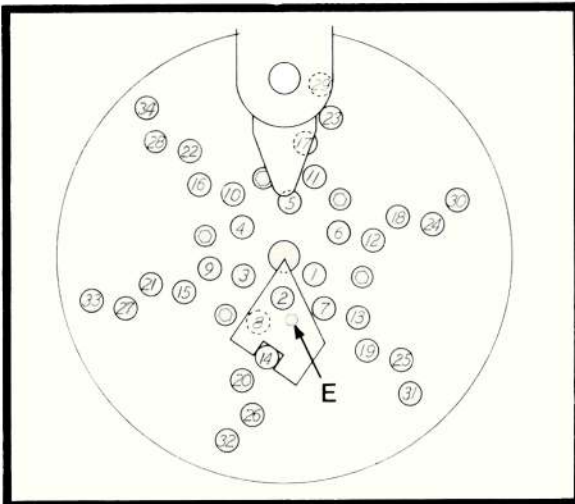
Position the point of the Zero Radius Block in the center of the mounting plate and line ups the block so that the Holding Pins can be dropped in holes 2 and 16. Bolt 'C' locks the conversion to the mounting plate and is usually only used when maximum capacity material is being formed.

ZERO RADIUS BLOCK SET-UP INSTRUCTIONS



DI-ACRO #4 BENDER

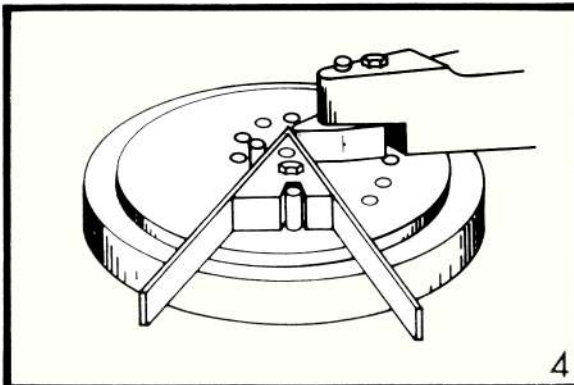
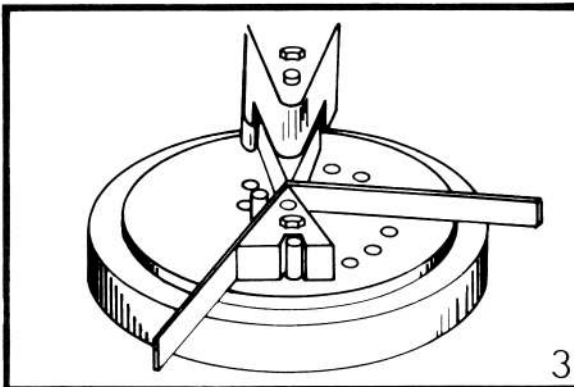
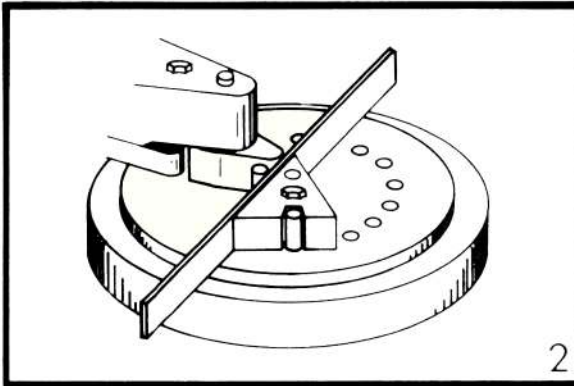
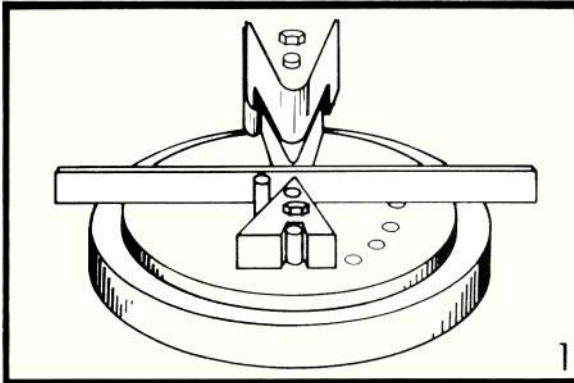
Position the point of the Zero Radius Block in the center of the mounting plate and line ups the block so that the Holding Pins can be dropped in holes 9 and 11. Bolt 'D' locks the conversion to the mounting plate and is usually only used when maximum capacity material is being formed.



DI-ACRO #8 BENDER

Position the point of the Zero Radius Block in the center of the mounting plate and line ups the block so that the Holding Pins can be dropped in holes 2 and 14. Bolt 'E' locks the conversion to the mounting plate and is usually only used when maximum capacity material is being formed.

ZERO RADIUS BLOCK OPERATING INSTRUCTIONS



RADIUS BLOCK BENDING

A sharp zero radius bend can be easily formed with Di-Acro Benders by using a Zero Radius Block similar to the one illustrated. Although the sketches show the forming of strip stock, the operation can be performed equally as well in round, square, and other solid, ductile materials.

When forming heavy materials to a zero radius, their ductile limits must be taken into consideration and it is often desirable to provide a small radius on the bending edge of the block to avoid fracture or marking on the inside of the bend.

By using a Built-up Forming Nose and mounting two or more Zero Radius Blocks on each other, the forming width capacity of all Di-Acro Benders can be increased considerably on this type of operation.

BLOCK SET-UP INSTRUCTIONS

1. Adjust Forming Nose so the material will fit snugly between Nose and apex of the Zero Radius Block.
2. Clamp material close to bending edge using Locking Pin or Holding Block.
3. Advance the Operating Arm with a steady even pressure until it strikes the Angle Gauge, thereby establishing exact degree of bend.
4. Bend is now completed and additional parts can be exactly duplicated by repeating these steps.