Calibration

Die Name: The die name is the name that will be assigned to the die. This name will be used to refer to this specific die everywhere in the software.

Die Angle: The die angle is the angle of the material profile that wraps around the outside edge of the die.

Die Size CLR: The die size CLR is the centerline radius of the die. This value may be stamped on the die or the die is listed by this value.

Achieved CLR: The achieved CLR is the centerline radius of the die that compensates for any spring back. This value is usually slightly larger than the die size CLR.

Calibrated CLR: The Calibrated CLR is the used in the software to determine the amount of stretch or growth in the bending process for that material and die.

Bend Location Offset: The Bend Location Offset (BLO) is the distance added to the bend locations to offset the difference between the line-up mark on the die or bender to the true start of bend.



The best way to calibrate a new die when adding it to the die library is to use the Die Calibration Worksheet. This can be found in the die library under Calibration help.

The calibration worksheet menu can be accessed by clicking the Worksheet button in the die library.

Die Calibration W	lorksheet			-			points - A
Bend-Tech (Calibration	n: JD2 - Mode	13				
Select the Model of y	our Bender:	1					
JD2 - Model 3		$< \square$					
Instructions		-					
1. Cut a piece o enough to creat	f material and te a 90 degree	measure it AFTER y part. We recommen	ou cut. This is t d a length 5 tir	he 'CUT LENGT mes the Die CLR	H [°] . Make sure the p	siece is long	
2. Mark the tube bends with this	e a few inches Die. This is the	from one end. This r MARK LOCATION	mark will be lin	ed up in the ben	der as your referen	ce line for all futu	-
3. Line up the m degrees. You m	nark and bend way need to ove	to 90 degrees. You i in-bend to compensi	need to have a ste for spring-b	part that, when f ack.	Inished, is within 1	degree of 90	Leg 1
4. Measure the from the top of t	height of both the leg down to	legs. It may be easie the table (outside d	et to set one la (mensions).	ig on a table and	I the other leg straig	pht up: measure	
Fill in the follow material. Leg 1	ing values from	n the steps above. U I the leg that has the	ee decimals fo mark on it.	r all values. The	OD is the Outside D	Nameter of the	Leg 2d
Enter Values						Results	
Dia CLD	00	Callenath	Les 1	1	Mark Location		Centerline Radius (CLR): 0
Die GLA		Con Lenger	Legi	Ley z	Mark Location	27	Calibrated CLR: 0
	0		0		0	Y	Bend Location Offset 0
Warnings							
1. Set your Dim This can be fou	ension Locatio Ind on the Settin	n to: START [this is t ga tab or you may chan	he system defi ge your global op	sult), stons under the To	ols menu: Select Optio	ons then the Single	Part tab.
2. Direction to p during bending	lace the tube i	nto the Die: The tail	of stock of mat	erial that has not	been bent stays sta	ationary during be	ending: it does not swing across the shop
3. Note that the	CLR you are g	oing to use in the so	Aware is usual	ly 4 percent large	er than your stamps	ed die CLR size.	-
4. Your Calibrat	ed CLR should	I be 5 to 20 percent	larger than you	CLR.			45
				[Common P		and here and the	
				Calevation D	ecument P	The Pelloutions	Cancer Submit

In the Die Calibration Worksheet window, pick your bender or a bender that is similar to the one you are using from the drop down menu at the top of the window. If you cannot find your bender or a bender similar to your bender, just select the 'Any Rotary Draw', 'Any Rotary Compression' or 'Any Center Compression' option from this list.

Once a bender option has been chosen, follow the instructions very carefully (Click the Print Instructions button to get a print out of the steps). Accurately measure and write down the cut length BEFORE bending the test piece! These steps require you to bend a test piece of material to 90 degrees. To see a visual representation of any of the instructions place your cursor over the step. When you have each of these steps completed, enter each of the necessary values. After all these values have been entered, the results will be generated to the right under Results. Click the Submit button to apply these results to the current die.