828 4th Street
Elk River, MN 55330
Phone (763) 441-1581
Fax (763) 441-1596

Double Bender Operation

ERMC Double Benders were developed in response to the growing precast box culvert market. The standard bender is designed to bend Welded Wire Reinforcing without obstructions in the bending deck through D21 on 2" spacing or D32 on 4" spacing. The radius of the bend is the responsibility of the user, however 2" bending radii will generally conform to the bending specs for precast box culverts (ASTM C-1433). Units are available in 8', 10', and 12' versions.

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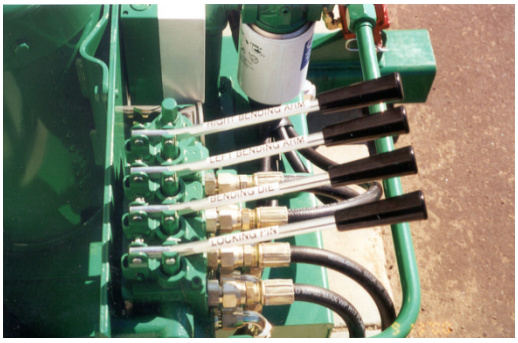
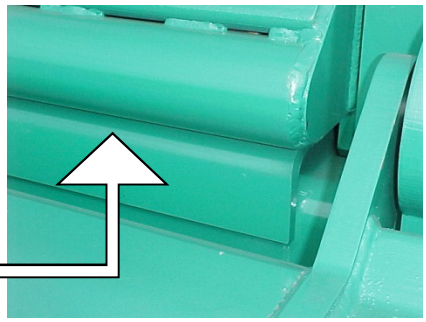
ERMC double benders will bend mesh regardless of spacing. The welded wire reinforcing may be fed from either side with no obstructions in the bending deck, and can be bent on a skew as well as straight. Double benders are available with an internal clear space of 102", 126", and150".

The bending mandrel is safely locked in place by the manually controlled hydraulic locking cylinder. The mandrel is positioned automatically and correctly for each bend.



ERMC double benders are built with manual hydraulic controls as standard. The operator is in complete command of the machine.



Mesh is secured firmly between the deck and bending mandrel for consistent, accurate bending with virtually no slippage regardless of mesh size.
ERMC Double Benders are capable of bending W21 on 2" centers (D32 on 4" centers) to a resting 90-degrees

Upgrades include the remote electrical hands-free operation with foot pedal controls as shown

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ERMC Double Benders may be loaded from either side

To make the first bend, the *Welded Wire Reinforcing* mat is placed in position for bending. After securing the mesh between the deck and mandrel, the bending arm is raised and *over-bends* the sheet to form a resting bend of 90-degrees.

To accomplish the second bend, simply move the mesh mat forward (There is no need to raise the mandrel) on the unobstructed bending deck, to the second position. The same method for bending is repeated with the exception that the bend is from the opposite bending arm. After the arm is retracted, the cage will have a **"U"** configuration.

The cage is extracted from the bender by simply raising the mandrel to the full 90-degree position. The arm will completely clear the bending deck for easy removal of the cage.