



828 4th Street
Elk River, MN 55330
Phone (763) 441-1581
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Frequently Asked Questions:

What is the largest bender you construct?

ERMC has been asked to construct single direction benders up to 30 feet in length. Prior to construction, the customer will furnish the maximum wire diameter, minimum spacing, and minimum bending radius required. The general rule of thumb regarding radius is four times the diameter of the largest wire. Ultimately, however, the responsibility of proper bending radii rests with the user. We have built single direction benders capable of bending D21 on 2" spacing for 30 feet. Double benders are available in lengths of 8', 10' or 12 feet, with a final resting bend of 90- degrees up to D21 on 2" spacing

Can I use the bender outdoors?

ERMC benders are built to be used outdoors. Obviously we recommend the units be operated indoors. To withstand severe cold ERMC offers tank heaters as optional equipment.

How is the bender powered?

ERMC will require the customer to furnish the voltage and frequency prior to construction. The unit is electrically powered with hydraulic operation. Single direction benders are available with gasoline powered generators for use in remote locations.

What is the largest angle I can bend ?

Double benders bend a maximum of 90 degrees; single direction bender maximum is 180-degrees. The units are constructed to over- bend the mesh. As the mesh returns to the resting position the operator will determine the correct amount of over-bending to employ. The bending operation may be automated with optional PLC controls for consistent bending limits.

ERMC has developed the *convertible* single direction bender. With only a slight change-over effort, the single direction 90 degree bender can be converted to 180 degree capability. Minimum mesh lead remains at 6" for 90 degree bends and approximately 14" lead for a full 180 degree operation. Convertible bender widths remain virtually unlimited with 8' minimum.



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Frequently Asked Questions (continued):

What size mesh can I bend?

ERMC standard *double benders* will handle up to D32 (5/8") on 4" centers or D 21 (1/2") on 2" centers. ERMC standard single direction benders are designed and built to bend D12.0 (3/8") on 2" centers for the entire length of the machine. Heavy-Duty models will bend the full range of mesh diameters through D32 on 4" spacing or D21 on 2" centers for the entire length of the bender.

Upgrades are available for either 90 degree or 180 degree models, however, the geometry and construction of the bender will require review by the ERMC engineering department to confirm upgrade suitability.

Bending anvils are supplied with 3/4" radius on 4' spacing with each single direction bender. At the time of order the customer may specify anvils through 2.5" radius with no increase in pricing. Larger radii anvils are available by request.

Can I bend rebar?

ERMC benders are designed and built for cold drawn wire and WWR (welded wire reinforcing). The responsibility for conformance to any and all bending specifications rests solely with the purchaser. The double bender has been developed in response to the popularity of precast box culverts. Likewise, the single direction benders have been designed and built in response to the increased use of WWR in precast and cast-in-place construction. We expect the benders to be used in any application where the purchaser / user sees an advantage in using preformed mesh.

Further questions?

Please call ERMC at 763.441.1581