INSTRUCTIONS FOR USING THE BT-1 BENDING TOOL

IMPORTANT: DO NOT BEND THE TRACK COMPLETELY AROUND THE BENDING TOOL SHOE. THE RADIUS OF THE SHOE IS 7" AND THE MINIMUM RADIUS FOR THE TRACK IS 24". THE TRACK MUST BE ADVANCED AS IT IS BENT ON THE TOOL.

(READ ALL OF THE FOLLOWING INSTRUCTIONS PRIOR TO CURVING THE TRACK)

1. A full scale chalk drawing of the curved portion of the track must be drawn on the floor or work bench in order to check the curving operation's progress. The radius of this full scale drawing can be drawn using a wooden plank or string with a length equal to the radius of the required curve. Be sure to allow at least 1' of straight track at each end of the curve to assure correct alignment.

2. Use a marker, or wax pencil to mark the location of the center of the <u>curve</u> on the top flange of the track.

3. Place marks on the top of the track in both directions out from the center line mark in 3" increments or a distance of 1.5 times the radius of the curve.

4. Slide the track into the bender and line up the FIRST mark of either end of the marked section with the apex of the bender's shoe.

5. Pull back SLIGHTLY on the bending tool's lever pipe. This should put a SLIGHT bend in the track, usually around 5 degrees.

6. Move the track forward or backward in the bender and align the second mark on the track with the apex of the bender's shoe. Pull back SLIGHTLY on the bending tool's lever pipe.

7. Continue this process until all the marks have a slight bend.

8. Check the track radius against the chalk drawing by laying it on top of the chalk line.

9. In most cases the formed radius will be too large, which is desirable. Repeat steps 4 through 8 until the required curve is formed.

11. If the radius becomes too tight during this process you can remove some of the curve by placing the apex of the curve against a wall, securing one end of the track, and pushing the other end toward the wall. Keep in mind that this is for SLIGHT adjustments only. ***<u>The key to bending the track correctly is to bend in small multiple steps</u>***, checking the radius against the chalk line while you do it, avoiding curving the track too tightly.