

INSTRUCTIONS FOR USING THE BT-2 BENDING TOOL

IMPORTANT NOTE: 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 curving progress. The radius of this full scale drawing can be drawn using chalk attached to 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 alignment of the track.
2. Use a marker or wax pencil to mark the location of the center of the curve 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. Secure the BT-2 tool to the floor, or work bench making sure that ample room exists to walk the track around the tool.
5. Slide the track into the bender and line up the FIRST mark of either end of the marked section with the apex of the tool's shoe.
6. Pull SLIGHTLY on the longest section of track coming out of the shoe. This should put a SLIGHT bend in the track, usually around 5 degrees.
7. Move the track forward or backward in the bender and align the second mark on the track with the apex of the tool's shoe. Pull SLIGHTLY on the longest section of track coming out of the shoe
8. Continue this process, repeating steps 6 and 7 until a slight bend exists at each mark unless the track is beginning to curve more that the drawn template. If this occurs the individual bends are too severe for the overall bend required and must be straightened.
9. Check the track radius against the chalk drawing by laying it on top of the chalk line.
10. In most cases the formed radius will be too large, which is desirable. Repeat steps 5 through 9 until the required curve is formed.
11. If the radius becomes too tight during this process you can remove some of the curve. **The key to bending the track correctly is to bend in small multiple steps**, checking the radius against the chalk line while you do it, avoiding curving the track too tightly.

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