Calibrating your FleXform™ Tool

The FleXform™ tool provides an excellent way to easily create consistent bends in our FleXmount™ bracket/arm series. Although the tool comes ready to use, to ensure that the bends are reproduceable, it is necessary to calibrate the tool from time to time as the tool wears in the dies. This will ensure that rotating the dial to a given position will create a specific bend angle as provided in the chart.

How to set the calibration wheel:

1. Loosen the Dial setscrew from the vise grip knob so that the dial turns freely on the setscrew.
2. Back the Dial off (counterclockwise when looking at the end of the knob) completely to the back end of the Vise Grip knob.
3. Back out the Vise Grip knob (counterclockwise) so that when the vise grip is closed there is an air gap between the die anvil and the saddle.
4. Using any FleXmount™ bracket/arm, place it in the FleXform Jaws ensuring that the bracket/arm is aligned with the center of the bend mark.
5. Turn the Vise Grip knob in (clockwise) until the tool holds the FleXmount™ bracket/arm firmly.
6. Open the jaws slightly and turn the knob in 1/4 turn.
7. Close the jaws slowly while watching the FleXmount™ bracket/arm for bending
8. Repeat the last three steps so that when the jaws close, the FleXform™ bracket/arm bends very little (less than 2 degrees).
9. With the handle of the vise grip pointed down, turn in the dial (clockwise) until the Dial bottoms out against the Vise Grip handle. Do not rotate the knob, only the dial.
10. Make a note of the Dial number that is closest to straight up on the Vise Grip.
11. Now rotate the dial out (counterclockwise) without turning the Vise Grip knob exactly three complete turns.
12. Tighten the dial setscrew.
13. Congratulations! The Dial is now set so that clamping in this position will not bend the FleXmount™ bracket/arm and by rotating the Dial (and Vise Grip Knob) in (clockwise) three full turns will bend the FleXmount™ bracket/arm approximately 100 degrees.
14. Note that all rotations found on the bending table are based rotations of the dial from a 0 position. If your dial mark was something other than 0, simply add this value to the chart.

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