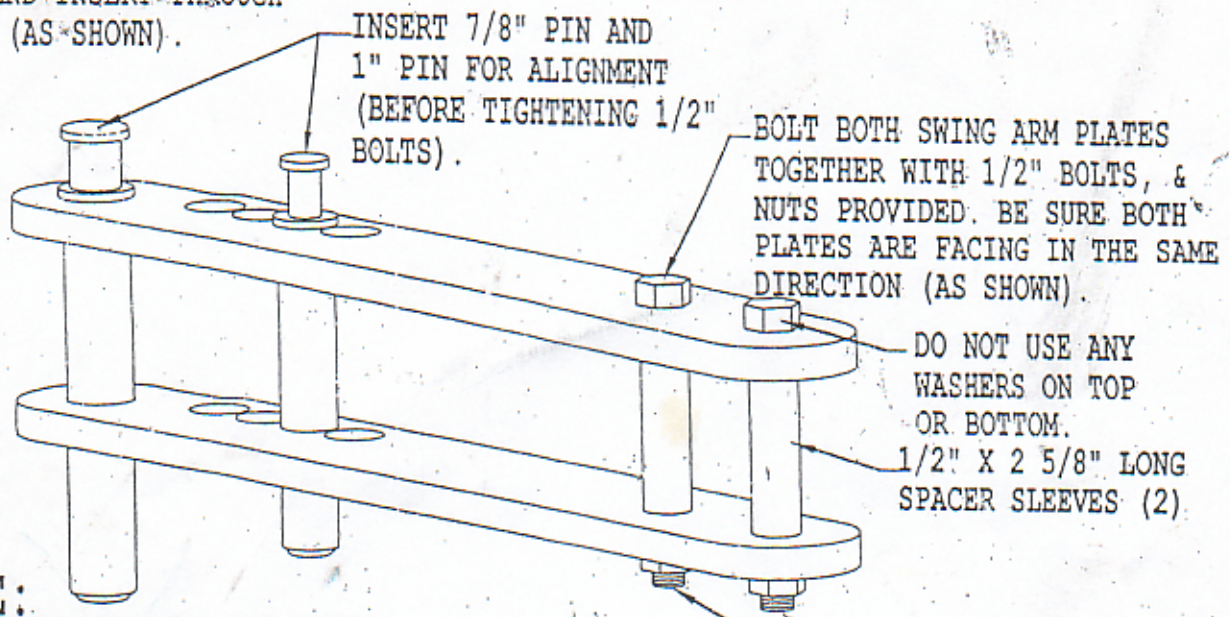


ASSEMBLY INSTRUCTIONS

REMOVE 1" PIN FROM FRAME ASSEMBLY AND INSERT THROUGH END HOLES (AS SHOWN).



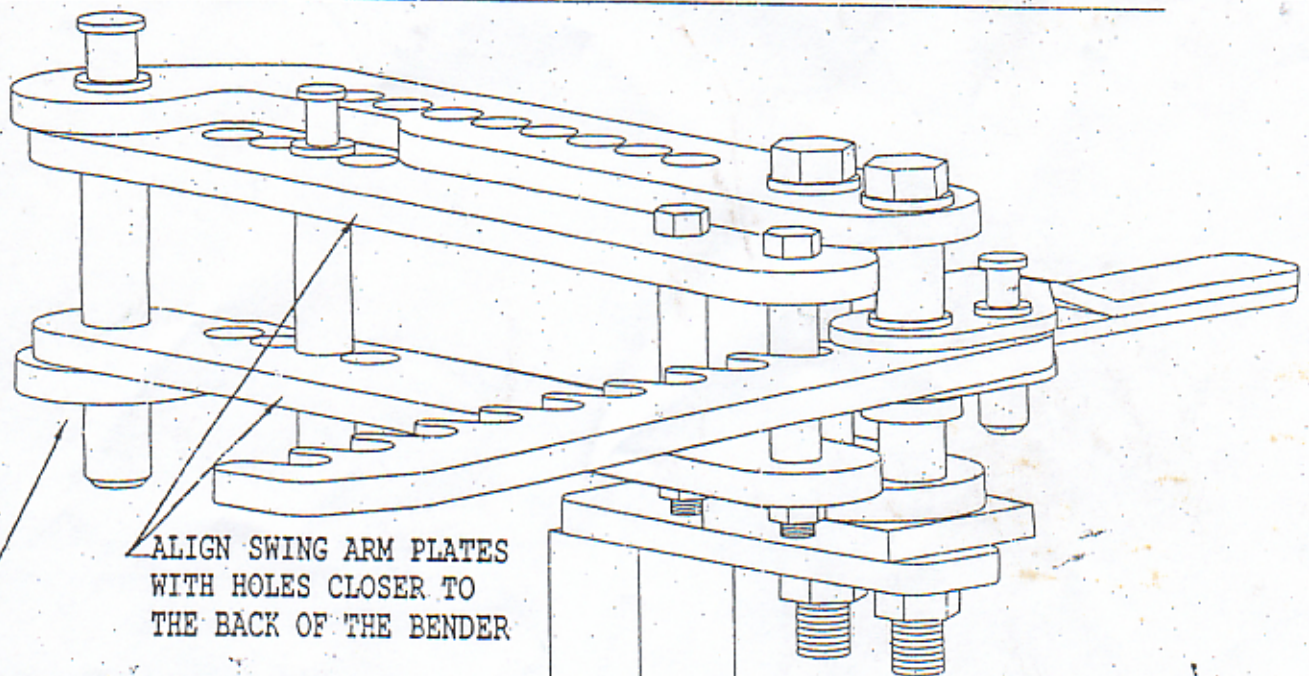
INSERT 7/8" PIN AND 1" PIN FOR ALIGNMENT (BEFORE TIGHTENING 1/2" BOLTS).

BOLT BOTH SWING ARM PLATES TOGETHER WITH 1/2" BOLTS, & NUTS PROVIDED. BE SURE BOTH PLATES ARE FACING IN THE SAME DIRECTION (AS SHOWN).

DO NOT USE ANY WASHERS ON TOP OR BOTTOM.
1/2" X 2 5/8" LONG SPACER SLEEVES (2)

NOTE:
PLATES MUST BE ALIGNED PROPERLY SO THAT PINS CAN SLIDE OUT FREELY.

1/2" BOLTS MUST BE TIGHT TO PREVENT PLATES FROM MOVING.



ALIGN SWING ARM PLATES WITH HOLES CLOSER TO THE BACK OF THE BENDER

ALIGN HOLES IN SWING ARM WITH HOLES IN FRAME, THEN SLIDE PIN THROUGH HOLES. BE SURE TO POSITION SWING ARM WITH THE DRIVE PIN HOLES TOWARD THE INSIDE (AS SHOWN)

ASSEMBLY INSTRUCTIONS

A. MAIN DIE INSTALLATION

REMOVE 1" PIN, LUBRICATE PIN AND DIE SLEEVE, PLACE DIE IN BENDER FRAME THEN SIDE PIN THROUGH FRAME AND DIE SLEEVE (AS SHOWN BELOW).

INSERT PIN THROUGH SWING ARM & FIRST HOLE OF MAIN DIE.

DIE SLEEVE

B. TUBE & BACKING BLOCK INSTALLATION

1. BENDER SWING ARMS MUST BE CLOSED AGAINST BENDER FRAME BEFORE INSTALLING TUBE & BACKING BLOCK.
2. INSERT TUBE INTO RADIUS OF MAIN DIE.

TUBE

BLOCK

3. PUSH BACKING BLOCK AS TIGHTLY AS POSSIBLE AGAINST TUBE, THEN INSERT PIN THROUGH BENDER FRAME & BLOCK.

C. STRAP & PIN INSTALLATION

PIN

STRAP

TUBE

PUSH FIRMLY ON THIS END OF TUBE, PLACE STRAP AROUND TUBE, LINE UP HOLES, THEN INSERT PIN THROUGH STRAP & DIE TAB.

BENDING INSTRUCTIONS

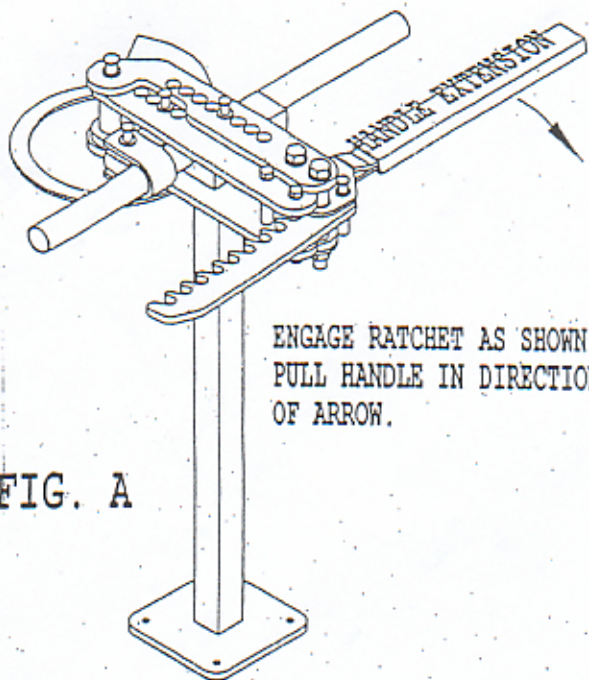
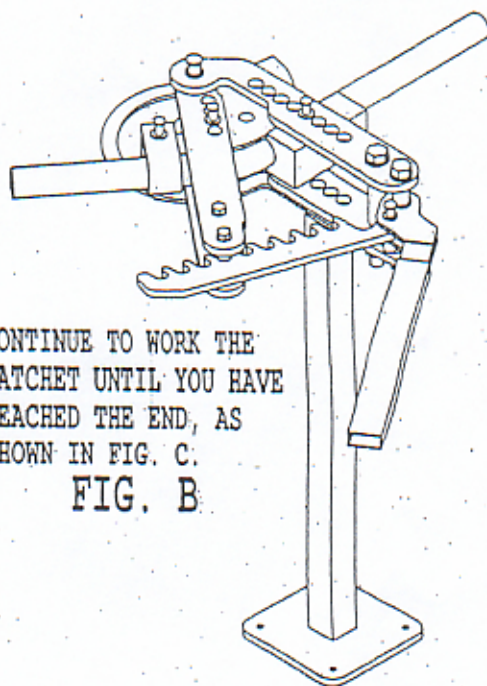


FIG. A

ENGAGE RATCHET AS SHOWN.
PULL HANDLE IN DIRECTION
OF ARROW.



CONTINUE TO WORK THE
RATCHET UNTIL YOU HAVE
REACHED THE END, AS
SHOWN IN FIG. C.

FIG. B

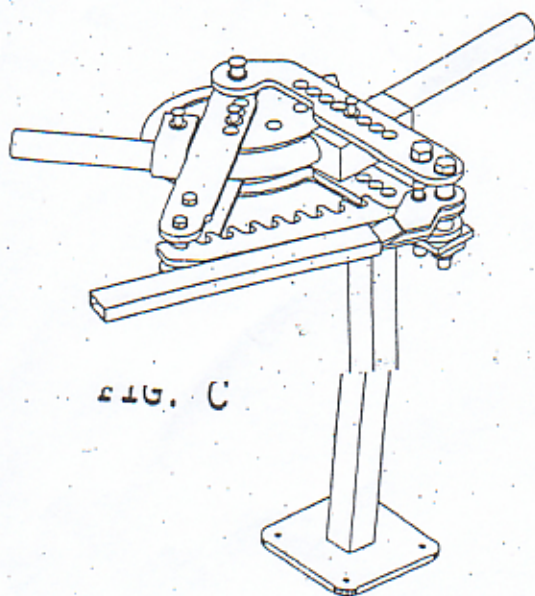


FIG. C

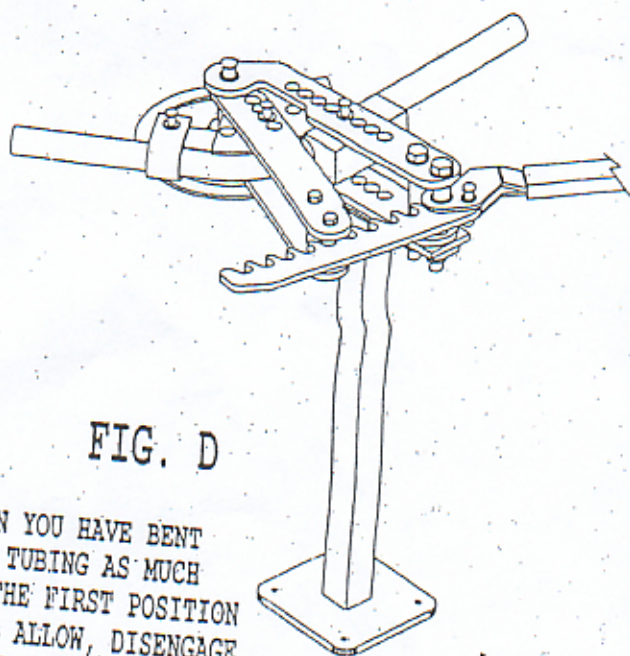
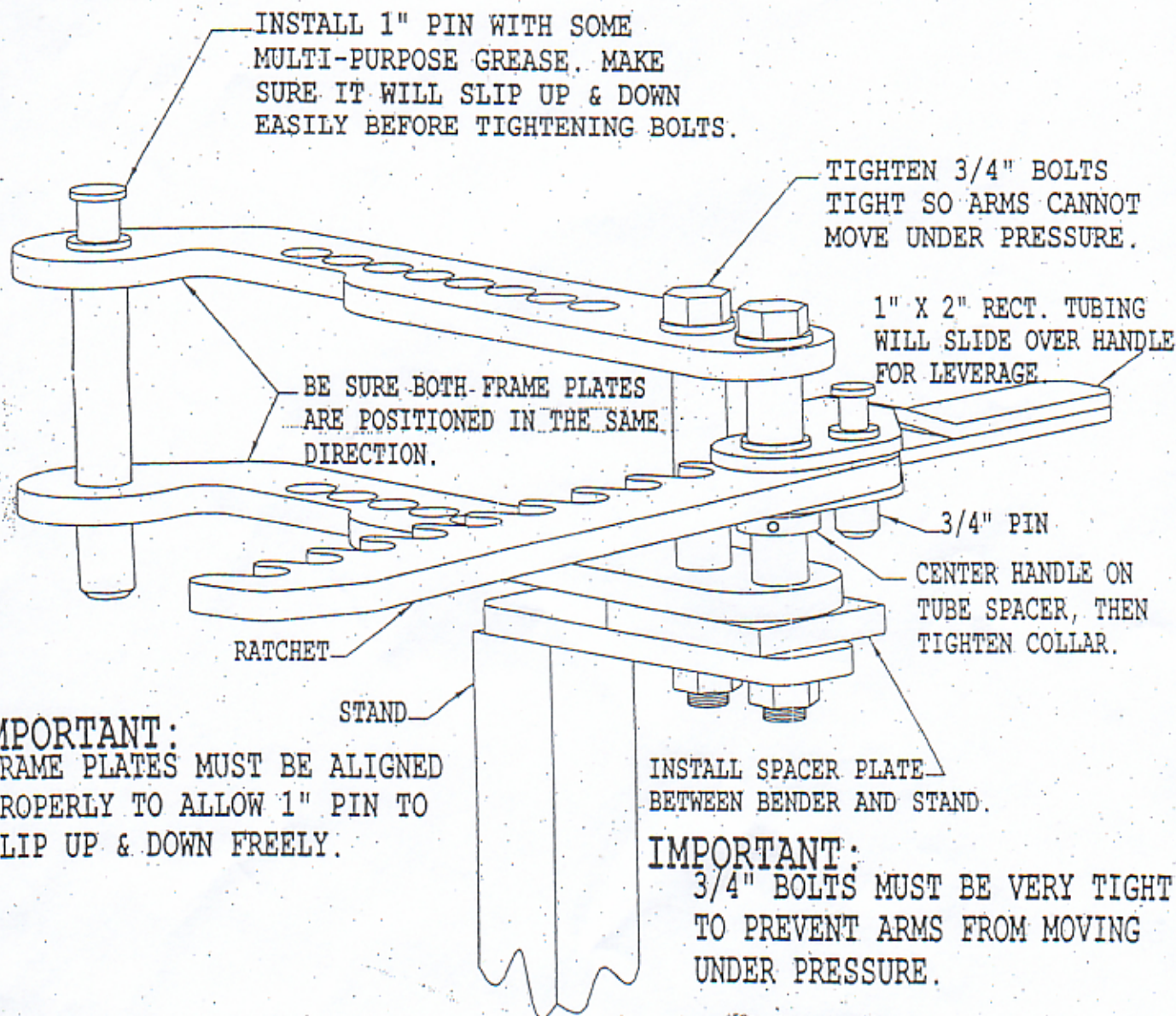


FIG. D

WHEN YOU HAVE BENT
THE TUBING AS MUCH
AS THE FIRST POSITION
WILL ALLOW, DISENGAGE
THE RATCHET & REMOVE THE
7/8" DRIVE PIN. ROTATE THE SWING ARM COUNTER-
CLOCKWISE UNTIL THE DRIVE PIN CAN BE REINSTALLED
THROUGH ANOTHER HOLE IN THE BENDING DIE. BE CARE-
FUL NOT TO MOVE THE TUBE. NOW REPEAT THE ABOVE
BENDING SEQUENCE UNTIL THE DESIRED DEGREE OF BEND
IS OBTAINED.

ASSEMBLY INSTRUCTIONS

IN THE FOLLOWING INSTRUCTIONS WE WILL TRY TO EXPLAIN THE ASSEMBLY OF THE BENDER. PLEASE READ EVERYTHING, BECAUSE SOME ITEMS ARE VERY IMPORTANT AND WILL SAVE YOU TIME LATER ON. THE BENDER IS DESIGNED TO BOLT TO A BENCH OR STAND. WE RECOMMEND INSTALLING IT ON A STAND. IT MAKES IT A GREAT DEAL EASIER TO WORK AROUND WITHOUT HAVING ANY OBSTACLES.



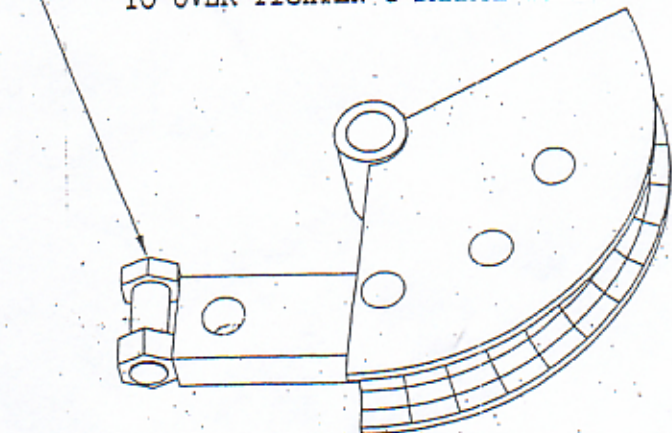
FRONT VIEW OF FRAME ASSEMBLY

THIS IS THE FIRST STEP OF ASSEMBLY. WHEN COMPLETED MAKE SURE THIS PORTION OF YOUR BENDER IS ASSEMBLED AS SHOWN IN THE ABOVE ILLUSTRATION.

IMPORTANT!

CHECK THESE ITEMS BEFORE STARTING BENDING.

TIGHTEN LOCKDOWN BOLT SO TUBE WILL NOT SLIP. BE CAREFUL NOT TO OVER-TIGHTEN & DAMAGE TUBE.



FOR A FRICTION-FREE BEND, ALWAYS LUBRICATE THE BACKING BLOCK. ALL PURPOSE WHEEL BEARING GREASE WORKS VERY WELL.

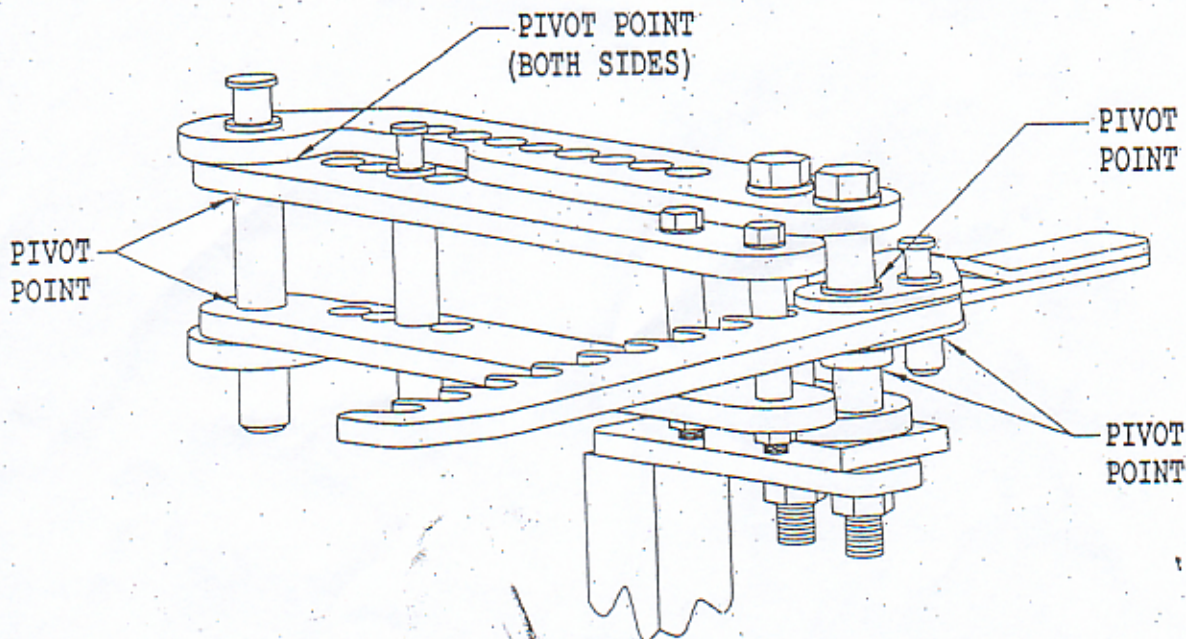


NOTE:

YOUR ~~BACKING~~ BLOCK HAS "TOP" STAMPED ON IT. THIS MUST ALWAYS FACE UP.

RADIUS OF MAIN DIE MUST BE CLEAN. ABSOLUTELY NO GREASE!

(BACKING BLOCKS WILL VARY IN SHAPE & DESIGN. THE BLOCK SHOWN ABOVE IS JUST ONE EXAMPLE.)



LUBRICATE ALL PIVOT POINTS TO PREVENT EXCESS WEAR AND TO INCREASE EASE OF BENDING.