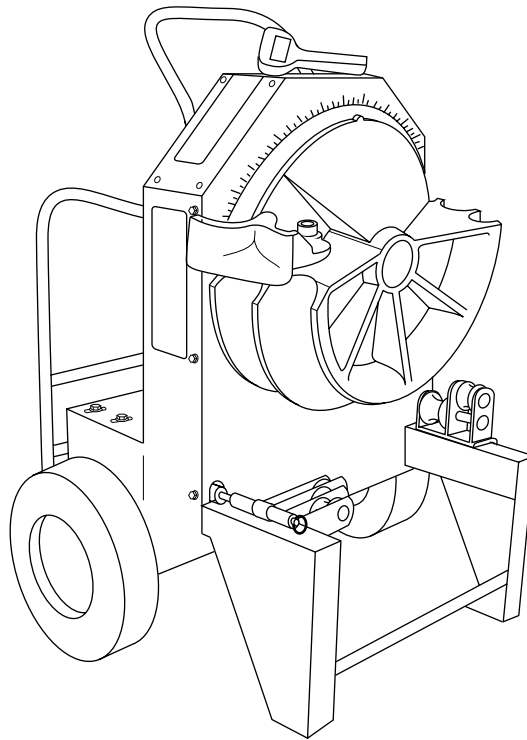


INSTRUCTION MANUAL



555C

Electric Bender Classic

Serial Codes AFB and ADE



Read and understand all of the instructions and safety information in this manual before operating or servicing this tool.

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Description

The Greenlee 555C Electric Bender Classic is intended to bend 1/2" to 2" conduit and pipe.

Bending shoe groups are available to accommodate the following types: Electrical Metallic Tubing, Intermediate Metallic Conduit, Rigid Conduit, PVC-Coated Rigid Conduit, and Schedule 40 Pipe. The shoe groups are shown in the Bending Attachment Groups section of this manual.

Safety

Safety is essential in the use and maintenance of Greenlee tools and equipment. This manual and any markings on the tool provide information for avoiding hazards and unsafe practices related to the use of this tool. Observe all of the safety information provided.

Purpose

This manual is intended to familiarize personnel with the safe operation and maintenance procedures for the following Greenlee tool:

555C Electric Bender Classic,
with Serial Codes AFB and ADE

Keep this manual available to all personnel.

Replacement manuals are available upon request at no charge at www.greenlee.com.

All specifications are nominal and may change as design improvements occur. Greenlee Textron Inc. shall not be liable for damages resulting from misapplication or misuse of its products.

Mobil is a registered trademark of Mobil Oil Corporation.

KEEP THIS MANUAL

IMPORTANT SAFETY INFORMATION



SAFETY ALERT SYMBOL

This symbol is used to call your attention to hazards or unsafe practices which could result in an injury or property damage. The signal word, defined below, indicates the severity of the hazard. The message after the signal word provides information for preventing or avoiding the hazard.

⚠ DANGER

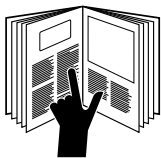
Immediate hazards which, if not avoided, **WILL** result in severe injury or death.

⚠ WARNING

Hazards which, if not avoided, **COULD** result in severe injury or death.

⚠ CAUTION

Hazards or unsafe practices which, if not avoided, **MAY** result in injury or property damage.



⚠ DANGER

Read and understand all of the instructions and safety information in this manual before operating or servicing this tool.

Failure to observe this warning will result in severe injury or death.



⚠ DANGER

Do not use this tool in a hazardous environment. Hazards include flammable liquids, gases, or other materials. Using this tool in a hazardous environment can result in a fire or explosion.

Failure to observe this warning will result in severe injury or death.



⚠ WARNING

Electric shock hazard:

- Connect the power cord to a 120 volt, 20 amp receptacle on a ground fault protected circuit only. See Grounding Instructions.
- Do not modify the power cord or plug.
- Inspect the power cord before use. Repair or replace the cord if damaged.
- Disconnect from power before servicing.

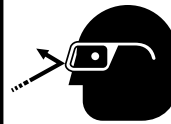
Failure to observe this warning could result in severe injury or death.



⚠ WARNING

- Do not expose to rain.
- Do not use in wet or damp locations.

Failure to observe these warnings could result in severe injury or death.



⚠ WARNING

Wear eye protection when operating or servicing this tool.

Failure to wear eye protection could result in serious eye injury from flying debris.




⚠ WARNING


Do not remove guards.

Failure to observe this warning could result in severe injury or death.


IMPORTANT SAFETY INFORMATION

	<p style="text-align: center;">⚠ WARNING</p> <p>Extension cords:</p> <ul style="list-style-type: none"> Use only three-wire, 12-gauge extension cords that have three-prong grounding-type plugs and three-hole receptacles that accept the tool's plug. Do not use extension cords that are longer than 30 m (100'). Repair or replace damaged extension cords. <p>Failure to observe these warnings could result in severe injury or death.</p>
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<p style="text-align: center;">⚠ WARNING</p> <p>Make sure that the handle is properly installed and secured with the safety spring clips and snap pins before lifting or moving the bender. An improperly installed handle could allow the bender to fall, injuring nearby personnel.</p> <p>Failure to observe this warning could result in severe injury or death.</p>


	<p style="text-align: center;">⚠ WARNING</p> <p>Pinch points:</p> <p>Keep hands away from bending shoe, rollers and conduit when bender is in use.</p> <p>Failure to observe this warning could result in severe injury or death.</p>
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<p style="text-align: center;">⚠ WARNING</p> <p>Unplug the bender before changing accessories. Accidental start-up could result in serious injury.</p>

	<p style="text-align: center;">⚠ CAUTION</p> <p>Do not use as a step or ladder.</p>
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<p style="text-align: center;">⚠ CAUTION</p> <ul style="list-style-type: none"> Conduit moves rapidly as it is bent. The path of the conduit must be clear of obstructions. Be sure clearance is adequate before starting the bend. Do not operate the bender while wearing loose clothing. Loose clothing can get caught in moving parts. Inspect the bender before use. Replace worn, damaged or missing parts with Greenlee replacement parts. A damaged or improperly assembled component could break and strike nearby personnel. Some bender parts and accessories are heavy and may require more than one person to lift and assemble. Use this tool for the manufacturer's intended purpose only. Use other than that which is instructed in this manual can result in injury or property damage. <p>Failure to observe these precautions could result in injury or property damage.</p>
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Grounding Instructions

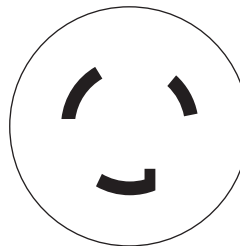
	<p>⚠ WARNING</p> <p>Electric shock hazard:</p> <ul style="list-style-type: none">• Do not modify the plug provided with the tool.• Connect this tool to a grounded receptacle on a 20 amp ground fault protected circuit. <p>Failure to observe these warnings could result in severe injury or death.</p>
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This tool must be grounded. In the event of a malfunction or breakdown, an electrical ground provides a path of least resistance for the electric current. This path of least resistance is intended to reduce the risk of electric shock.

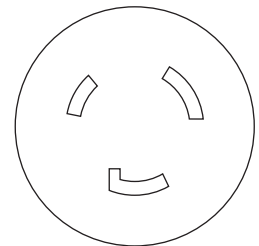
This tool's electric cord has a grounding conductor and a grounding plug as shown. Do not modify the plug. Connect the plug to a corresponding GFCI-protected receptacle that is properly installed and grounded in accordance with all national and local codes and ordinances.

Do not use an adapter.

NEMA L5-20 Twist-Lock 20 Amp/120 Volt Plug and Receptacle

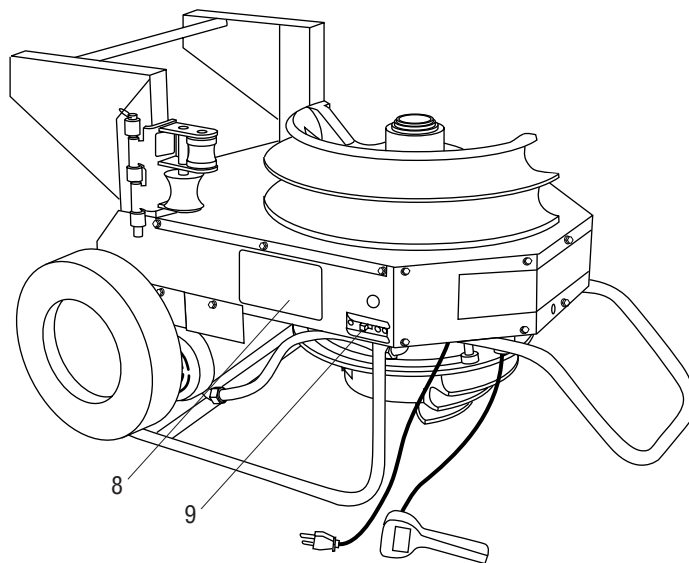
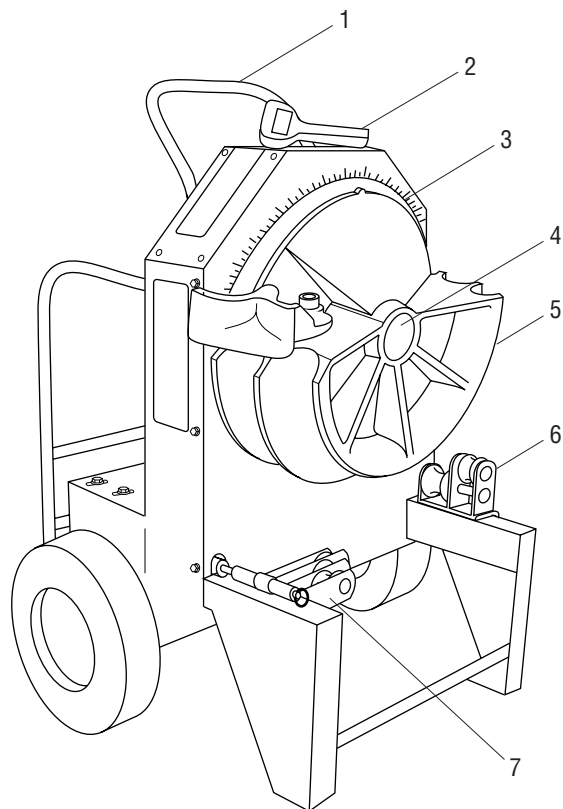


Plug



Receptacle

Identification



555RC Electric Bender (shown)

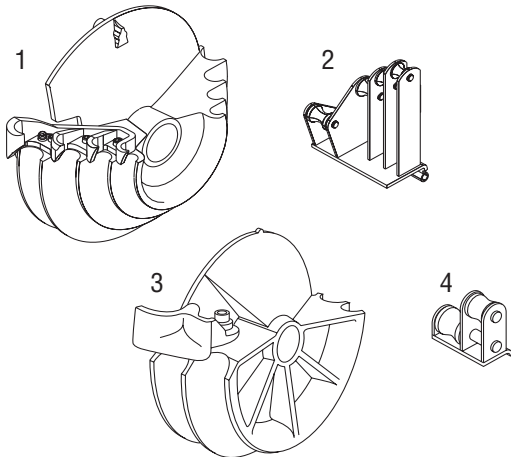
- | | |
|-----------------|--|
| 1. Handle | 6. 1-1/2" to 2" Roller Support |
| 2. Pendant | 7. 1/2" to 1-1/4" Roller Support (in storage position) |
| 3. Protractor | 8. Bending Instructions Decal |
| 4. Main Shaft | 9. Circuit Breaker (ON/OFF switch) |
| 5. Bending Shoe | |

Specifications

Height	1118 mm (44")
Width	724 mm (28.5")
Depth	521 mm (20.5")
Mass/Weight (bender without shoes or roller supports)	118 kg (260 lb)
Power Supply	120 VAC, 20 amp
GFCI-protected receptacle	
Operating Conditions	
Temperature	-20 °C to 49 °C (-5 °F to 120 °F)
Relative Humidity	0 to 98%
Capacity	1/2" to 2" conduit, schedule 40 pipe

Bending Attachment Groups

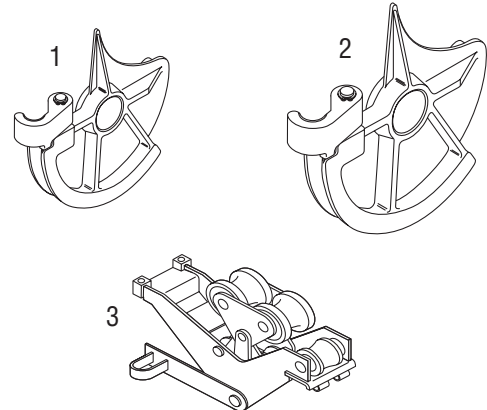
RIGID



28007: 1/2" to 1-1/4" IMC
1/2" to 2" Rigid Steel
1/2" to 2" Schedule 40 Pipe

Key	UPC No. 78-3310-	Description
1	00571	Bending shoe for 1/2" to 1-1/4"
2	00936	Roller support unit for 1/2" to 1-1/4"
3	17937	Bending shoe for 1-1/2" to 2"
4	17984	Roller support unit for 1-1/2" to 2"

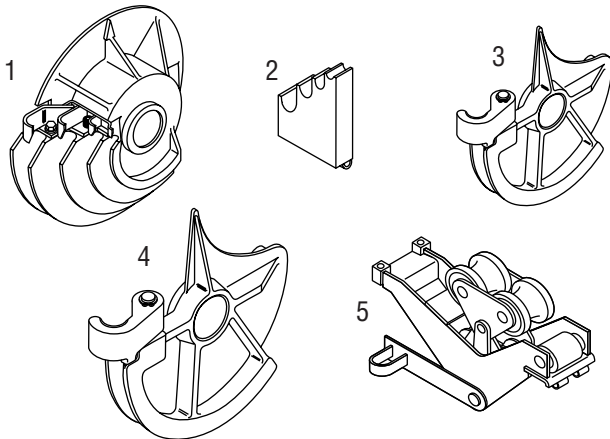
IMC



26330: 1-1/2" to 2" IMC

Key	UPC No. 78-3310-	Description
1	25263	Bending shoe for 1-1/2"
2	25268	Bending shoe for 2"
3	25273	Roller support unit for 1-1/2" to 2"
	23818	Storage box

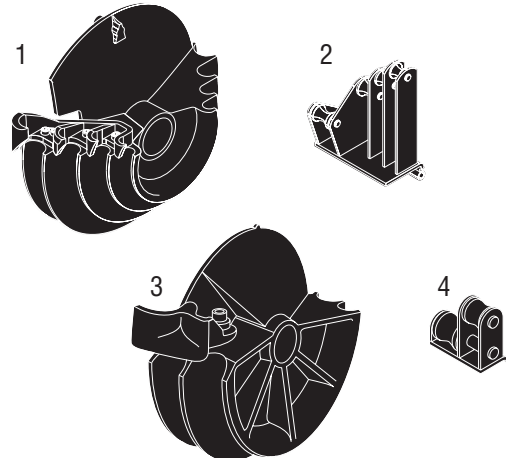
EMT



23802: 1/2" to 2" EMT

Key	UPC No. 78-3310-	Description
1	17944	Bending shoe for 1/2" to 1-1/4"
2	17986	Roller support unit for 1/2" to 1-1/4"
3	23499	Bending shoe for 1-1/2"
4	23505	Bending shoe for 2"
5	23541	Roller support unit for 1-1/2" to 2"
	23818	Storage box

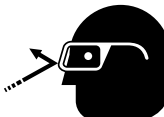
PVC-COATED RIGID



37279: 1-1/2" to 2" 40 Mil PVC-Coated Rigid

Key	UPC No. 78-3310-	Description
1	00573	Bending shoe for 1/2" to 1-1/4"
2	00946	Roller support unit for 1/2" to 1-1/4"
3	37281	Bending shoe for 1-1/2" to 2"
4	37282	Roller support unit for 1-1/2" to 2"
	23818	Storage box

Setup

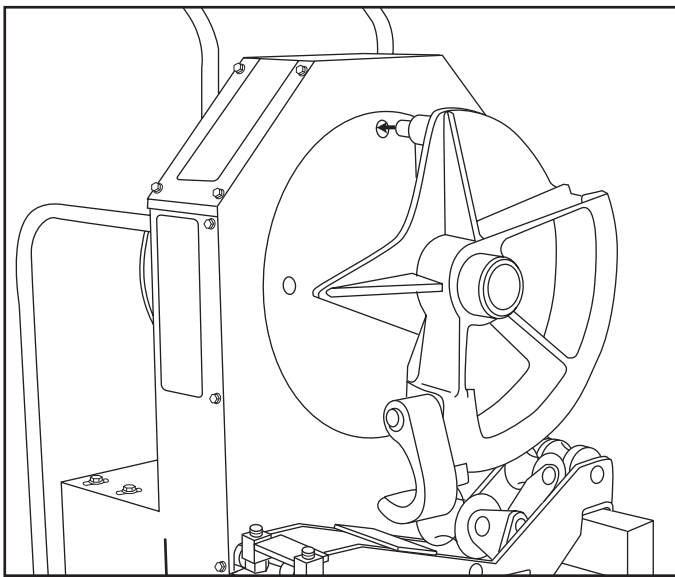
	<p align="center">⚠ WARNING</p> <p>Wear eye protection when operating or servicing this tool.</p> <p>Failure to wear eye protection could result in serious eye injury from flying debris.</p>
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<p align="center">⚠ WARNING</p>
<p>Unplug the bender before changing accessories. Accidental start-up could result in serious injury.</p>

1. Slide the appropriate bending shoe onto the shaft of the main sprocket, as shown. Align the four drive studs on the back of the shoe with the four holes in the main sprocket.

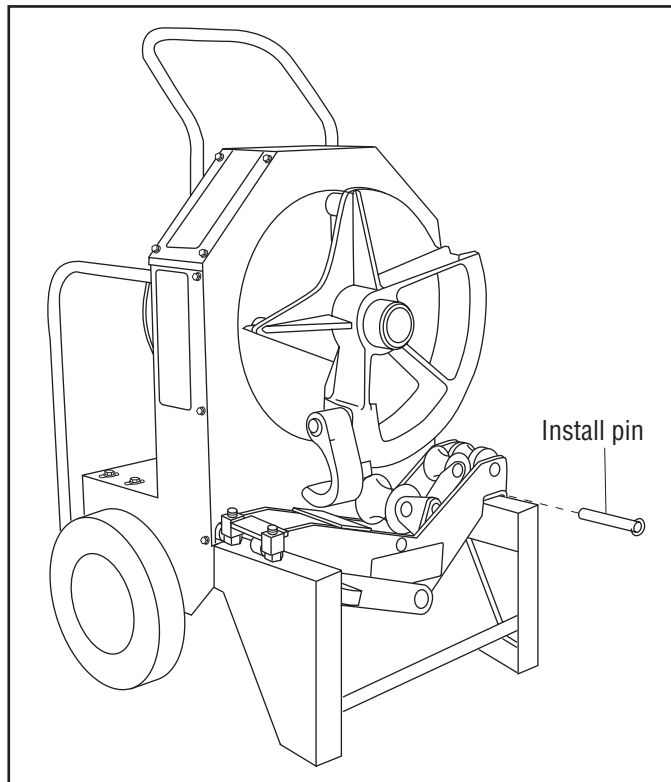
Note: 1-1/2" and 2" EMT and IMC bending shoes have only three drive studs.

Installing a Bending Shoe



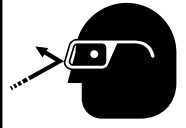
2. Mount the appropriate support unit onto the leg of the bender and install the hinge pin, as shown.


Roller Support Unit Installed



3. Mark the conduit. See the decals on the bender or the Additional Bending Instructions section of this manual.
4. Place the bender in either the vertical or horizontal bending position.

Operation

	<p>⚠ WARNING</p> <p>Wear eye protection when operating or servicing this tool.</p> <p>Failure to wear eye protection could result in serious eye injury from flying debris.</p>
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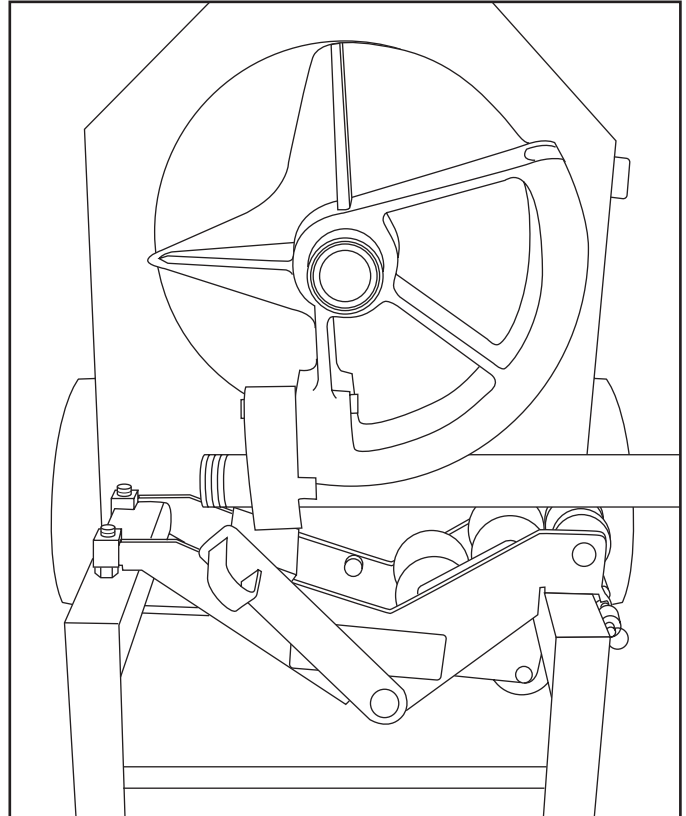
	<p>⚠ WARNING</p> <p>Pinch points:</p> <p>Keep hands away from bending shoe, rollers and conduit when bender is in use.</p> <p>Failure to observe this warning could result in severe injury or death.</p>
---	--

<p>⚠ WARNING</p> <p>Do not operate the bender while wearing loose clothing. Loose clothing can get caught in moving parts.</p> <p>Failure to observe this warning could result in severe injury or death.</p>	
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BENDING CONDUIT

1. Plug the cord into an appropriate receptacle. See Grounding Instructions.
2. Press BEND or UNLOAD until the shoe is 5° to 10° before the 0° starting point.
3. Load the conduit so that the bending mark is aligned with the front edge of the shoe hook, as illustrated.

Loading the Conduit



4. See the instruction decal for the appropriate bend angle.

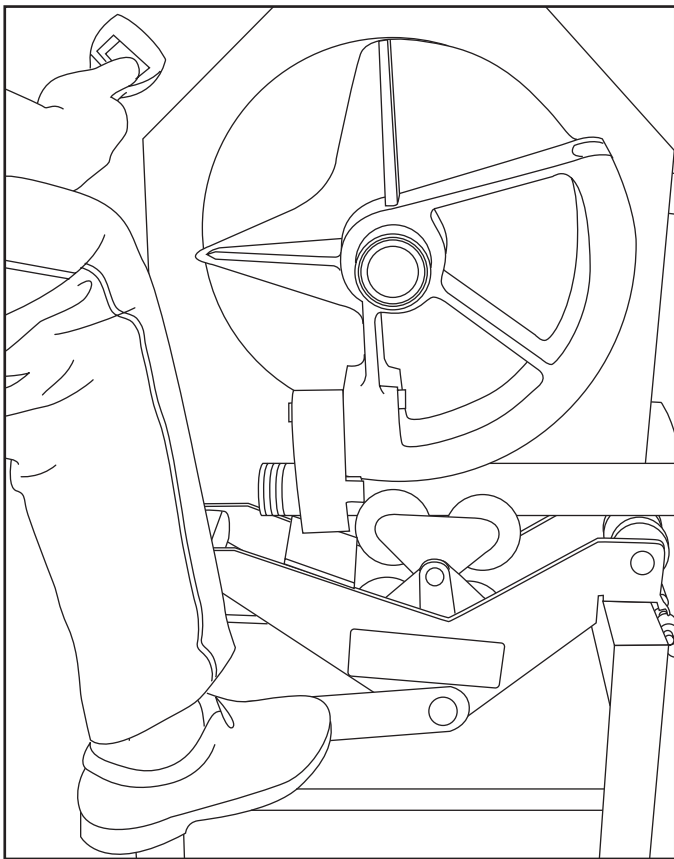
Operation (cont'd)

5. Bend the conduit:

If bending 1-1/2" to 2" EMT or IMC:

- a. Place one foot on the loading pedal, as shown.

**Engaging the Loading Pedal
(for 1-1/2" to 2" EMT or IMC only)**



- b. Press and hold BEND. The bender will pull up the roller support. When the roller support contacts the stop, remove your foot from the loading pedal.
- c. Release the switch as you approach the desired angle of bend.
- d. Press BEND momentarily until the bend is complete.

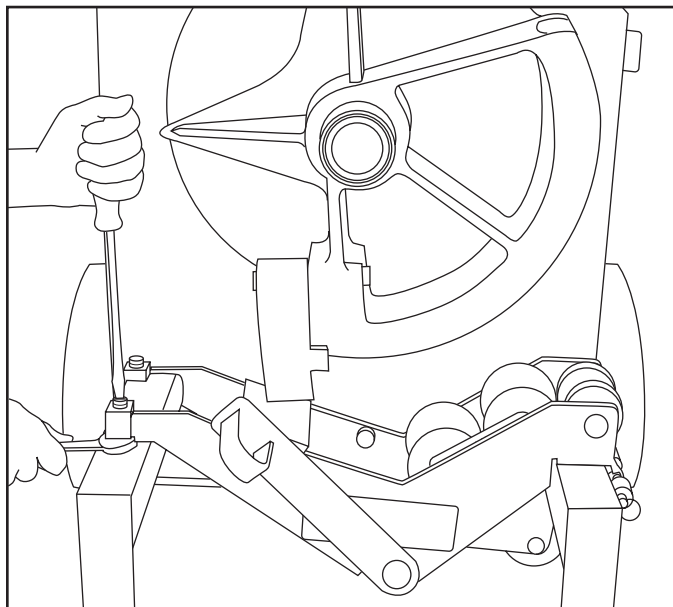
If bending any other size or type of conduit:

- a. Press and hold BEND.
- b. Release the switch as you approach the desired angle of bend.
- c. Press BEND momentarily until the bend is complete.
6. Press UNLOAD. The shoe will rotate backward.
Note: If bending EMT or IMC, the roller support unit will drop to its original position.
7. Twist the conduit to release it from the hook. Remove the conduit.
8. Press and hold UNLOAD until the shoe has rotated back to 0°.

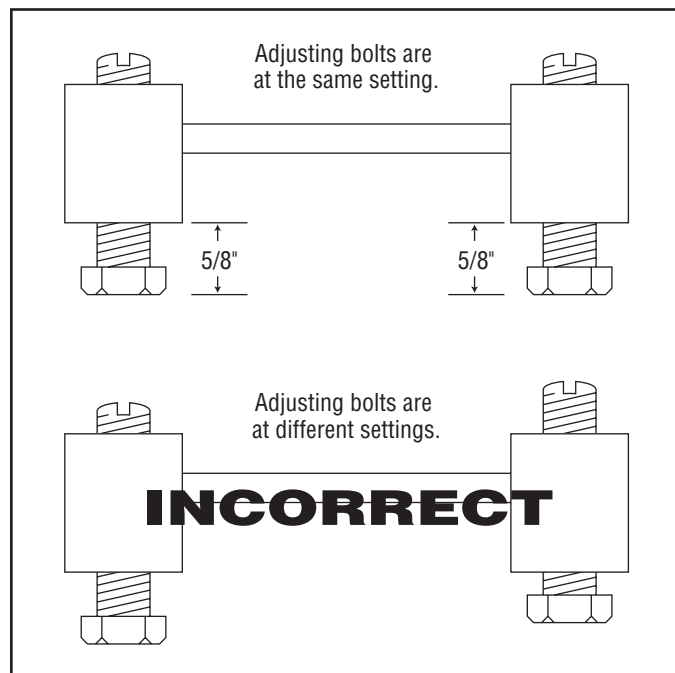
ADJUSTING THE SQUEEZE

3. Tighten the set screws.

Adjusting the Squeeze

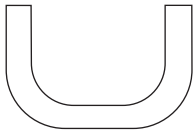


Standard Squeeze Setting



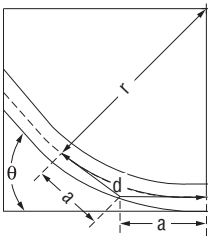


Illustrated Bending Glossary



back-to-back bend — any U-shaped bend formed by two parallel 90° bends with a straight section of conduit or pipe between the bends.

center-to-center distance — the distance between the successive bends that make up an offset or a three-bend saddle.



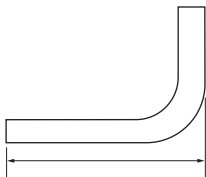
developed length — the actual length of pipe that will be bent; see distance “d” in the illustration at left.

gain — the difference between the straight-line distance ($a + a$) and the shorter radial distance, (d) where:

θ = angle of bend

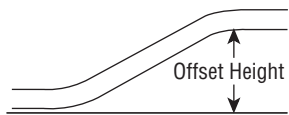
r = the centerline bending radius of the bending shoe

kick — single bend of less than 90°

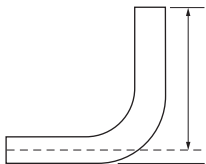


leg length — the distance from the end of a straight section of conduit or pipe to the bend; measured from the end to the outside edge of the conduit or pipe.

offset bend — two opposite bends with the same degree of bend; used to avoid an obstruction.



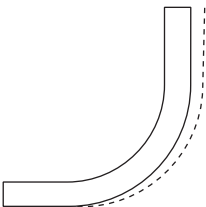
offset height — the distance between the two legs of an offset bend, measured perpendicular to the two legs; also called amount of offset and depth of offset.



rise — the distance from the end of a straight section of conduit or pipe to the bend; measured from the end to the center line of the conduit or pipe. Also called stub or stub-up.

saddle — a three-bend or four-bend combination; used to avoid an obstruction.

shrink — the amount of conduit “lost” when laying out an offset bend working toward an obstruction; see the explanation under Offset Bending in this manual.



springback — the amount, measured in degrees, that a conduit or pipe tends to straighten after being bent.

Bending Instructions

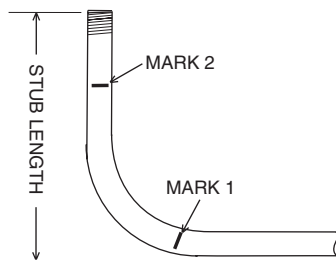
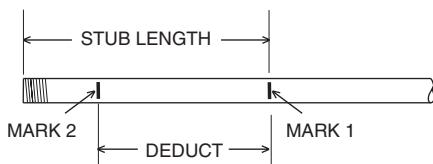
90° STUBS

1. Measure the length of the required stub.
2. See the Minimum Stub Length formula on the Deduct Table. The required stub must be equal to or longer than the Minimum Stub Length.
3. Measure and mark the stub length on the conduit. This is Mark 1. Subtract the Deduct from this mark and make a new mark. This is Mark 2.
4. Align Mark 2 with the front edge of the hook and bend the conduit.

Notes:

When the operator presses "UNLOAD", the conduit may spring back a few degrees. Compensate by overbending as shown in the Scale Reading Table.

The rigid shoe can make a 180° bend in one shot. All other shoes bend to 90° maximum.



Deduct Table

SIZE		1/2	3/4	1	1-1/4	1-1/2	2
DEDUCT	RIGID/PVC	7-1/2	9	11	14	14-1/4	16-1/8
	EMT	7	8-7/8	10-3/4	13-1/8	13-7/8	15-3/8
	IMC	7-1/2	9	11	14	13-3/4	15-1/4
MINIMUM STUB LENGTH = DEDUCT PLUS 2 INCHES							

Figures are approximate

Scale Reading Table

SIZE	RIGID					EMT				
	15°	30°	45°	60°	90°	15°	30°	45°	60°	90°
1/2	18-3/4	35	50	66-1/4	96-1/4	16-1/4	32-1/2	47-1/2	63-3/4	95
3/4	17-1/2	32-1/2	47-1/2	63-3/4	95	17-1/2	33-3/4	48-3/4	63-3/4	95
1	17-1/2	33-3/4	48-3/4	65	95	17-1/2	32-1/2	48-3/4	65	95
1-1/4	18-3/4	33-3/4	48-3/4	63-3/4	95	17-1/2	33-3/4	48-3/4	65	95
1-1/2	18-3/4	33-3/4	48-3/4	65	95	16-1/4	31-1/4	46-1/4	61-1/4	92-1/2
2	20	35	48-3/4	63-3/4	96-1/4	17-1/2	33-3/4	48-3/4	63-3/4	95

SIZE	IMC					PVC-Coated				
	15°	30°	45°	60°	90°	15°	30°	45°	60°	90°
1/2	20	36-1/4	51-1/4	67-1/2	98-3/4	17-1/2	33-3/4	48-3/4	65	95
3/4	20	36-1/4	51-1/4	67-1/2	97-1/2	17-1/2	33-3/4	48-3/4	63-3/4	95
1	21-1/4	36-1/4	51-1/4	66-1/4	97-1/2	17-1/2	32-1/2	47-1/2	63-3/4	95
1-1/4	18-3/4	33-3/4	50	65	96-1/4	18-3/4	33-3/4	50	65	95
1-1/2	17-1/2	33-3/4	48-3/4	63-3/4	95	18-3/4	33-3/4	48-3/4	65	95
2	20	35	50	65	96-1/4	20	35	48-3/4	63-3/4	96-1/4

Figures are approximate

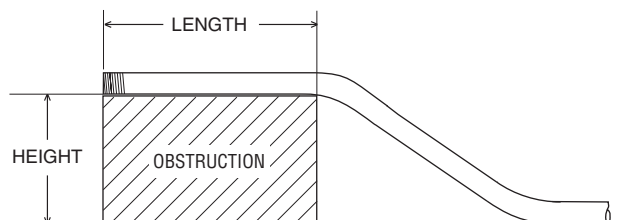
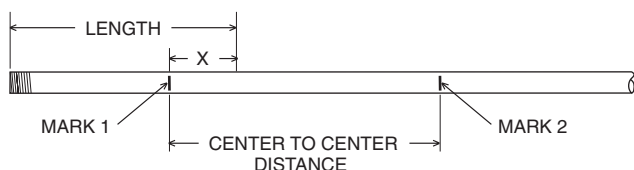
Bending Instructions (cont'd)

Offsets

1. Measure the height and length of the obstruction. Select the angle to be used.
2. See the Offset Table. The height of the obstruction must be equal to or greater than the minimum offset.
3. Refer to the X Table to find the X dimension. Refer to the Offset Table to find the center-to-center distance.

Note: If the center-to-center distance is not shown, calculate it by using the multipliers shown in the Offset Table.

4. Mark the conduit as shown.
5. Insert the conduit into the bender. Align Mark 1 with the front edge of the hook and bend the conduit.
6. Align Mark 2 with the front edge of the hook. Without removing the conduit from the bender, rotate the conduit 180°. Make the second bend.



Offset Table

OFFSET ►		2	4	6	8	10
15°	Max Conduit Size	3/4	1-1/2	2	2	
	Center-to-Center	7-3/4	15-7/16	23-3/16	30-15/16	38-5/8
30°	Max Conduit Size		3/4	1	1-1/2	2
	Center-to-Center		8	12	16	20
45°	Max Conduit Size			1/2	1	1-1/4
	Center-to-Center			8-1/2	11-5/16	14-1/8

OFFSET ►		12	14	16	18	20	22
15°	Max Conduit Size	2					
	Center-to-Center	46-3/8	54-1/16	61-13/16	69-9/16	77-1/4	85
30°	Max Conduit Size	2					
	Center-to-Center	24	28	32	36	40	44
45°	Max Conduit Size	1-1/2	2	2			
	Center-to-Center	16-15/16	19-13/16	22-5/8	25-7/16	28-1/4	31-1/8

CENTER-TO-CENTER DISTANCE = OFFSET HEIGHT x MULTIPLIER

OFFSET ANGLE	10°	15°	22-1/2°	30°	45°
MULTIPLIER	5.8	3.9	2.6	2.0	1.4

Figures are approximate

X Table

CONDUIT SIZE	1/2	3/4	1	1-1/4	1-1/2	2
"X"	3-1/16	3-1/16	3-3/16	4	4-1/4	4-1/2

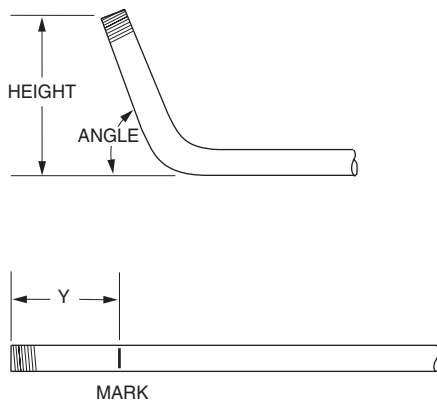
Figures are approximate

Additional Bending Instructions

The following drawings and bending tables are intended to provide the information necessary to accomplish the most common types of bends. The Bending Tables contain conduit marking information.

STUBS

1. Select the size and type of conduit. Determine the height of stub and the angle to be used.
2. Find the table that corresponds to the size and type of conduit selected in Step 1.
3. Under the column labeled **ANGLE**, find the appropriate angle.
4. Find the row labeled **Y**. In the row at the top of the page, find the height (**H**) of the stub. The number shown at the intersection of row **Y** and column **H** is the distance **Y**. Place the bending mark **Y** inches from the end of the conduit.
5. Bend the conduit.



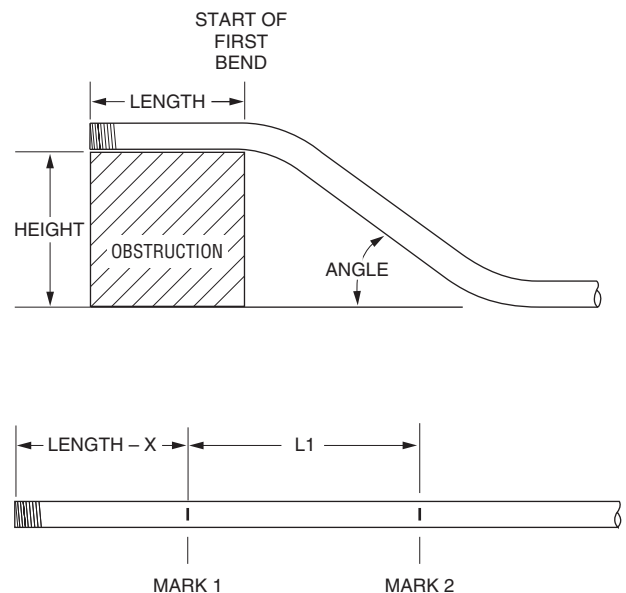
OFFSETS

An offset is used to route the conduit around an obstruction. To make an offset, two equal bends are required. The distance between the two bends is the center-to-center distance.

When working past an obstruction, it is necessary to determine the location of the first bend. The center-to-center distance is then used to determine the location of the second bend. When working toward an obstruction, it is necessary to determine the location of the second bend. The center-to-center distance is then used to determine the location of the first bend.

Working Past an Obstruction

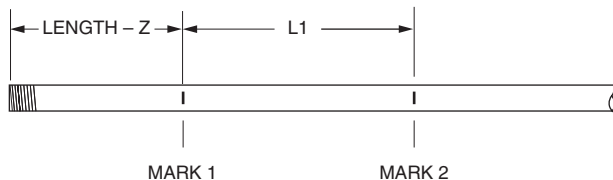
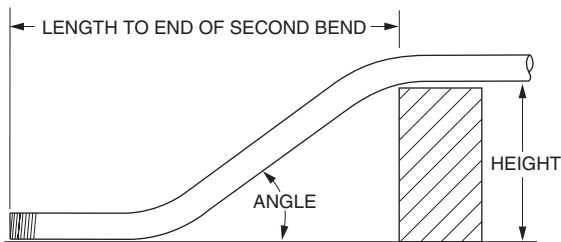
1. Select the size and type of conduit. Measure the height of the obstruction and the distance labeled **LENGTH**. Determine the angle to be used.
2. Find the table that corresponds to the size and type of conduit selected in Step 1.
3. To the right of the size and type of conduit, find the dimension labeled **X**. Subtract **X** from **LENGTH**. Place the first bending mark this distance from the end of the conduit.
4. Under the column labeled **ANGLE**, find the appropriate angle. Find the row labeled **L1**. In the row at the top of the page, find the height (**H**) of the offset. The number shown at the intersection of row **L1** and column **H** is **L1**. Place the second bending mark **L1** inches from the first bending mark.
5. Bend the conduit.



Additional Bending Instructions (cont'd)

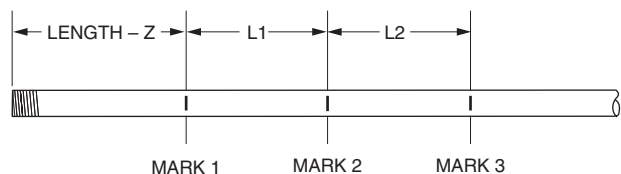
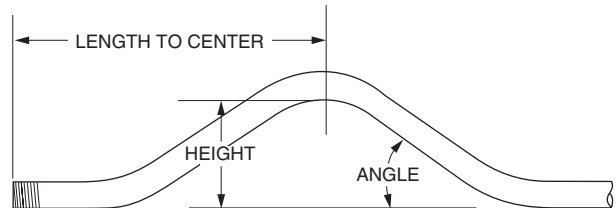
Working Toward an Obstruction

1. Select the size and type of conduit. Measure the height of the obstruction and the distance labeled **LENGTH TO END OF SECOND BEND**. Determine the angle to be used.
2. Find the table that corresponds to the size and type of conduit selected in Step 1.
3. Under the column labeled **ANGLE**, find the appropriate angle. Find the row labeled **Z**. In the row at the top of the page, find the height (**H**) of the offset. The number shown at the intersection of the **Z** row and the **H** column is **Z**. Subtract **Z** from **LENGTH TO THE END OF SECOND BEND**. Place the first bending mark this distance from the end of the conduit.
4. In the same column, find the row labeled **L1**. Place the second bending mark **L1** inches from the first bending mark.
5. Bend the conduit.



THREE-BEND SADDLE

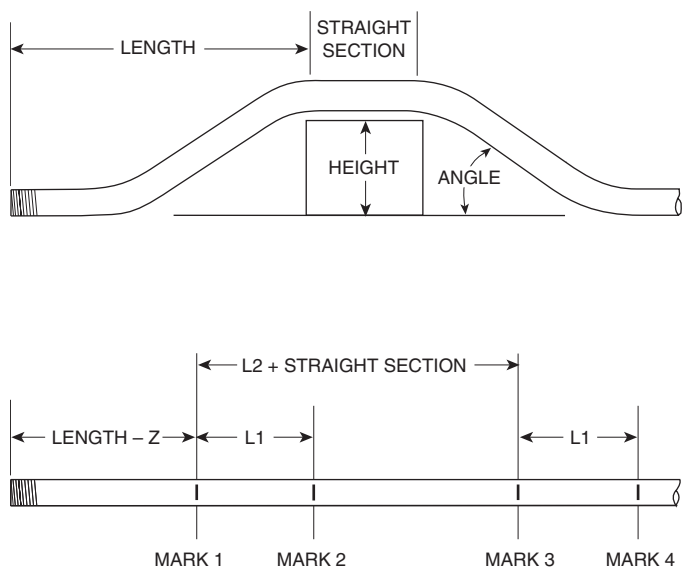
1. Select the size and type of conduit. Measure the height of the obstruction and the distance from the end of the conduit to the center (**LENGTH TO CENTER**) of the bend. Determine the angle to be used.
2. Find the table that corresponds to the size and type of conduit selected in Step 1.
3. Under the column labeled **ANGLE**, find the appropriate angle. Find the row labeled **Z**. In the row at the top of the page, find the height (**H**) of the offset. The number shown at the intersection of the **Z** row and the appropriate **H** column is **Z**. Subtract **Z** from the **LENGTH TO CENTER**. Place the first bending mark this distance from the end of the conduit.
4. In the same column, find the row labeled **L1**. Place the second bending mark **L1** inches from the first bending mark.
5. In the same column, find the row labeled **L2**. Place the third bending mark **L2** inches from the second bending mark.
6. Bend the conduit.



Additional Bending Instructions (cont'd)

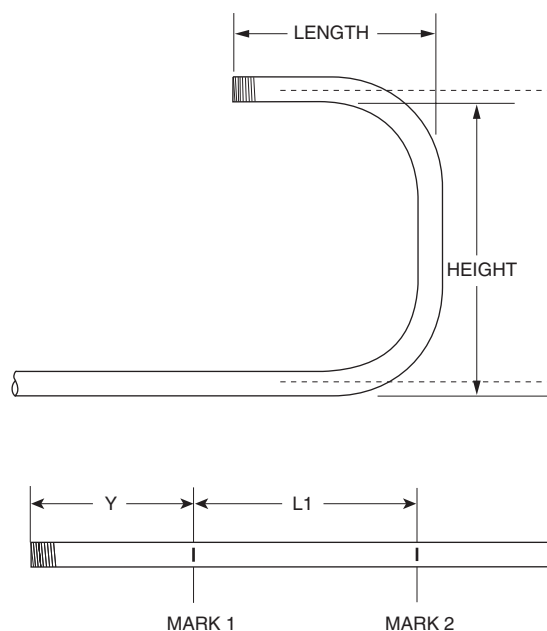
FOUR-BEND SADDLE

1. Select the size and type of conduit. Measure the height of the obstruction, the distance labeled **LENGTH**, and the distance labeled **STRAIGHT SECTION**. Determine the angle to be used.
2. Find the table that corresponds to the size and type of conduit selected in Step 1.
3. Under the column labeled **ANGLE**, find the appropriate angle. Find the row labeled **Z**. In the row at the top of the page, find the height (**H**) of the offset. The number shown at the intersection of the **Z** row and the appropriate **H** column is **Z**. Subtract **Z** from the **LENGTH**. Place the first bending mark this distance from the end of the conduit.
4. In the same column, find the row labeled **L1**. Place the second bending mark **L1** inches from the first bending mark.
5. In the same column, find the row labeled **L2**. Add **L2** to the **STRAIGHT SECTION**. Place the third bending mark this distance from the first bending mark.
6. Make the final bending mark **L1** inches from the third bending mark.
7. Bend the conduit.



U-BENDS

1. Select the size and type of conduit. Determine the **LENGTH** and the **HEIGHT**.
2. Find the table that corresponds to the size and type of conduit selected in Step 1.
3. Under the column labeled **ANGLE**, find 90° .
4. Find the row labeled **Y**. In the row at the top of the page, find the height (**H**) that corresponds to the **LENGTH**. The number shown at the intersection of the **Y** row and the appropriate **H** column is the distance **Y**. Place the bending mark **Y** inches from the end of the conduit.
5. Find the row labeled **L1**, and go to the right to find the height (**H**) that corresponds to the **HEIGHT**.
6. The number shown at the intersection of the **L1** row and the appropriate **H** column is **L1**. Place the second bending mark **L1** inches from the first mark.
7. Bend the conduit.



Additional Bending Tables

	DIM	ANGLE	2"	4"	6"	8"	10"	12"	15"	18"	24"	36"
1/2" EMT												
	Y	15	3.74	11.47	19.20	26.92	34.65	42.38	53.97	65.56	88.74	135.11
	L1	15	7.72	15.45	23.18	30.90	38.63	46.36	57.95	69.54	92.72	139.09
	L2	15	8.94	16.66	24.39	32.12	39.84	47.57	59.16	70.75	93.94	140.30
	Z	15	10.70	18.16	25.62	33.09	40.55	48.02	59.21	70.41	92.80	137.59
MINIMUM H = 0.84												
	Y	22.5	1.37	6.60	11.82	17.05	22.28	27.50	35.34	43.18	58.86	90.22
	L1	22.5	5.20	10.43	15.65	20.88	26.11	31.33	39.17	47.01	62.69	94.05
	L2	22.5	7.02	12.25	17.48	22.70	27.93	33.16	41.00	48.83	64.51	95.87
	Z	22.5	8.68	13.51	18.34	23.17	28.00	32.83	40.07	47.31	61.80	90.77
MINIMUM H = 1.48												
	Y	30	0.04	4.04	8.04	12.04	16.04	20.04	26.04	32.04	44.04	68.04
	L1	30		7.94	11.94	15.94	19.94	23.94	29.94	35.94	47.94	71.94
	L2	30		10.37	14.37	18.37	22.37	26.37	32.37	38.37	50.37	74.37
	Z	30		11.42	14.89	18.35	21.82	25.28	30.48	35.67	46.07	66.85
MINIMUM H = 2.25												
	Y	45		1.23	4.05	6.88	9.71	12.54	16.78	21.02	29.51	46.48
	L1	45			8.29	11.11	13.94	16.77	21.01	25.26	33.74	50.71
	L2	45			11.93	14.76	17.59	20.42	24.66	28.90	37.39	54.36
	Z	45			11.85	13.85	15.85	17.85	20.85	23.85	29.85	41.85
MINIMUM H = 4.14												
	Y	60			1.83	4.14	6.45	8.76	12.22	15.69	22.62	36.47
	L1	60				8.74	11.05	13.36	16.82	20.29	27.21	41.07
	L2	60				13.60	15.91	18.22	21.68	25.14	32.07	45.93
	Z	60				11.99	13.14	14.30	16.03	17.76	21.22	28.15
MINIMUM H = 6.38												
	Y	90				1.00	3.00	5.00	8.00	11.00	17.00	29.00
	L1	90						10.01	13.01	16.01	22.01	34.01
	L2	90						17.30	20.30	23.30	29.30	41.30
	Z	90						11.29	11.29	11.29	11.29	11.29
MINIMUM H = 11.29												
3/4" EMT												
	Y	15	2.35	10.07	17.80	25.53	33.26	40.98	52.58	64.17	87.35	133.71
	L1	15	7.72	15.45	23.17	30.90	38.63	46.36	57.95	69.54	92.72	139.08
	L2	15	9.17	16.90	24.62	32.35	40.08	47.81	59.40	70.99	94.17	140.54
	Z	15	11.79	19.26	26.72	34.19	41.65	49.11	60.31	71.51	93.90	138.68
MINIMUM H = 1.12												
	Y	22.5	0.05	5.28	10.50	15.73	20.95	26.18	34.02	41.86	57.54	88.90
	L1	22.5	5.20	10.42	15.65	20.88	26.10	31.33	39.17	47.01	62.69	94.04
	L2	22.5	7.37	12.60	17.83	23.05	28.28	33.50	41.34	49.18	64.86	96.22
	Z	22.5	9.90	14.73	19.56	24.39	29.22	34.04	41.29	48.53	63.02	91.99
MINIMUM H = 1.94												
	Y	30		2.72	6.72	10.72	14.72	18.72	24.72	30.72	42.72	66.72
	L1	30		7.93	11.93	15.93	19.93	23.93	29.93	35.93	47.93	71.93
	L2	30		10.83	14.83	18.83	22.83	26.83	32.83	38.83	50.83	74.83
	Z	30		12.77	16.23	19.70	23.16	26.62	31.82	37.02	47.41	68.19
MINIMUM H = 2.92												
	Y	45			2.67	5.50	8.33	11.15	15.40	19.64	28.12	45.09
	L1	45			8.25	11.08	13.90	16.73	20.97	25.22	33.70	50.67
	L2	45			12.60	15.43	18.25	21.08	25.33	29.57	38.05	55.02
	Z	45			13.46	15.46	17.46	19.46	22.46	25.46	31.46	43.46
MINIMUM H = 5.27												
	Y	60			0.33	2.64	4.95	7.26	10.72	14.18	21.11	34.97
	L1	60					10.95	13.26	16.72	20.19	27.12	40.97
	L2	60					16.75	19.06	22.53	25.99	32.92	46.78
	Z	60					15.04	16.20	17.93	19.66	23.12	30.05
MINIMUM H = 8.03												
	Y	90					1.13	3.13	6.13	9.13	15.13	27.13
	L1	90							12.62	15.62	21.62	33.62
	L2	90							21.32	24.32	30.32	42.32
	Z	90							13.95	13.95	13.95	13.95
MINIMUM H = 13.95												

Additional Bending Tables (cont'd)

	DIM	ANGLE	2"	4"	6"	8"	10"	12"	15"	18"	24"	36"
1" EMT												
	Y	15	1.35	9.07	16.80	24.53	32.26	39.98	51.57	63.16	86.35	132.71
	L1	15	7.72	15.44	23.17	30.90	38.63	46.35	57.95	69.54	92.72	139.08
	L2	15	9.54	17.26	24.99	32.72	40.45	48.17	59.76	71.36	94.54	140.90
	Z	15	12.51	19.98	27.44	34.91	42.37	49.83	61.03	72.23	94.62	139.40
MINIMUM H = 1.31												
	Y	22.5		4.33	9.56	14.78	20.01	25.24	33.07	40.91	56.59	87.95
	L1	22.5		10.42	15.64	20.87	26.10	31.32	39.16	47.00	62.68	94.04
	L2	22.5		13.15	18.37	23.60	28.82	34.05	41.89	49.73	65.41	96.77
	Z	22.5		15.64	20.47	25.30	30.13	34.96	42.20	49.44	63.93	92.90
MINIMUM H = 2.29												
	Y	30		1.75	5.75	9.75	13.75	17.75	23.75	29.75	41.75	65.75
	L	30		7.91	11.91	15.91	19.91	23.91	29.91	35.91	47.91	71.91
	L2	30		11.55	15.55	19.55	23.55	27.55	33.55	39.55	51.55	75.55
	Z	30		13.87	17.34	20.80	24.27	27.73	32.92	28.12	48.51	69.30
MINIMUM H = 3.47												
	Y	45			1.56	4.39	7.22	10.05	14.29	18.53	27.02	43.99
	L1	45				11.01	13.84	16.67	20.91	25.16	33.64	50.61
	L2	45				16.47	19.30	22.13	26.37	30.62	39.10	56.07
	Z	45				16.98	18.98	20.98	23.98	26.98	32.98	44.98
MINIMUM H = 6.35												
	Y	60				1.33	3.64	5.95	9.42	12.88	19.81	33.67
	L1	60					10.80	13.11	16.57	20.04	26.97	40.82
	L2	60					18.08	20.39	23.85	27.32	34.24	48.10
	Z	60					17.02	18.17	19.91	21.64	25.10	32.03
MINIMUM H = 9.74												
	Y	90						1.25	4.25	7.25	13.25	25.25
	L1	90								15.02	21.02	33.02
	L2	90								25.93	31.93	43.93
	Z	90								17.12	17.12	17.12
MINIMUM H = 17.12												
1-1/4" EMT												
	Y	15	0.26	7.99	15.72	23.45	31.17	38.90	50.49	62.08	85.27	131.63
	L1	15	7.71	15.44	23.17	30.90	38.62	46.35	57.94	69.53	92.72	139.08
	L2	15	10.07	17.80	25.52	33.25	40.98	48.71	60.30	71.89	95.07	141.44
	Z	15	13.20	20.66	28.12	35.59	43.05	50.52	61.71	72.91	95.30	140.09
MINIMUM H = 1.48												
	Y	22.5		3.33	8.55	13.78	19.01	24.23	32.07	39.91	55.59	86.95
	L1	22.5		10.41	15.63	20.86	26.09	31.31	39.15	46.99	62.67	94.03
	L2	22.5		13.94	19.17	24.40	29.62	34.85	42.69	50.53	66.21	97.56
	Z	22.5		16.60	21.43	26.26	31.09	35.91	43.16	50.40	64.89	93.86
MINIMUM H = 2.66												
	Y	30		0.72	4.72	8.72	12.72	16.72	22.72	28.72	40.72	64.72
	L1	30			11.89	15.89	19.89	23.89	29.89	35.89	47.89	71.89
	L2	30			16.61	20.61	24.61	28.61	34.61	40.61	52.61	76.61
	Z	30			18.58	22.04	25.51	28.97	34.17	39.37	49.76	70.54
MINIMUM H = 4.09												
	Y	45			0.33	3.15	5.98	8.81	13.05	17.30	25.78	42.75
	L1	45				10.93	13.75	16.58	20.83	25.07	33.55	50.52
	L2	45				18.00	20.83	23.66	27.90	32.14	40.63	57.60
	Z	45				18.82	20.82	22.82	25.82	28.82	34.82	46.82
MINIMUM H = 7.65												
	Y	60					2.11	4.42	7.89	11.35	18.28	32.14
	L1	60						12.89	16.35	19.82	26.74	40.60
	L2	60						22.32	25.79	29.25	36.18	50.04
	Z	60						20.69	22.42	24.16	27.62	34.55
MINIMUM H = 11.92												
	Y	90							1.88	4.88	10.88	22.88
	L1	90									20.13	32.13
	L2	90									34.29	46.29
	Z	90									21.38	21.38
MINIMUM H = 21.38												

Additional Bending Tables (cont'd)

	DIM	ANGLE	2"	4"	6"	8"	10"	12"	15"	18"	24"	36"
1-1/2" EMT												
	Y	15		6.26	13.99	21.72	29.44	37.17	48.76	60.35	83.53	129.90
	L1	15	7.71	15.44	23.17	30.90	38.62	46.35	57.94	69.53	92.72	139.08
	L2	15	9.95	17.68	25.40	33.13	40.86	48.58	60.18	71.77	94.95	141.31
	Z	15	14.42	21.88	29.35	36.81	44.28	51.74	62.94	74.13	96.53	141.31
MINIMUM H = 1.81												
	Y	22.5		1.77	7.00	12.22	17.45	22.68	30.52	38.36	54.03	85.39
	L1	22.5		10.41	15.64	20.86	26.09	31.31	39.15	46.99	62.67	94.03
	L2	22.5		13.76	18.98	24.21	29.44	34.66	42.50	50.34	66.02	97.38
	Z	22.5		17.76	22.59	27.42	32.25	37.07	44.32	51.56	66.04	95.02
MINIMUM H = 3.11												
	Y	30			3.26	7.26	11.26	15.26	21.26	27.26	39.26	63.26
	L1	30			11.90	15.90	19.90	23.90	29.90	35.90	47.90	71.90
	L2	30			16.36	20.36	24.36	28.36	34.36	40.36	52.36	76.36
	Z	30			19.67	23.14	26.60	30.07	35.26	40.46	50.85	71.64
MINIMUM H = 4.64												
	Y	45				1.84	4.67	7.50	11.74	15.98	24.47	41.44
	L1	45					13.78	16.60	20.85	25.09	33.57	50.54
	L2	45					20.47	23.30	27.55	31.79	40.27	57.24
	Z	45					21.78	23.78	26.78	29.78	35.78	47.78
MINIMUM H = 8.33												
	Y	60					0.91	3.22	6.68	10.15	17.07	30.93
	L1	60							16.40	19.87	26.80	40.65
	L2	60							25.34	28.80	35.73	49.58
	Z	60							23.22	24.95	28.42	35.34
MINIMUM H = 12.61												
	Y	90							0.89	3.89	9.89	21.89
	L1	90									20.34	32.34
	L2	90									33.74	45.74
	Z	90									21.77	21.77
MINIMUM H = 21.77												
2" EMT												
	Y	15		5.15	12.87	20.60	28.33	36.05	47.65	59.24	82.42	128.78
	L1	15	7.71	15.44	23.17	30.90	38.62	46.35	57.94	69.53	92.71	139.08
	L2	15	10.19	17.92	25.64	33.37	41.10	48.83	60.42	72.01	95.19	141.56
	Z	15	14.77	22.24	29.70	37.17	44.63	52.10	63.29	74.49	96.88	141.66
MINIMUM H = 1.89												
	Y	22.5		0.88	6.11	11.33	16.56	21.79	29.62	37.46	53.14	84.50
	L1	22.5		10.40	15.63	20.86	26.08	31.31	39.15	46.99	62.67	94.02
	L2	22.5		14.12	19.35	24.57	29.80	35.02	42.86	50.70	66.38	97.74
	Z	22.5		18.24	23.07	27.90	32.73	37.55	44.80	52.04	66.52	95.50
MINIMUM H = 3.28												
	Y	30			2.45	6.45	10.45	14.45	20.45	26.45	38.45	62.45
	L1	30			11.88	15.88	19.88	23.88	29.88	35.88	47.88	71.88
	L2	30			16.84	20.84	24.84	28.84	34.84	40.84	52.84	76.84
	Z	30			20.28	23.75	27.21	30.67	35.87	41.07	51.46	72.24
MINIMUM H = 4.94												
	Y	45				1.02	3.85	6.68	10.92	15.16	23.65	40.62
	L1	45					13.74	16.56	20.81	25.05	33.53	50.50
	L2	45					21.16	23.99	28.24	32.48	40.96	57.93
	Z	45					22.66	24.66	27.66	30.66	36.66	48.66
MINIMUM H = 8.95												
	Y	60					0.00	2.31	5.77	9.23	16.16	30.02
	L1	60							16.30	19.77	26.70	40.55
	L2	60							26.21	29.67	36.60	50.46
	Z	60							24.40	26.14	29.60	36.53
MINIMUM H = 13.63												
	Y	90								2.62	8.62	20.62
	L1	90									19.94	31.94
	L2	90									34.80	46.80
	Z	90									23.74	23.74
MINIMUM H = 23.74												

Additional Bending Tables (cont'd)

	DIM	ANGLE	2"	4"	6"	8"	10"	12"	15"	18"	24"	36"
1/2" IMC, Rigid, and 40 Mil PVC-Coated Rigid												
	Y	15	3.03	10.76	18.48	26.21	33.94	41.67	53.26	64.85	88.03	134.39
	L1	15	7.72	15.45	23.18	30.90	38.63	46.36	57.95	69.54	92.72	139.09
	L2	15	8.87	16.59	24.32	32.05	39.78	47.50	59.10	70.69	93.87	140.23
	Z	15	11.12	18.58	26.05	33.51	40.97	48.44	59.63	70.83	93.22	138.01
MINIMUM H = 0.95												
	Y	22.5	.77	5.98	11.21	16.44	21.66	26.89	34.73	42.57	58.25	89.60
	L1	22.5	5.20	10.43	15.66	20.88	26.11	31.34	39.17	47.01	62.69	94.05
	L2	22.5	6.92	12.15	17.38	22.60	27.83	33.06	40.89	48.73	64.41	95.77
	Z	22.5	9.07	13.90	18.73	23.56	28.38	33.21	40.46	47.70	62.18	91.15
MINIMUM H = 1.62												
	Y	30		3.49	7.49	11.49	15.49	19.49	25.49	31.49	43.49	67.49
	L1	30		7.95	11.95	15.95	19.95	23.95	29.95	35.95	47.95	71.95
	L2	30		10.24	14.24	18.24	22.24	26.24	32.24	38.24	50.24	74.24
	Z	30		11.78	15.24	18.70	22.17	25.63	30.83	36.02	46.42	67.20
MINIMUM H = 2.42												
	Y	45			3.59	6.41	9.23	12.06	16.30	20.55	29.03	46.00
	L1	45			8.30	11.13	13.95	16.78	21.02	25.27	33.75	50.72
	L2	45			11.74	14.57	17.39	20.22	24.46	28.71	37.19	54.16
	Z	45			12.13	14.13	16.13	18.13	21.13	24.13	30.13	42.13
MINIMUM H = 4.33												
	Y	60			1.42	3.73	6.04	8.34	11.81	15.27	22.20	36.06
	L1	60				8.77	11.08	13.39	16.85	20.31	27.24	41.10
	L2	60				13.35	15.66	17.97	21.44	24.90	31.83	45.69
	Z	60				12.18	13.33	14.49	16.22	17.95	21.41	28.34
MINIMUM H = 6.55												
	Y	90				.71	2.71	4.71	7.71	10.71	16.70	28.70
	L1	90						10.12	13.12	16.12	22.12	34.12
	L2	90						17.00	20.00	23.00	29.00	41.00
	Z	90						11.26	11.26	11.26	11.26	11.26
MINIMUM H = 11.26												
3/4" IMC, Rigid, and 40 Mil PVC-Coated Rigid												
	Y	15	1.86	9.58	17.31	25.04	32.77	40.49	52.08	63.68	86.86	133.22
	L1	15	7.72	15.45	23.17	30.90	38.63	46.36	57.95	69.54	92.72	139.08
	L2	15	9.19	16.91	24.64	32.37	40.09	47.82	59.41	71.00	94.19	140.55
	Z	15	12.06	19.53	26.89	34.46	41.92	49.38	60.58	71.78	94.17	138.95
MINIMUM H = 1.19												
	Y	22.5		4.85	10.08	15.31	20.53	25.76	33.60	41.44	57.12	88.47
	L1	22.5		10.42	15.65	20.88	26.10	31.33	39.17	47.01	62.69	94.04
	L2	22.5		12.62	17.85	23.08	28.30	33.53	41.37	49.21	64.89	96.24
	Z	22.5		15.01	19.84	24.67	29.49	34.32	41.57	48.81	63.29	92.26
MINIMUM H = 2.05												
	Y	30		2.33	6.33	10.33	14.33	18.33	24.33	30.33	42.33	66.33
	L1	30		7.93	11.93	15.93	19.93	23.93	29.93	35.93	47.93	71.93
	L2	30		10.86	14.86	18.86	22.86	26.86	32.86	38.86	50.86	74.86
	Z	30		13.05	16.52	19.98	23.45	26.91	32.11	37.30	47.70	68.48
MINIMUM H = 3.06												
	Y	45			2.31	5.13	7.96	10.79	15.03	19.28	27.76	44.73
	L1	45			8.24	11.07	13.90	16.73	20.97	25.21	33.70	50.67
	L2	45			12.64	15.47	18.30	21.13	25.37	29.61	38.10	55.07
	Z	45			13.76	15.76	17.76	19.76	22.76	25.76	31.76	43.76
MINIMUM H = 5.49												
	Y	60				2.28	4.59	6.90	10.36	13.83	20.75	34.61
	L1	60					10.94	13.25	16.72	20.18	27.11	40.97
	L2	60					16.81	19.12	22.58	26.05	32.98	46.83
	Z	60					15.36	16.52	18.25	19.88	23.45	30.38
MINIMUM H = 8.31												
	Y	90					.76	2.76	5.76	8.76	14.76	26.76
	L1	90							12.60	15.60	21.60	33.60
	L2	90							21.39	24.39	30.39	42.39
	Z	90							14.33	14.33	14.33	14.33
MINIMUM H = 14.33												

Additional Bending Tables (cont'd)

	DIM	ANGLE	2"	4"	6"	8"	10"	12"	15"	18"	24"	36"
1" IMC, Rigid, and 40 Mil PVC-Coated Rigid												
	Y	15	1.08	8.81	16.52	24.25	31.97	39.70	51.29	62.88	86.07	132.43
	L1	15	7.72	15.44	23.17	30.90	38.63	46.35	57.94	69.54	92.72	139.08
	L2	15	9.59	17.32	25.04	32.77	40.50	48.23	59.82	71.41	94.59	140.95
	Z	15	12.53	20.00	27.46	34.93	42.39	49.86	61.05	72.25	94.64	139.43
MINIMUM H = 1.31												
	Y	22.5		4.13	9.35	14.58	19.81	25.03	32.87	40.71	56.39	87.75
	L1	22.5		10.42	15.64	20.87	26.09	31.32	39.16	47.00	62.68	94.04
	L2	22.5		13.22	18.45	23.68	28.90	34.13	41.97	49.81	65.49	96.84
	Z	22.5		15.69	20.52	25.35	30.18	35.01	42.25	49.49	63.98	92.95
MINIMUM H = 2.31												
	Y	30		1.58	5.58	9.58	13.58	17.58	23.58	29.58	41.58	65.58
	L1	30		7.91	11.91	15.91	19.91	23.91	29.91	35.91	47.91	71.91
	L2	30		11.66	15.66	19.66	23.66	27.66	33.66	39.66	51.66	75.66
	Z	30		13.95	17.41	20.88	24.34	27.81	33.00	38.20	48.59	69.38
MINIMUM H = 3.51												
	Y	45			1.42	4.24	7.06	9.89	14.14	18.38	26.86	43.83
	L1	45				11.01	13.83	16.66	20.91	25.15	33.63	50.60
	L2	45				16.62	19.45	22.28	26.52	30.76	39.25	56.22
	Z	45				17.11	19.11	21.11	24.11	27.11	33.11	45.11
MINIMUM H = 6.44												
	Y	60				1.17	3.48	5.79	9.25	12.71	19.64	33.49
	L1	60					10.78	13.09	16.55	20.02	26.94	40.80
	L2	60					18.27	20.58	24.04	27.50	34.43	48.29
	Z	60					17.22	18.37	20.11	21.84	25.30	32.23
MINIMUM H = 9.91												
	Y	90						1.01	4.01	7.01	13.01	25.01
	L1	90								14.93	20.93	32.93
	L2	90								26.16	32.16	44.16
	Z	90								17.49	17.49	17.49
MINIMUM H = 17.49												
1-1/4" IMC, Rigid, and 40 Mil PVC-Coated Rigid												
	Y	15		7.15	14.87	22.60	30.33	38.06	49.65	61.24	84.42	130.78
	L1	15	7.71	15.44	23.17	30.90	38.62	46.35	57.94	69.53	92.72	139.08
	L2	15	10.07	17.80	25.53	33.25	40.98	48.71	60.30	71.89	95.07	141.44
	Z	15	13.77	21.24	28.70	36.17	43.63	51.09	62.29	73.49	95.88	140.66
MINIMUM H = 1.63												
	Y	22.5		2.57	7.80	13.02	18.25	23.47	31.31	39.15	54.83	86.19
	L1	22.5		10.41	15.63	20.86	26.09	31.31	39.15	46.99	62.67	94.03
	L2	22.5		13.94	19.17	24.40	29.62	34.85	42.69	50.53	66.21	97.56
	Z	22.5		17.18	22.01	26.84	31.66	36.49	43.73	50.98	65.46	94.43
MINIMUM H = 2.88												
	Y	30			4.00	8.00	12.00	16.00	22.00	28.00	40.00	64.00
	L1	30			11.89	15.89	19.89	23.89	29.89	35.89	47.89	71.89
	L2	30			16.61	20.61	24.61	28.61	34.61	40.61	52.61	76.61
	Z	30			19.16	22.62	26.09	29.55	34.75	39.94	50.33	71.12
MINIMUM H = 4.38												
	Y	45				2.48	5.31	8.14	12.38	16.62	25.11	42.08
	L1	45					13.75	16.58	20.83	25.07	33.55	50.52
	L2	45					20.83	23.66	27.90	32.14	40.63	57.60
	Z	45					21.40	23.40	26.40	29.40	35.40	47.40
MINIMUM H = 8.06												
	Y	60					1.46	3.77	7.23	10.69	17.62	31.48
	L1	60							16.35	19.82	26.74	40.60
	L2	60							25.79	29.25	36.18	50.04
	Z	60							23.00	24.73	28.20	35.13
MINIMUM H = 11.32												
	Y	90							1.23	4.23	10.23	22.23
	L1	90									20.13	32.13
	L2	90									34.29	46.29
	Z	90									21.96	21.96
MINIMUM H = 21.96												

Additional Bending Tables (cont'd)

	DIM	ANGLE	2"	4"	6"	8"	10"	12"	15"	18"	24"	36"
1-1/2" Rigid and 40 Mil PVC-Coated Rigid												
	Y	15		5.87	13.59	21.32	29.05	36.77	48.37	59.96	83.14	129.50
	L1	15	7.71	15.44	23.17	20.90	38.62	46.35	57.94	69.53	92.72	139.08
	L2	15	9.94	17.67	25.39	33.12	40.85	48.58	60.17	71.76	94.94	141.31
	Z	15	14.50	21.97	29.43	36.89	44.36	51.82	63.02	74.21	96.61	141.39
MINIMUM H = 1.82												
	Y	22.5		1.48	6.71	11.93	17.16	22.38	30.22	38.06	53.74	85.10
	L1	22.5		10.41	15.64	20.86	26.09	31.31	39.15	46.99	62.67	94.03
	L2	22.5		13.75	18.97	24.20	29.43	34.65	42.49	50.33	66.01	97.37
	Z	22.5		17.84	22.67	27.50	32.32	37.15	44.39	51.64	66.12	95.09
MINIMUM H = 3.13												
	Y	30			3.02	7.02	11.02	15.02	21.02	27.02	39.02	63.02
	L1	30			11.90	15.90	19.90	23.90	29.90	35.90	47.90	71.90
	L2	30			16.35	20.35	24.35	28.35	34.35	40.35	52.35	76.35
	Z	30			19.75	23.21	26.68	30.14	35.34	40.53	50.92	71.71
MINIMUM H = 4.68												
	Y	45				1.65	4.48	7.31	11.55	15.79	24.28	41.25
	L1	45					13.78	16.60	20.85	25.09	33.58	50.55
	L2	45					20.45	23.28	27.52	31.77	40.25	57.22
	Z	45					21.84	23.84	26.84	29.84	35.84	47.84
MINIMUM H = 8.37												
	Y	60					0.74	3.05	6.52	9.98	16.91	30.76
	L1	60							16.41	19.87	26.80	40.66
	L2	60							25.31	28.77	35.70	49.56
	Z	60							23.28	25.01	28.47	35.40
MINIMUM H = 12.66												
	Y	90							0.75	3.75	9.75	21.75
	L1	90									20.35	32.35
	L2	90									33.70	45.70
	Z	90									21.80	21.80
MINIMUM H = 21.80												
2" Rigid and 40 Mil PVC-Coated Rigid												
	Y	15		4.42	12.15	19.87	27.60	35.33	46.92	58.51	81.69	128.06
	L1	15	7.71	15.44	23.17	30.89	38.62	46.35	57.94	69.53	92.71	139.08
	L2	15	10.27	18.00	25.73	33.46	41.18	48.91	60.50	72.09	95.27	141.64
	Z	15	15.20	22.66	30.13	37.59	45.06	52.52	63.72	74.91	97.30	142.09
MINIMUM H = 2.00												
	Y	22.5		0.24	5.47	10.70	15.92	21.15	28.99	36.83	52.51	83.86
	L1	22.5		10.40	15.63	20.85	26.08	31.31	39.15	46.99	62.66	94.02
	L2	22.5		14.24	19.47	24.70	29.92	35.15	42.99	50.83	66.51	97.86
	Z	22.5		18.71	23.54	28.36	33.19	38.02	45.26	52.51	66.99	95.96
MINIMUM H = 3.47												
	Y	30			1.84	5.84	9.84	13.84	19.84	25.84	37.84	61.84
	L1	30			11.88	15.88	19.88	23.88	29.88	35.88	47.88	71.88
	L2	30			17.00	21.00	25.00	29.00	35.00	41.00	53.00	77.00
	Z	30			20.79	24.26	27.72	31.19	36.38	41.58	51.97	71.75
MINIMUM H = 5.20												
	Y	45				0.42	3.25	6.08	10.32	14.57	23.05	40.02
	L1	45					13.72	16.55	20.79	25.04	33.52	50.49
	L2	45					21.40	24.23	28.47	32.72	41.20	58.17
	Z	45					23.26	25.26	28.26	31.26	37.26	49.26
MINIMUM H = 9.38												
	Y	60						1.68	5.14	8.61	15.54	29.39
	L1	60							16.27	19.73	26.66	40.52
	L2	60							26.51	29.97	36.90	50.76
	Z	60							25.11	26.85	30.31	37.24
MINIMUM H = 14.25												
	Y	90								1.87	7.87	19.87
	L1	90										31.80
	L2	90										47.16
	Z	90										24.72
MINIMUM H = 24.72												

Additional Bending Tables (cont'd)

	DIM	ANGLE	2"	4"	6"	8"	10"	12"	15"	18"	24"	36"
1-1/2" IMC												
	Y	15		6.41	14.14	21.87	29.60	37.32	48.91	60.51	83.69	130.05
	L1	15	7.71	15.44	23.17	30.90	38.62	46.35	57.94	69.53	92.72	139.00
	L2	15	9.95	17.68	25.40	33.13	40.86	48.58	60.18	71.77	94.94	141.31
	Z	15	13.99	21.45	28.92	36.38	43.85	51.31	62.51	73.70	96.10	140.88
MINIMUM H = 1.69												
	Y	22.5		2.02	7.24	12.47	17.69	22.92	30.76	38.60	54.28	85.64
	L1	22.5		10.41	15.64	20.86	26.09	31.31	39.15	46.99	62.67	94.03
	L2	22.5		13.76	18.98	24.21	29.44	34.66	42.50	50.34	66.02	97.38
	Z	22.5		17.33	22.16	26.99	31.82	36.64	43.89	51.13	65.61	94.59
MINIMUM H = 2.94												
	Y	30			3.55	7.55	11.55	15.55	21.55	27.55	39.55	63.55
	L1	30			11.90	15.90	19.90	23.90	29.90	35.90	47.90	71.90
	L2	30			16.36	20.36	24.36	28.36	34.36	40.36	52.36	76.36
	Z	30			19.24	22.71	26.17	29.64	34.83	40.03	50.42	71.21
MINIMUM H = 4.43												
	Y	45				2.17	5.00	7.83	12.07	16.31	24.80	41.77
	L1	45					13.78	16.60	20.85	25.09	33.57	50.54
	L2	45					20.47	23.30	27.55	31.79	40.27	57.24
	Z	45					21.35	23.35	26.35	29.35	35.35	47.35
MINIMUM H = 8.02												
	Y	60					1.26	3.56	7.03	10.49	17.42	31.28
	L1	60							16.40	19.87	26.80	40.65
	L2	60							25.34	28.80	35.73	49.58
	Z	60							22.79	24.52	27.99	34.91
MINIMUM H = 12.24												
	Y	90							1.25	4.25	10.25	22.25
	L1	90									20.34	32.34
	L2	90									33.74	45.74
	Z	90									21.34	21.34
MINIMUM H = 21.34												
2" IMC												
	Y	15		5.04	12.77	20.50	28.22	35.95	47.54	59.13	82.31	128.68
	L1	15	7.71	15.44	23.17	30.90	38.62	46.35	57.94	69.53	92.71	139.00
	L2	15	10.19	17.92	25.64	33.37	41.10	48.83	60.42	72.01	95.19	141.56
	Z	15	14.56	22.03	29.49	36.96	44.42	51.89	63.00	74.28	96.67	141.45
MINIMUM H = 1.84												
	Y	22.5		0.88	6.10	11.33	16.56	21.78	29.62	37.46	53.14	84.50
	L1	22.5		10.40	15.63	20.86	26.08	31.31	39.15	46.99	62.67	94.02
	L2	22.5		14.12	19.35	24.57	29.80	35.02	42.86	50.70	66.38	97.74
	Z	22.5		18.03	22.86	27.69	32.52	37.34	44.59	51.83	66.31	95.29
MINIMUM H = 3.20												
	Y	30			2.50	6.50	10.50	14.50	20.50	26.50	38.50	62.50
	L1	30			11.88	15.88	19.88	23.88	29.88	35.88	47.88	71.88
	L2	30			16.84	20.84	24.84	28.84	34.84	40.84	52.84	76.84
	Z	30			20.07	23.54	27.00	30.46	35.66	40.86	51.25	72.03
MINIMUM H = 4.84												
	Y	45				1.12	3.94	6.77	11.02	15.26	23.74	40.71
	L1	45					13.74	16.56	20.81	25.05	33.53	50.50
	L2	45					21.16	23.99	28.24	32.48	40.96	57.93
	Z	45					22.45	24.45	27.45	30.45	36.45	48.45
MINIMUM H = 8.80												
	Y	60					0.11	2.42	5.89	9.35	16.28	20.13
	L1	60							16.30	19.77	26.70	20.55
	L2	60							26.21	29.67	36.60	50.46
	Z	60							24.19	25.93	29.39	26.32
MINIMUM H = 13.45												
	Y	90								2.75	8.75	20.75
	L1	90									19.94	31.94
	L2	90									34.80	46.80
	Z	90									23.53	23.53
MINIMUM H = 23.53												

Handle Removal and Replacement

The handle of the 555C is designed to be removable. This feature is convenient when performing complex bending, and makes it easy to replace a damaged handle.

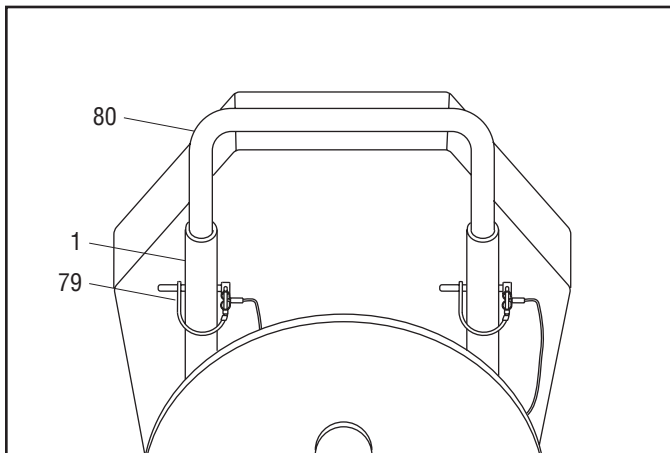
Removal

1. Place the bender in the upright position.
2. Release the spring clip on the safety snap pin (79).
3. Remove the pin from the handle (80) and the sleeve of the frame (1).
4. Repeat Steps 1 through 3 for the other end of the handle.
5. Lift the handle to remove.

Replacement

1. Insert the handle (80) into the sleeves of the frame (1).
2. Align the holes in the handle with the holes in the sleeves.
3. Insert the safety snap pin (79). Ensure that the pin goes through the handle and the sleeve on the frame (1).
4. Engage the safety spring clip over the end of the pin. Ensure that the loop on the clip is completely around the pin.
5. Repeat Steps 2 through 4 for the other end of the handle.

Removing or Replacing Handle



Transportation

⚠ WARNING

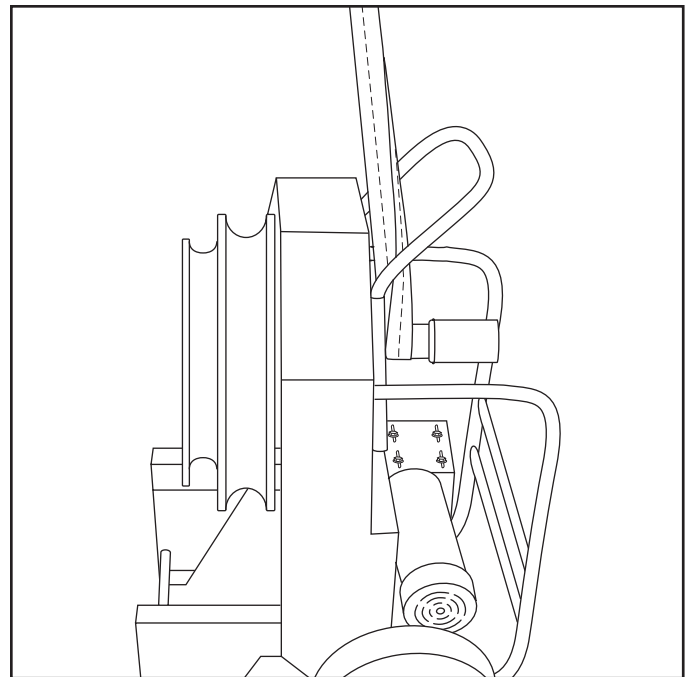
Make sure that the handle is properly installed and secured with the safety spring clips and snap pins before lifting or moving the bender. An improperly installed handle could allow the bender to fall, injuring nearby personnel.

Failure to observe this warning could result in severe injury or death.

The only proper way to lift this bender is by attaching a nylon or polyester sling around the storage spindle. The sling should extend between the handle and main frame of the bender so that the handle acts as a guide for the sling, as shown.

Make sure that all components used to lift this bender are properly rated for the 159 kg (350 lb) weight. Use a ramp to load and unload from a truck or other vehicle that is not equipped with a lift gate.

Transporting Bender




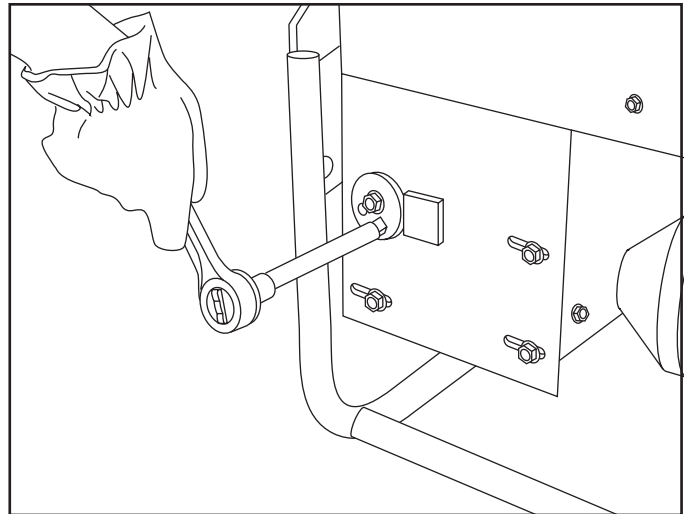
Maintenance

There is no need for periodic flushing and replacing of lube in the bender gear box since it is sealed and locked tight. However, if the box is opened for repair and the lube is lost or contaminated by dirt, then the box and parts should be flushed out and filled with 26 fluid ounces of Mobil® 634 synthetic oil.

Flushing should be accomplished with kerosene, which is a petroleum hydrocarbon that does not affect seals.

Note: Aromatic hydrocarbons such as benzene, chlorinated solvents such as carbon-tetrachloride, and ketones such as acetone should never be used for flushing as they are solvents for rubber. They are also harmful to the environment.

	⚠ WARNING
	<p>Disconnect this tool when not in use, before servicing or adjusting, and when changing shoes or conduit rollers and supports.</p> <p>Failure to observe this warning could result in severe injury or death.</p>

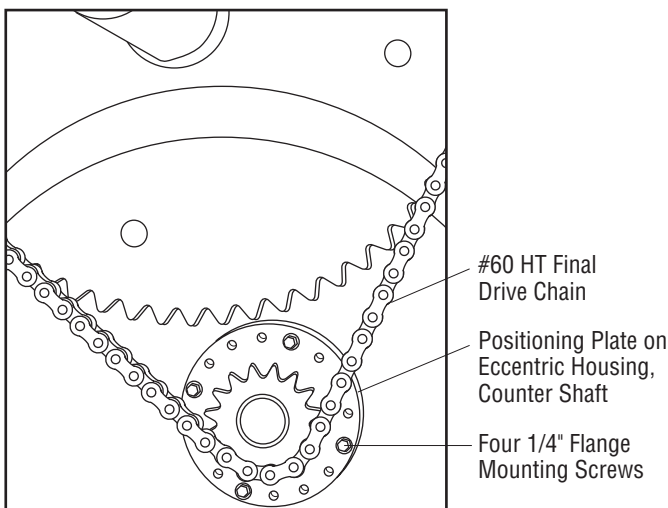
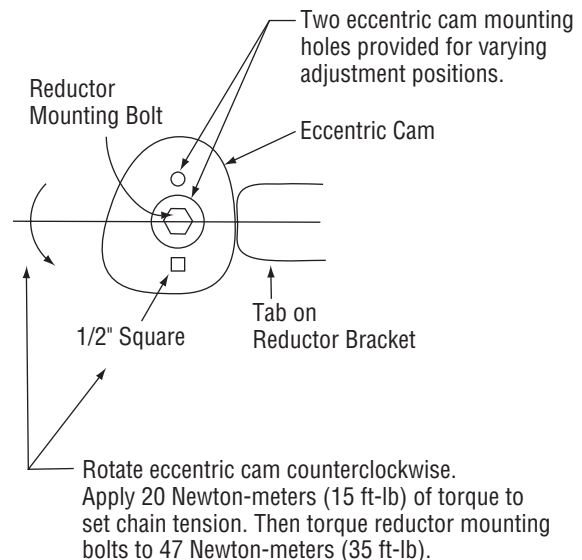


With the eight reducer mounting bolts (22, 24) loose, rotate the eccentric cam with a 1/2" square drive to tension the chain. Torque the eight reducer mounting bolts to 47 Newton-meters (35 ft-lb).

Chain Adjustment

Both chains have to be adjusted if the final drive #60 chain is to be reset. Refer to the Exploded View and Parts List.

1. Remove the front cover (38) and upper rear guard (37).
2. Loosen the eight mounting bolts for the reducer (19). Remove the eccentric cam and move the reducer to create chain slack.
3. Remove the four retaining screws for eccentric adjustment. Rotate to remove slack from the chain and align with one of the two sets of holes in the frame. Remount the eccentric with the four bolts.
4. Slide the reducer in slotted mounting holes to the retention chain. Set tension with the eccentric cam.




Troubleshooting

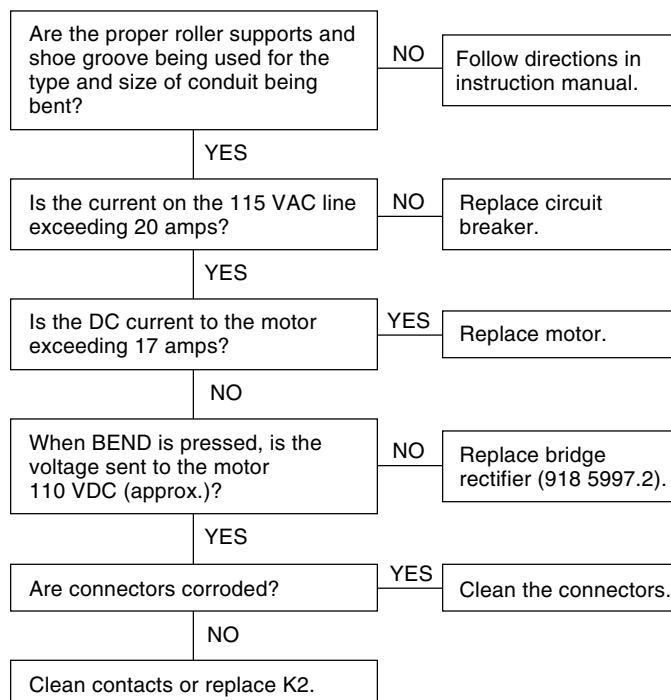
Problem	Probable Cause	Possible Remedy
Bender will not operate.	No voltage.	Check supply voltage circuit operation. Check that switch is on.
Bends are overbent a few degrees.	Too much squeeze on 1-1/2" or 2" EMT or IMC conduit. Unusual conduit characteristics.	Back squeeze off per adjustment instructions. Bend smaller angle to compensate.
Bends are underbent a few degrees.	Too little squeeze on 1-1/2" or 2" EMT or IMC conduit. Unusual conduit characteristics.	Increase squeeze per adjustment instructions. Bend larger angle to compensate.

Troubleshooting (cont'd)

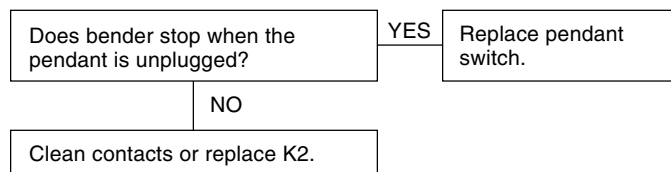
The following flow charts show the suggested troubleshooting procedures for some bender problems. They by no means encompass all possible problems or solutions.

	⚠ WARNING
	<p>Electric shock hazard:</p> <ul style="list-style-type: none"> • Contact with live circuits can result in severe injury or death. • Some troubleshooting steps require power to the bender. This type of troubleshooting step should only be performed at authorized Greenlee service centers by personnel who are familiar with safe troubleshooting procedures. <p>Failure to observe these warnings could result in severe injury or death.</p>

Trips 555C switch/circuit breaker

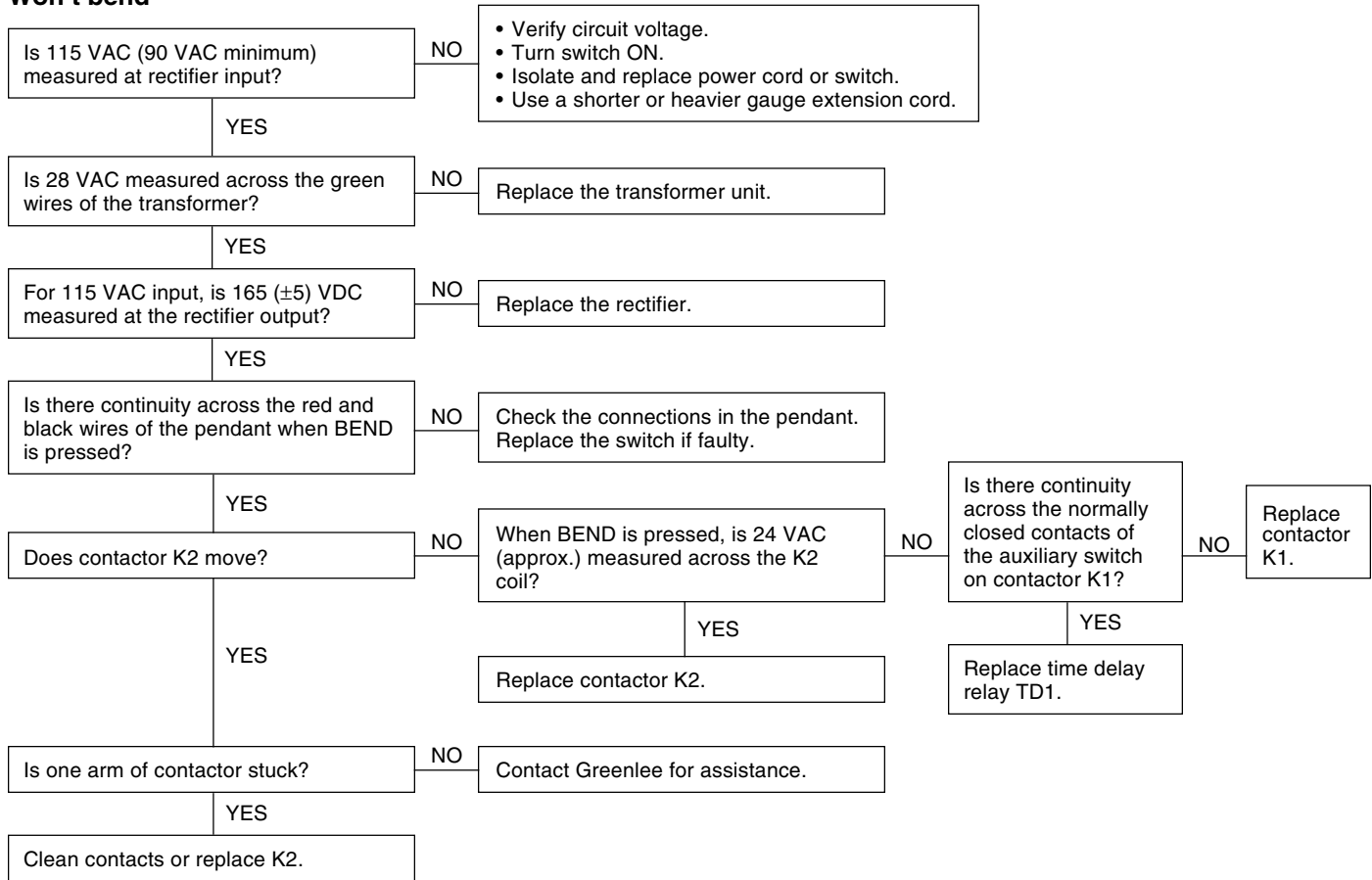


Won't stop

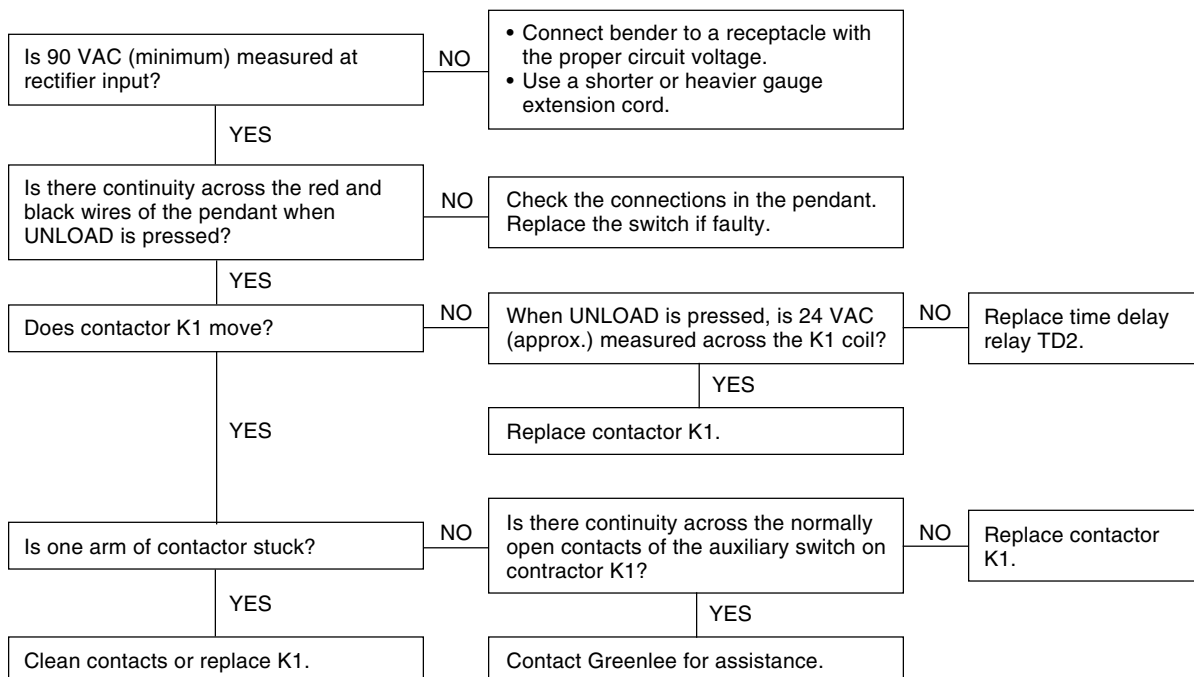


Troubleshooting (cont'd)

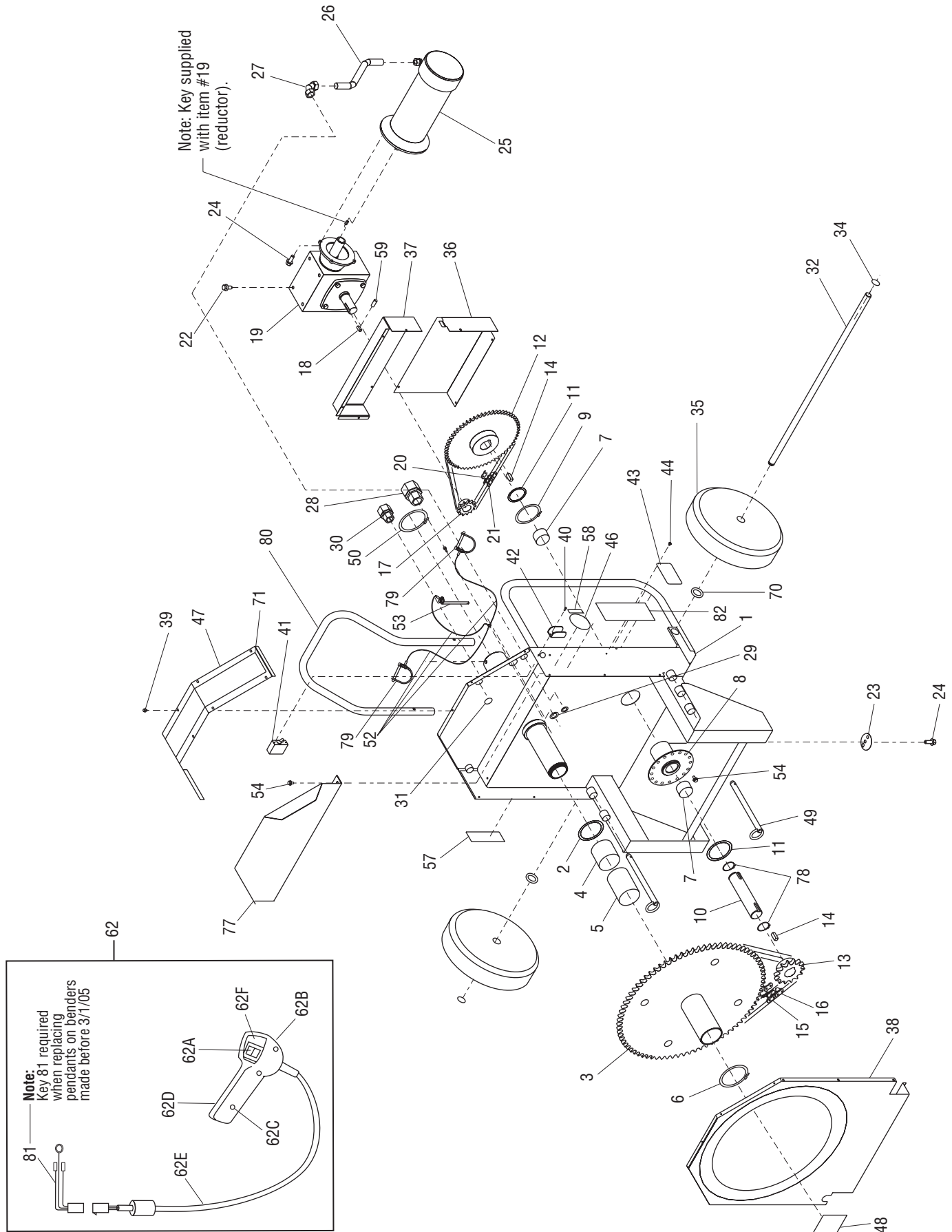
Won't bend



Bender runs only in the BEND direction



Exploded View — 555C Electric Bender Classic

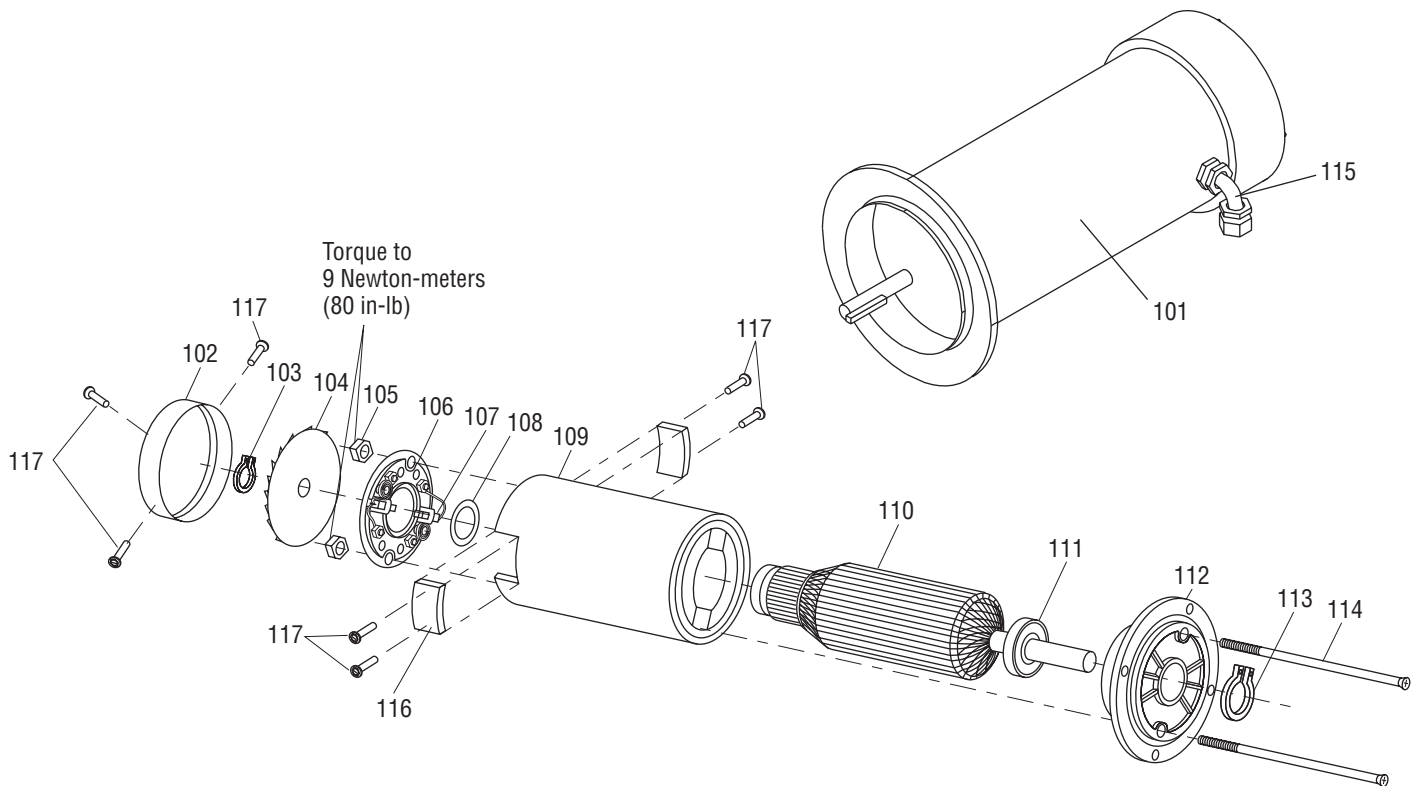


Parts List — 555C Electric Bender Classic

Key	Part No.	Description	Qty
1	50397427	Weldment, main frame	1
2	50234528	Washer, fiber	1
3	50328964	Weldment, sprocket unit	1
4	90524098	Bearing, Fiberglide® ø2.625 x 2.5 long	1
5	90524101	Bearing, Fiberglide ø2.625 x 3.75 long	1
6	90524144	Ring, retaining #5100-237	1
7	90524128	Bearing, Fiberglide ø1.625 x 1.00 long	2
8	50397630	Weldment, countershaft	1
9	90540239	Ring, retaining #5100-250	1
10	50397648	Countershaft	1
11	90524136	Bearing, thrust Fiberglide	2
12	90545486	Sprocket, #40 60T	1
13	90542533	Sprocket, #60 14T	1
14	50397656	Key, countershaft	2
15	90545460	Chain, #60 87P	1
16	90542517	Masterlink, #60	1
17	90545478	Sprocket, #40 13T	1
18	50084313	Key, reductor sprocket	1
19	90523881	Reductor, worm gear	1
20	90527879	Masterlink, #40	1
21	90545516	Chain, #40 87P	1
22	90545680	Bolt, 3/8–16 UNC x .75	7
23	50397583	Eccentric	1
24	90542371	Bolt, 3/8–16 UNC x 1.00	5
25	91869730	Motor	1
26	90545494	Conduit, Sealtight	1
27	91852145	Elbow, Sealtight	1
28	91866839	Strain relief	1
29	90511700	Nut, 3/4 conduit lock	1
30	91867673	Strain relief, pendant switch	1
31	91862639	Nut, 1/2 conduit lock	1
32	50397575	Axle	1
34	90515285	Ring, retaining #5160-75	2
35	90533909	Wheel	2
36	50397680	Guard, rear lower	1
37	50397699	Guard, rear upper	1
38	50397605	Cover, front	1
39	90516559	Screw, #10–16 x .50 hex head	31
40	90504305	Screw, #6–32 x .375 Phillips	2
41	91863856	Switch, air pax	1
42	50297082	Guard, switch	1
43	50069055	Nameplate	1
44	90530012	Rivet, pop 1/8 x 1/8 drive	4

Parts List — 555C Electric Bender Classic (cont'd)

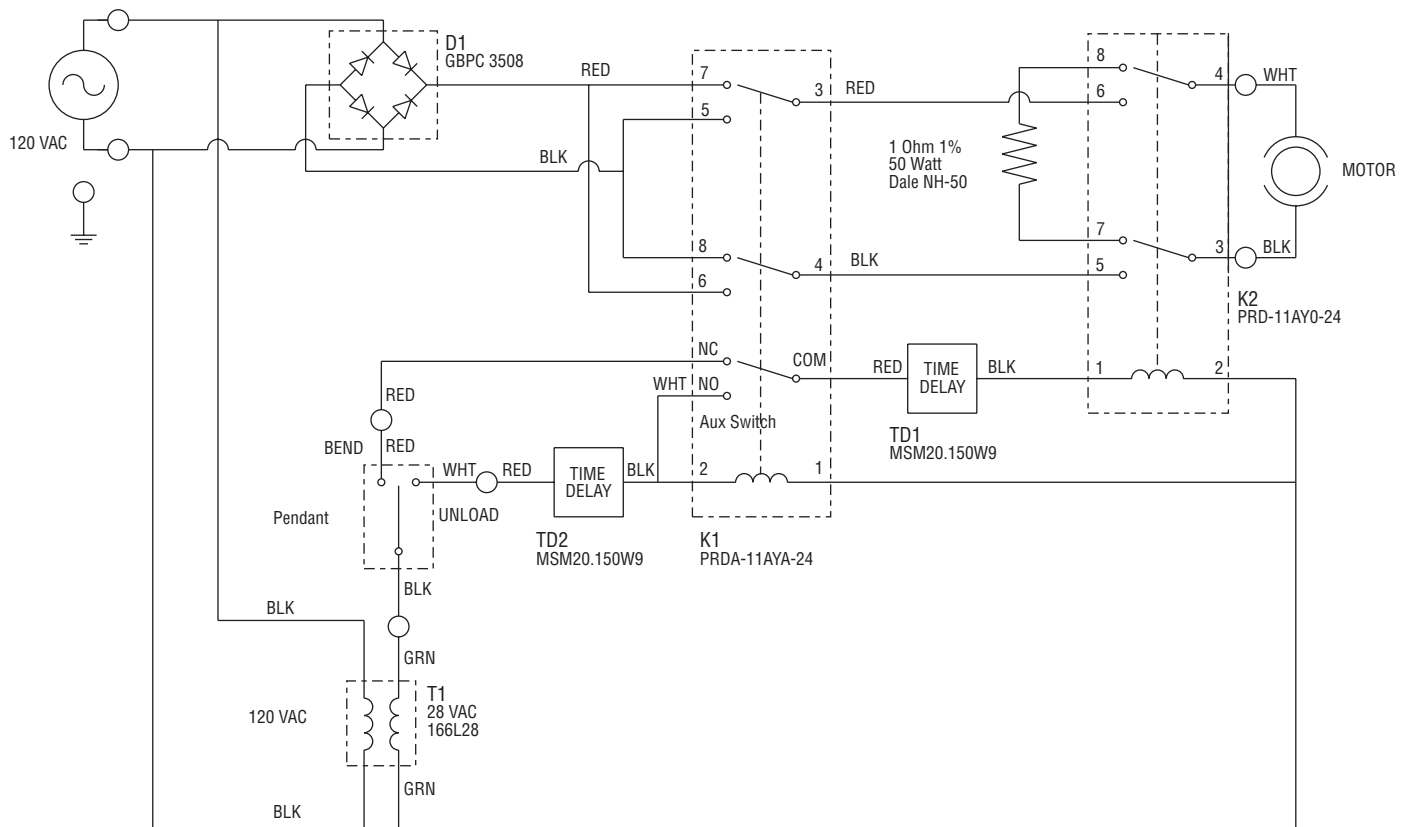
Key	Part No.	Description	Qty
46	50303929	Decal, damp warning	1
47	50397591	Cover, top	1
49	90533895	Pin, hitch	2
50	90525019	Ring, retaining #5100-287	1
52	90545524	Lanyard	3
53	90545451	Pin, hitch	1
54	90543351	Screw, 1/4 x .37 thread-forming	6
57	50339370	Decal, squeeze adjust	1
58	50389742	Decal, circuit breaker	1
59	90553233	Pin, DRIV-LOK®, 1/8 x 1/2	1
61	50079123	Power cord, Twist-Lock 20 Amp	1
62	50398393	Switch, pendant (complete assembly with Molex plug)	1
62A	91864496	Switch, center OFF	1
62B	50319027	Handle, right half	1
62C	90534417	Screw, #6–20 x .625 pan head, self-tapping	3
62D	50319019	Handle, left half	1
62E	50398377	Cord	1
62F	50354876	Decal, faceplate	1
70	90517407	Washer, flat	2
71	50024973	Decal, instruction	1
77	50068890	Electronic control assembly	1
78	90510518	Ring, retaining #5100-150	2
79	90552687	Pin, safety snap	2
80	50397486	Handle, upper	1
81	50120620	Adapter, with Molex plug (required when replacing pendant switch on units made prior to 3/1/05)	1
82	52025721	Decal, safety/warning	1

Exploded View and Parts List — 115 Volt Motor

Pacific Scientific

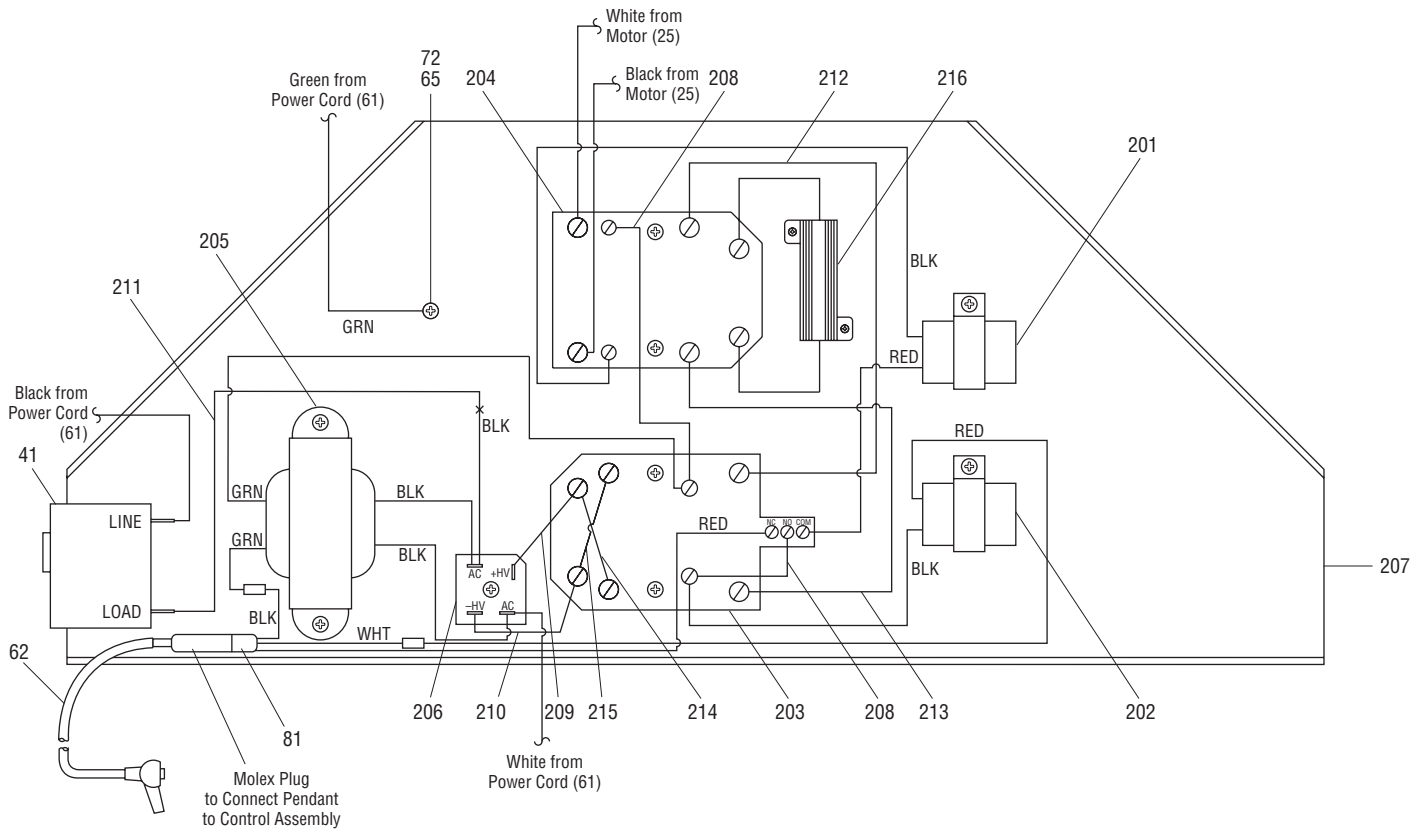
Key	Part No.	Description	Qty
101	91869730	Motor (SRF-3648-5532-7-56C)	1
*	91864178	Motor, 115 Volt (standard) (SRF-3745-4676-2-56C)	1
102	91864712	Fan cover	1
103	90550714	Retaining ring	1
104	91864321	Fan	1
105	91864283	End bell nut	2
106	91864194	Bell, rear end	1
107	91864208	Brush	2
108	91864224	Thrust washer	1
109	91869757	Shell and magnet assembly	1
*	91864275	Shell and magnet assembly, 115V	1
110	91869749	Armature	1
*	91864259	Armature, 115V	1
111	91864216	Bearing kit	2
112	91864186	Bell, front end	1
113	91864240	Retaining ring	1
114	91864267	Tie bolt, 115V	2
115	91858763	90° Connector	1
116	91864305	Brush cover	2
117	91864313	Cover screw	7

**Note: Alternate motor
Check motor part number before ordering magnet shell or armature.*

Schematic Diagram



Control Assembly



Electronic Control Assembly — Part No. 50068890

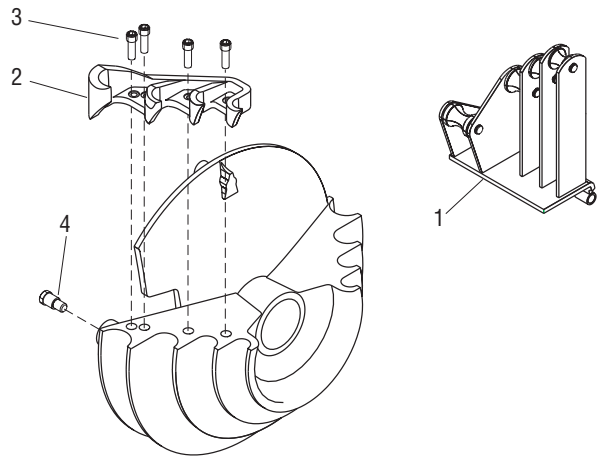
Key	Schematic Reference	Part No.	Description	Qty
201	TD1	50069152	Timer assembly, 150 ms ON Delay	1
202	TD2	50069071	Timer assembly, 150 ms ON Delay	1
203	K1	91869668	Relay, power, DPDT (with switch)	1
204	K2	91869676	Relay, power, DPDT	1
205	T1	50069080	Transformer assembly	1
206	D1	91859972	Bridge rectifier	1
207		50068954	Bracket, electrical mounting	1
208		50068962	Wire harness, 14 AWG	2
209		50060341	Wire harness, 12 AWG (RED)	1
210		50060350	Wire harness, 12 AWG (BLK)	1
211		50069160	Wire unit, BLK Rectifier	1
212		50068989	Wire harness, 12 AWG (RED)	1
213		50068997	Wire harness, 12 AWG (BLK)	1
214		50060481	Wire harness, 12 AWG (RED)	1
215		50060490	Wire harness, 12 AWG (BLK)	1
216		50060511	Resistor unit with leads	1
65		90543297	Screw, #8–32 x .37 ground	1
72		90537246	Washer, internal tooth lock	1
81		50120620	Adapter with Molex Plug	1

Bending Shoes and Roller Supports

Bending Shoe and Roller Support 1/2" to 1-1/4" IMC and Rigid Conduit

Key	Part No.	Description	Qty
1	50009362	Roller support, 1/2" to 1-1/4" IMC and rigid	1
	50005715	Bending shoe assembly (includes items 2-4) ...	1
2	50005693	Hook	1
3	90510887	Screw, 3/8-16 UNC x 1-1/4" socket head cap ..	4
4	50234226	Stud, drive	3

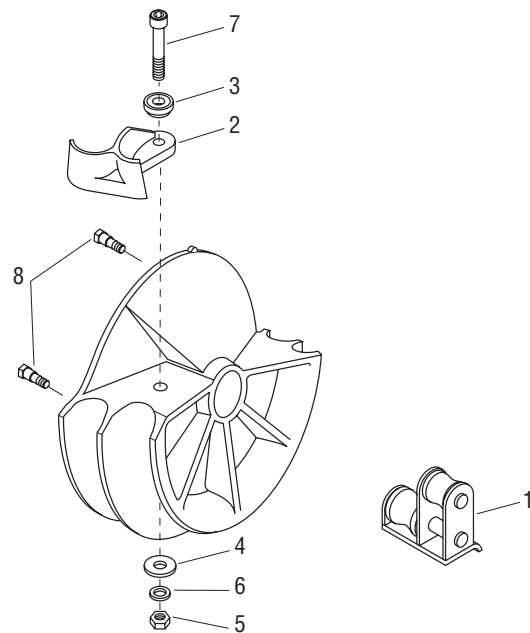
Shoe not available separately.



Bending Shoe and Roller Support 1-1/2" to 2" Rigid Conduit

Key	Part No.	Description	Qty
1	50179845	Roller support, 1-1/2" to 2" rigid conduit	1
	50179373	Bending shoe assembly, 1-1/2" to 2" rigid conduit (includes items 2-8)	1
2	50179691	Pipe hook	1
3	50179748	Pivot	1
4	90526759	Washer, 5/8 flat	1
5	90515692	Nut, 5/8-11 UNC hex	1
6	90509056	Lock washer, 5/8 split	1
7	90524268	Screw, 5/8-11 UNC x 4" socket head cap	1
8	50234226	Stud, drive	4

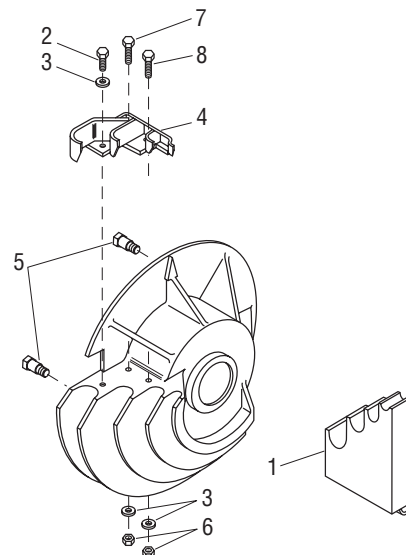
Shoe not available separately.



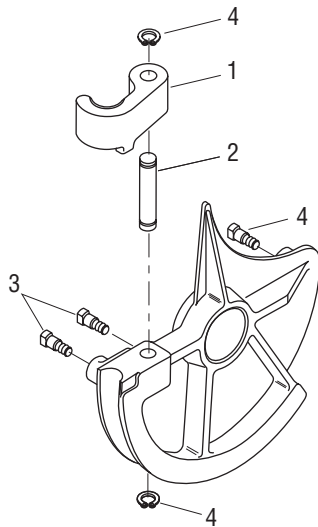
Bending Shoe and Pipe Rest 1/2" to 1-1/4" EMT Conduit

Key	Part No.	Description	Qty
1	50179861	Pipe rest assembly for 1/2" to 1-1/4" EMT conduit	1
	50179446	Bending shoe assembly for 1/2" to 2-1/4" EMT conduit (includes items 2-8)	1
2	90505972	Screw, 3/8-16 UNC x 1" socket head cap	1
3	90505069	Lock washer, 3/8 split	3
4	50245554	Pipe hook	1
5	50234226	Stud, drive	4
6	90506391	Nut, 3/8-16 UNC hex, cad.-plated	2
7	90505328	Screw, 3/8-16 UNC x 1-1/4 SAE grade 5 socket head cap	1
8	90510887	Screw, 3/8-16 UNC x 1-1/4 socket head	1

Shoe not available separately.

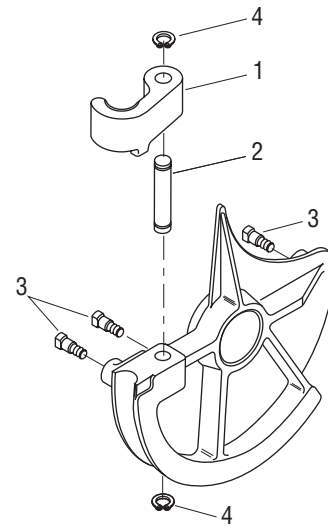


Bending Shoes and Roller Supports (cont'd)



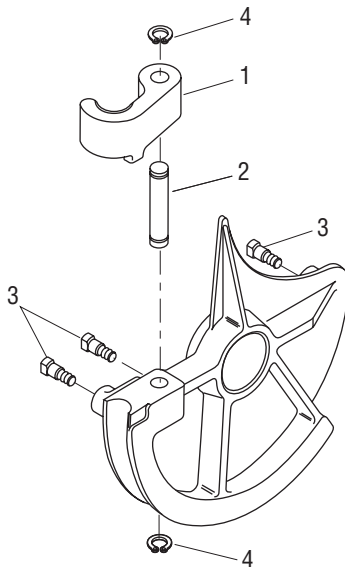
Bending Shoe 1-1/2" EMT Conduit

Key	Part No.	Description	Qty
	50234994	Shoe unit, 1-1/2" EMT (includes items 1-4)	1
1	50188208	Hook, 1-1/2" EMT	1
2	50188410	Pin, 1-1/2" EMT hook	1
3	50234226	Stud, drive	3
4	90515293	Ring, Tru-Arc #5160-87 retaining	2



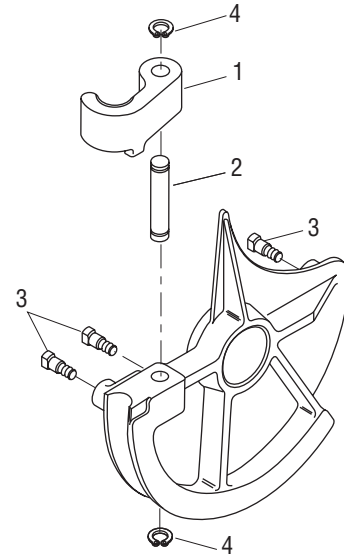
Bending Shoe 1-1/2" IMC Conduit

Key	Part No.	Description	Qty
	50253631	Shoe unit, 1-1/2" IMC (includes items 1-4)	1
1	50188119	Hook, 1-1/2" IMC	1
2	50188372	Pin, 1-1/2" IMC	1
3	50234226	Stud, drive	3
4	90515285	Ring, Tru-Arc retaining	2



Bending Shoe 2" EMT Conduit

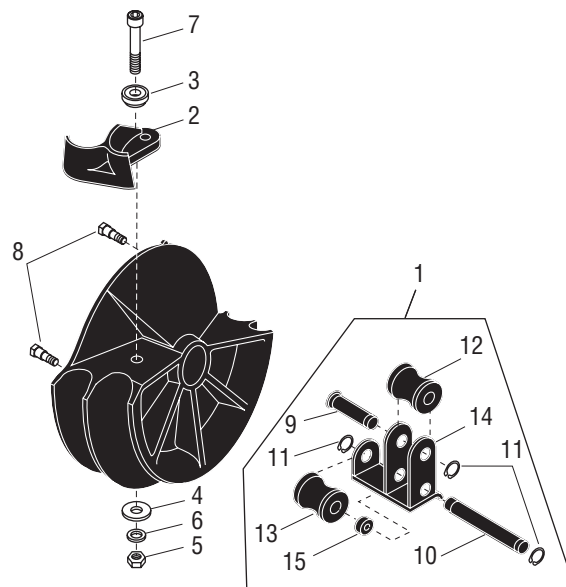
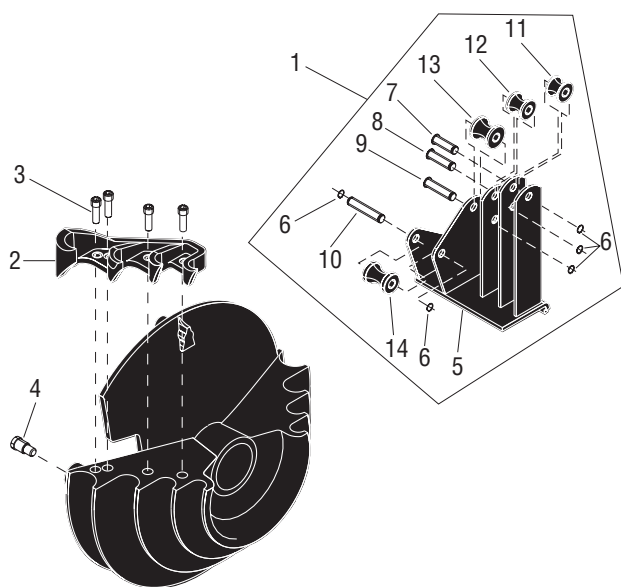
Key	Part No.	Description	Qty
	50235052	Shoe unit, 2" EMT conduit (includes items 1-4)	1
1	50188186	Hook, 2" EMT	1
2	50188429	Pin, 2" EMT hook	1
3	50234226	Stud, drive	3
4	90515293	Ring, Tru-Arc #5160-87, retaining	2



Bending Shoe 2" IMC Conduit

Key	Part No.	Description	Qty
	50252682	Shoe unit, 2" IMC (includes items 1-4)	1
1	50001957	Hook, 2" IMC	1
2	50188429	Pin, 2" IMC	1
3	50234226	Stud, drive	3
4	90515293	Ring, Tru-Arc retaining	2

Bending Shoes and Roller Supports (cont'd)



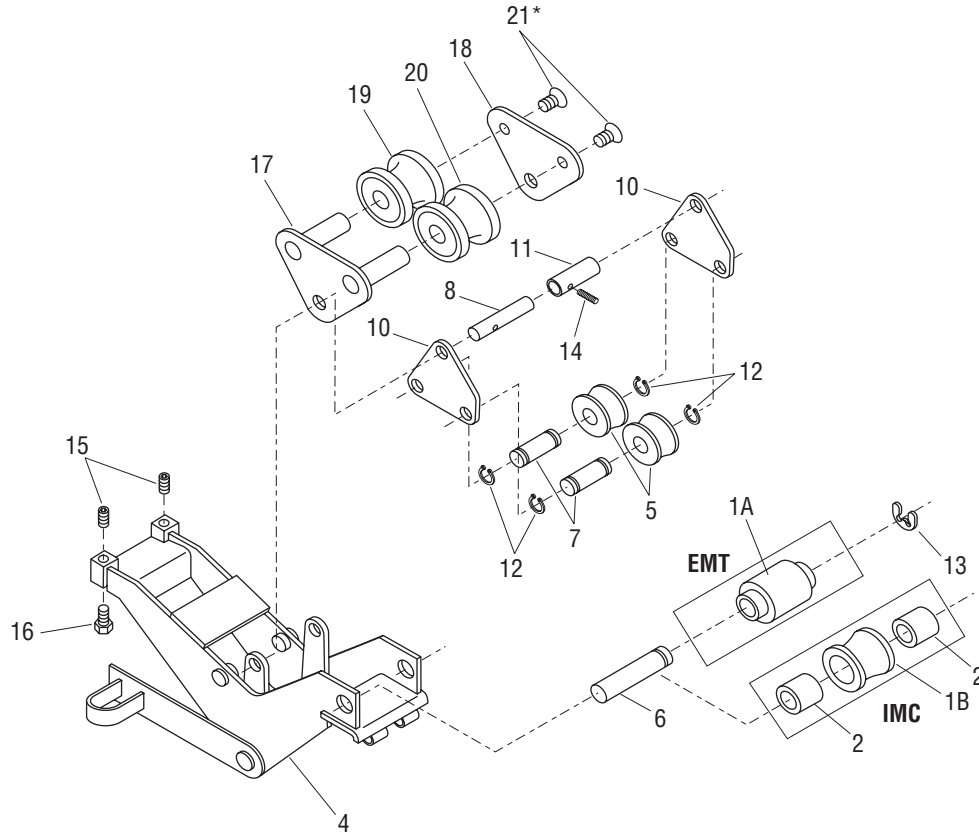
Bending Shoe and Roller Support 1/2" to 1-1/4" 40 Mil PVC-Coated Rigid Conduit

Key	Part No.	Description	Qty
1	50009460	Roller support, 1/2" to 1-1/4" PVC-coated rigid (includes items 5–14)	1
	50005731	Bending shoe assembly, 1/2" to 1-1/4" PVC-coated rigid (includes items 2–4)	1
2	50005707	Hook	1
3	90510887	3/8–16 UNC x 1-1/4" Socket head cap screw	4
4	50234226	Stud, drive	3
5	50009451	Support weldment, roller	1
6	90513533	Retaining ring	5
7	50009230	1/2" Roller axle	1
8	50009249	3/4" Roller axle	1
9	50009257	1" Roller axle	1
10	50009265	1-1/4" Roller axle	1
11	50009273	1/2" Roller	1
12	50009281	3/4" Roller	1
13	50009290	1" Roller	1
14	50009303	1-1/4" Roller	1

Bending Shoe and Roller Support 1-1/2" to 2" 40 Mil PVC-Coated Rigid Conduit

Key	Part No.	Description	Qty
1	50372823	Roller support, 1-1/2" to 2" PVC-coated rigid (includes items 9–15)	1
	50372815	Bending shoe assembly, 1-1/2" to 2" PVC (includes items 2–8)	1
2	50024990	Hook	1
3	50179748	Pivot	1
4	90526759	5/8" Flat washer	1
5	90515692	5/8–11 UNC Hex nut	1
6	90509056	5/8" Lock washer	1
7	90524268	5/8–11 UNC x 4" Socket head cap screw	1
8	50234226	Stud, drive	4
9	50376624	1-1/2" Shaft	1
10	50376616	2" Shaft	1
11	90515285	Retaining ring	3
12	50372840	1-1/2" Roller	1
13	50372831	2" Roller	1
14	50376640	Support weldment	1
15	50320254	Spacer	1

Bending Shoes and Roller Supports (cont'd)



EMT Roller Support Unit

Key	Part No.	Description	Qty
	50235419	Support unit, 1-1/2" and 2" EMT roller (includes all of the following)	1
1A	50279831	Roller unit, cushioned	1
4	50235397	Frame unit	1
5	50235109	Roller, 1-1/2" EMT	2
6	50235117	Pin, roller support	1
7	50239325	Pin, 1-1/2" EMT roller	2
8	50235176	Pin, roller pivot	1
10	50235249	Plate, 1-1/2" EMT pivot	2
11	50237934	Spacer	1
12	90515285	Ring, retaining	4
13	90524640	Ring, Tru-Arc #X5133-98 external series "E" retaining	1
14	90514912	Rollpin, #59, -040-187-1250	1
15	90528484	Screw, 1/2-13 UNC x 3/4 cup point socket set	2
16	90505425	Screw, 1/2-13 UNC x 1, hex head cap	2
17	50349643	Support weldment, 2" roller	1
18	50349651	Plate, 2" inner roller support	1
19	50235192	Roller, 2" EMT front	1
20	50237926	Roller, 2" EMT back	1
21*	90533941	Screw, 7/16-14 UNC x 1, flat head	2

IMC Roller Support Unit

Key	Part No.	Description	Qty
	50252739	Support unit, 1-1/2" and 2" IMC roller (includes items 1 and 2)	1
1B	50283340	Roller	1
2	50283359	Spacer	2
4	50263250	Frame unit	1
5	50252747	Roller, 1-1/2" IMC	2
6	50235117	Pin, roller support	1
7	50239325	Pin, 1-1/2" IMC roller	2
8	50235176	Pin, roller pivot	1
10	50235249	Plate, 1-1/2" IMC pivot	2
11	50237934	Spacer	1
12	90515285	Ring, retaining	4
13	90524640	Ring, Tru-Arc #X5133-98 external series "E" retaining	1
14	90514912	Rollpin, #59, -040-187-1250	1
15	90528484	Screw, 1/2-13 UNC x 3/4 cup point socket set	2
16	90505425	Screw, 1/2-13 UNC x 1, hex head cap	2
17	50349643	Support weldment, 2" roller	1
18	50349651	Plate, 2" inner roller support	1
19	50252798	Roller, 2" IMC	2
21*	90533941	Screw, 7/16-14 UNC x 1, flat head	2

*Key No. 21 must be torqued to 54 to 61 Newton-meters (40 to 45 ft-lb).



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