

# **#1 HAND BENDER**

## **OPERATION AND PARTS MANUAL**



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## SAFETY INFORMATION



**Before bender is set up for operation, mount on work bench or stand\* with stand or work bench bolted in place.**

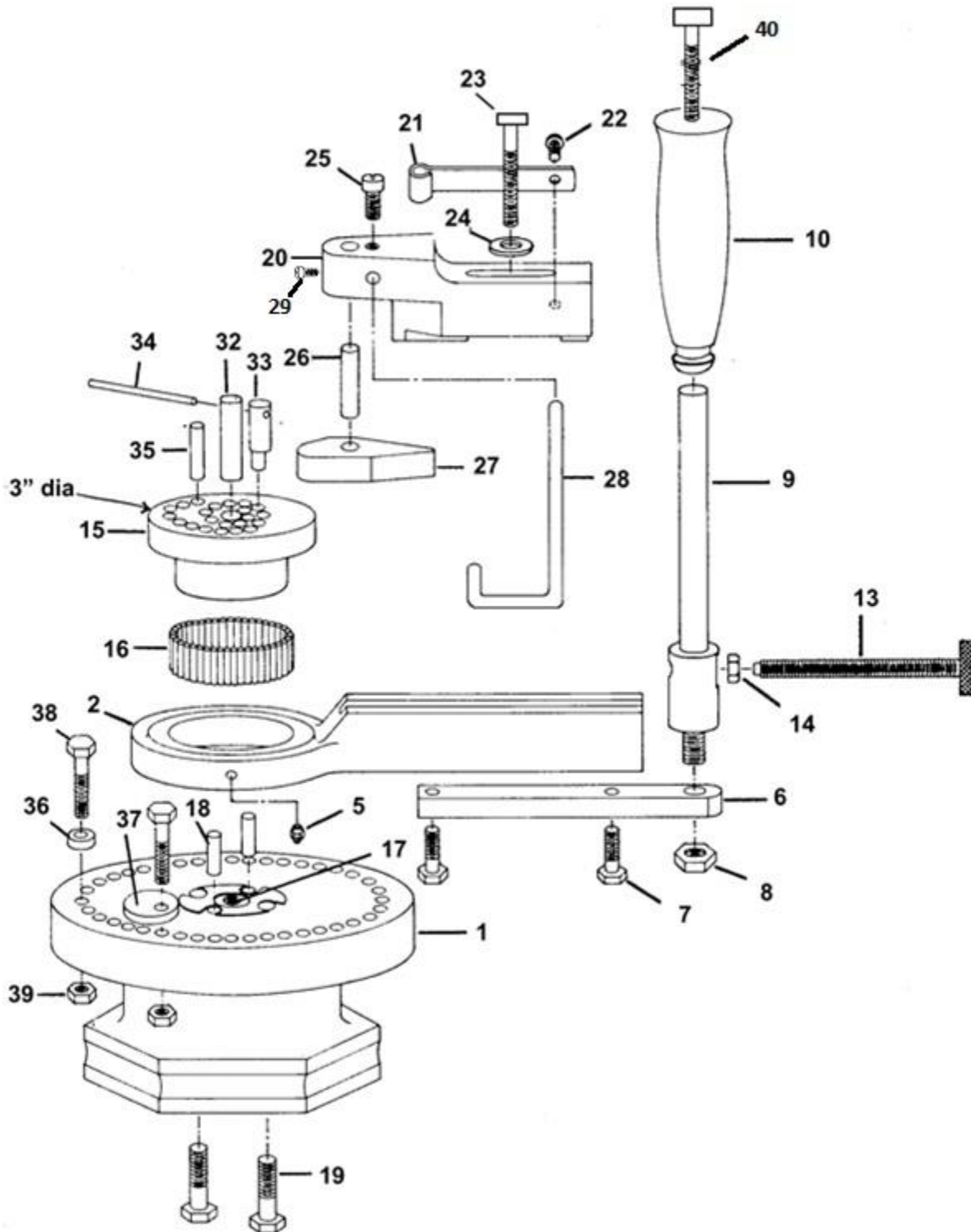
**\*IF BENDER IS MOUNTED ON ITS OWN STAND, SECURE STAND TO FLOOR.**

## MAINTENANCE

Keep machine surfaces clean and free of debris. Periodically add grease in grease fitting.

# #1 HAND BENDER PARTS BREAKDOWN

8100800-080

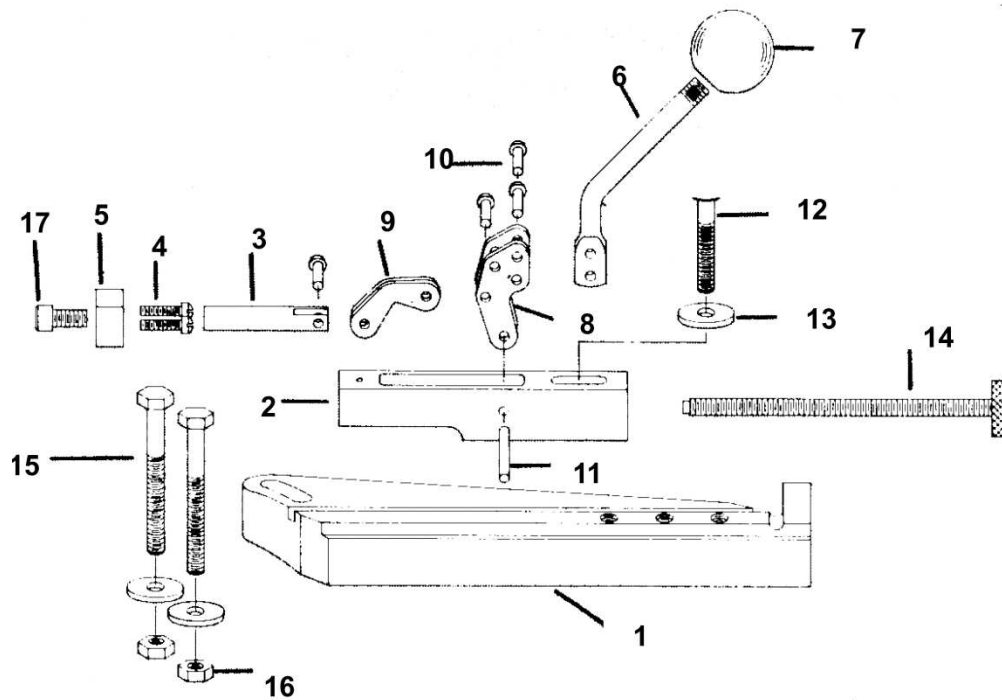


## PARTS LIST

### 8100800-080

ITEM	PART NUMBER	DESCRIPTION	QTY
1	100-1101001	BASE	1
2	100-1208002	PADDLE	1
5	8690100-200	DRIVE FITTING	1
6	100-1208005	HANDLE ARM	1
7	21A0104C0304	SCREW-HHCS 1/4-20 X 3/4	2
8	31X0308C	NUT-JAM 3/8-16	1
9	100-4701007	HANDLE STUD	1
10	8120811-400	REVOLVING HANDLE	1
13	100-1217023	SUPPORT SCREW WELDMENT	1
14	31X0516C	NUT-JAM 5/16-18	1
15	100-1105011	MOUNTING PLATE	1
16	3103001	NEEDLE BEARING	53
17	100-5702038	SHIM	6
18	19A0104X0304	PIN-DOWEL 1/4 X 3/4	2
19	21A0516C1308	SCREW-HHCS 5/16-18 X 1-3/8	2
20	100-1217015	NOSE HOLDER	1
21	8100510-401	NOSE SPRING	1
22	20B0104C0308	SCREW-BHCS 1/4-20 X 3/8	1
23	21A0104C2000	SCREW-HHCS 1/4-20 X 2	1
24	0104WILLIAMS WASHER	WILLIAMS WASHER 1/4	1
25	23A0104C0308	SCREW-SSS 1/4-20X3/8	1
26	19A0516X1102	NOSE PIN (PIN-DOWEL 5/16X1-1/2)	1
27	100-1217013	FORMING NOSE	1
28	8100142-071	BEND LOCATING GAUGE ASSEMBLY	
	100-1420033	BEND LOCATING GAUGE ROD	1
	100-1420034	BEND LOCATING GAUGE ARM	1
	100-1420035	BEND LOCATING STOP BUTTON	1
	8470510-700	RETAINING RING	2
29	23A0104C0104	SCREW-SSS 1/4-20X1/4	1
32	8100006-970	RADIUS PIN	1
33 & 34	8100120-370	LOCKING PIN ASSEMBLY	
	100-1203029	LOCKING PIN "A"	1
	100-1203028	LOCKING PIN HANDLE	1
35	19A0104X1000	HOLDING PIN (PIN-DOWEL 1/4 X 1)	1
36	100-1410019	RETURN STOP	1
37	100-1420018	ANGLE GAUGE	1
38	21A0104C1102	SCREW-HHCS 1/4-20 X 1-1/2	2
39	31X0104C	NUT-JAM 1/4-20	2
40	20A0516C0102	SCREW-SHCS 5/16-18 X 1/2	1
40A	61X0516	WASHER-FLAT 5/16(NOT SHOWN)	1

# #1 BENDER QUIK-LOK ASSEMBLY 106-1113801



ITEM	PART NUMBER	DESCRIPTION	QTY
1	106-1113001	BASE	1
2	8116111-302	HANGER 2	1
3	8000111-300	SLIDE ARM	1
4	21A0X10C0508	SCREW-HHCS #10-24 X 5/8	2
5	8100111-300	NOSE	1
6	8200111-300	HANDLE ARM	1
7	8120810-600	PLASTIC KNOB	1
8	8111312-400	HANDLE LINK	2
9	8111312-500	LINK	2
10	8470310-100	RIVET	4
11	19A0316X1104	PIN-DOWEL 3/16 X 1-1/4	1
12	21A0104C1304	SCREW-HHCS 1/4-20 X 1-3/4	1
13	0104WILLIAMS WASHER	WASHER-WILLIAMS 1/4	3
14	100-1217023	SUPPORT SCREW ASSEMBLY	1
14A	31X0516C	NUT-JAM 5/16-18	1
15	21A0104C2102	SCREW-HHCS 1/4-20 X 2-1/2	2
16	30X0104C	NUT-FULL 1/4-20	2
17	20A0516C0508	SCREW-SHCS 5/16-18 X 5/8	1

## SPECIFICATIONS & THE ART OF BENDING

We are proud to re-introduce the #1 Bender, which we affectionately call "Junior." Although, the #1 Bender is the "midget" of the Di-Acro Bender family, this precision machine is a high-speed production unit for all materials within its range. Small parts can often be formed at rates in excess of 750 bends per hour.

### SPECIFICATIONS

Radius Capacity	2"
Height of Standard Forming Nose	1 1/2"
Built-Up Nose	1"
Center Hole Diameter	3/8"
Operating Leverage	8"
Weight	22 lbs.
<b>Material Capabilities</b>	
Round Mild Steel Bar	3/16"
Square Mild Steel	1/8"
Steel Tubing	5/16"
Flat Steel Bar (Easy Way)	1/8" x 3/4"
Flat Steel Bar (Hard Way)	1/16" x 1/2"
Angle	1/16" x 1/2" x 1/2"
Channel	1/16" x 1/4" x 1/2"



FOR A COMPLETE DESCRIPTION OF 20 BENDING OPERATIONS WITH CLEAR STEP-BY-STEP ILLUSTRATIONS OF EACH, REFER TO THE DI-ACRO **"ART OF BENDING"** CATALOG THAT WAS INCLUDED WITH THIS CATALOG. IT SHOWS OVER 90 DIAGRAMS AND CHARTS TOGETHER WITH VALUABLE TOOLING SUGGESTIONS.

## OPTIONAL STAND

Part Number: 8230110-900

Stand Dimensions: 20" WIDE, 15" DEEP, 33-1/4" HIGH

**CALL DI-ACRO FOR PRICE AND AVAILABILITY**



Fasteners needed to attach Hand Bender to stand are the following:  
(Note: Fasteners to attach stand to floor are not included)

PART NUMBER	DESCRIPTION	QTY
21A0104C2000	SCREW-HHCS 1/4-20X2	3
61X0104	WASHER-FLAT 1/4	3
30X0104C	NUT-FULL 1/4-20	3



# Warranty & Limitation of Liability

Defective parts, of a product manufactured by DI-ACRO, will be replaced or repaired at no charge for twelve (12) months following delivery to the original purchaser. Labor is included for the first 90 days. This warranty becomes void when products have not been used according to instructions furnished by DI-ACRO, nor does it cover any altered parts or unauthorized repairs. We cannot be responsible for the cost of repairs made or attempted outside of our factory. All other warranty claims are made FOB our plant, providing such items(s) is returned freight prepaid to our plant for examination.

This warranty does not apply to parts, components or systems not manufactured by DI-ACRO. These products are covered instead by the existing warranties, if any, of their manufacturers. Normal service items with a reasonable life expectancy of less than one year are warranted only to the extent of the reasonable life under normal use and service.

Authorization must be obtained from DI-ACRO before returning parts or equipment to the factory. DI-ACRO will satisfy this warranty by replacing the product or refunding the purchase price upon receipt, inspection and defect identification.

DI-ACRO's liability under this warranty shall not exceed the amount paid for the product.

**THIS IS DI-ACRO'S SOLE WARRANTY IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, WHICH ARE HEREBY EXCLUDED, INCLUDING IN PARTICULAR ALL WARRANTIES OF MERCHANTABILITY, FITNESS OR ANY LOSS, DAMAGE OR EXPENSES DIRECTLY OR INDIRECTLY RELATED TO THE USE OF ITS PRODUCT OR FROM ANY OTHER CAUSE OR FOR CONSEQUENTIAL DAMAGES INCLUDING, WITHOUT LIMITATION, LOSS OF TIME AND LOSS OF PRODUCTION.**

**IT IS EXPRESSLY UNDERSTOOD THAT DI-ACRO IS NOT RESPONSIBLE FOR DAMAGE OR INJURY CAUSED TO OTHER PRODUCTS, MACHINERY, PROPERTY OR PERSONS BY REASON OF THE USE OF ITS PRODUCTS.**



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