

#3 HAND BENDER

OPERATION AND PARTS MANUAL



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TABLE OF CONTENTS

SAFETY INFORMATION	PG. 3
MAINTENANCE	PG. 3
#3 BENDER BREAKDOWN AND PARTS LIST	PG. 4-5
QUIK-LOK MOUNTING INSTRUCTIONS	PG. 6
QUIK-LOK BREAKDOWN AND PARTS LIST	PG. 7-8
SPECIFICATIONS & THE ART OF BENDING	PG. 9
OPTIONAL STAND	PG. 10
WARRANTY	PG. 11

SAFETY INFORMATION



Before bender is set up for operation, mount on work bench or stand.

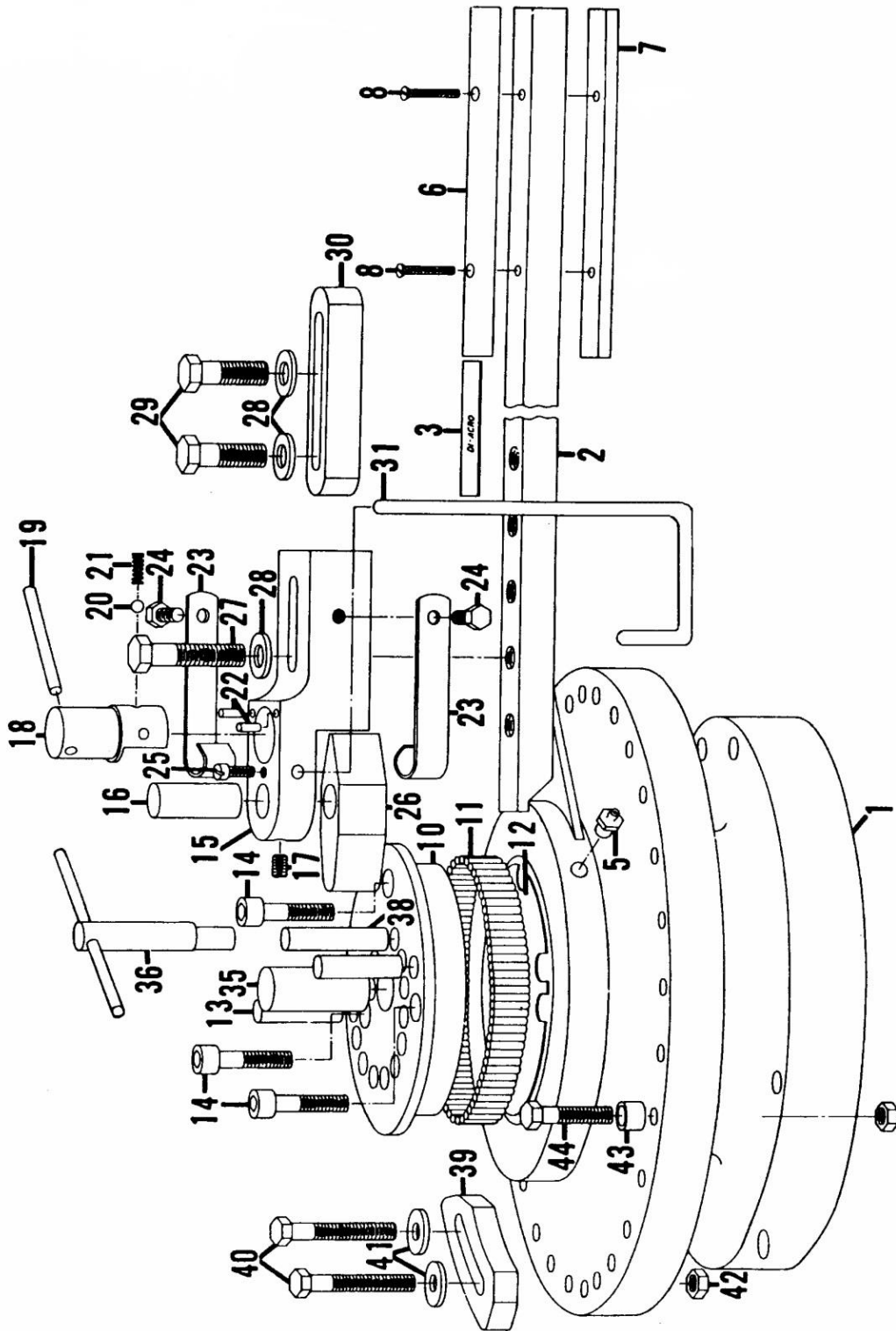
***IF BENDER IS MOUNTED ON ITS OWN STAND, SECURE STAND TO FLOOR.**

MAINTENANCE

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

#3 HAND BENDER PARTS BREAKDOWN

8130800-080



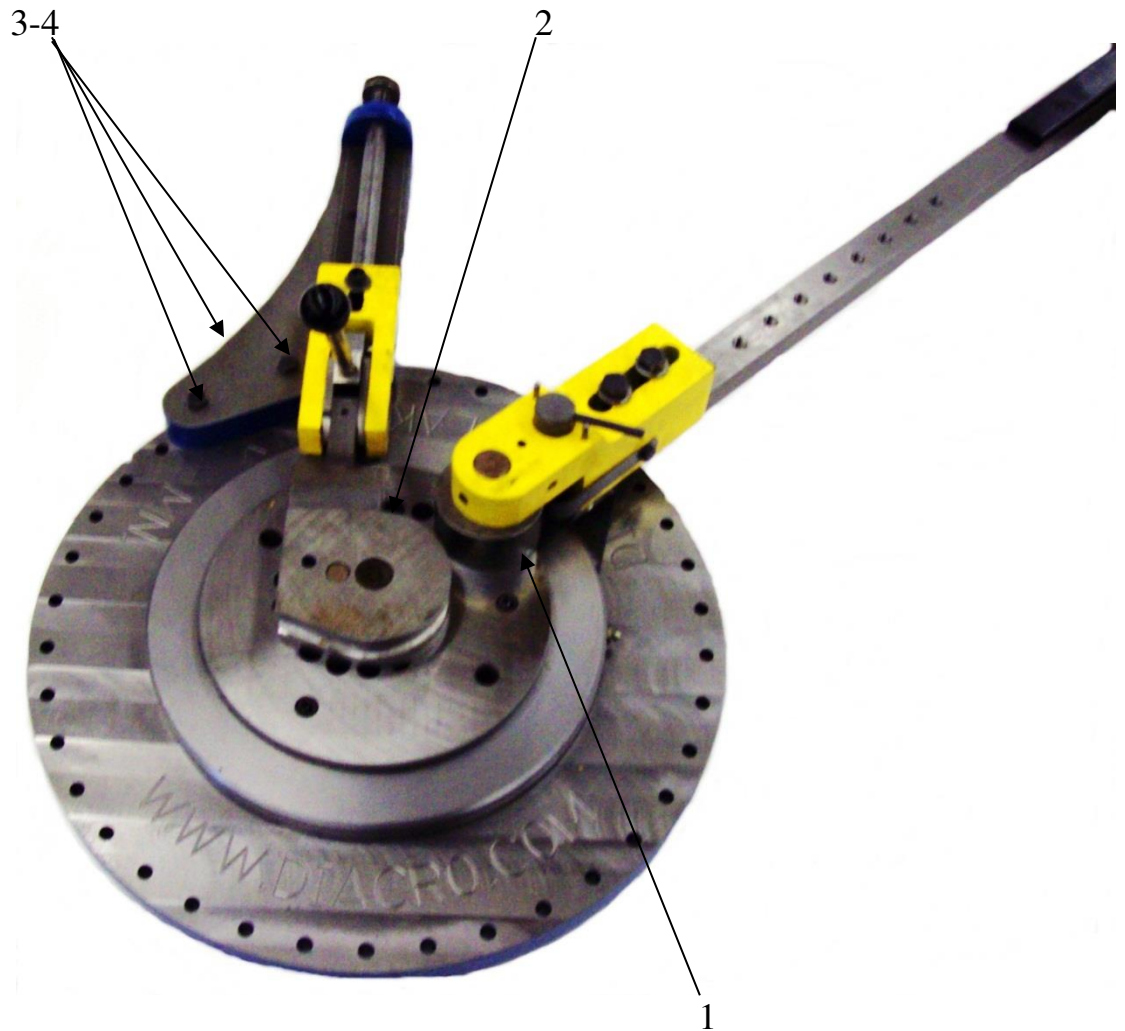
PARTS LIST

8130800-080

ITEM	PART NUMBER	DESCRIPTION	QTY
1	8130110-100	BASE	1
2	8100120-800	HANDLE ARM WELDMENT	1
3	8150650-110	NAMEPLATE	1
5	120-0191-P	GREASE FITTING	1
6	8130120-800	HANDLE GRIP	2
8	20C0104C0508	SCREW-FHSCS 1/4-20X5/8	4
10	8130110-501	MOUNTING PLATE	1
11	8310300-200	ROLLER BEARING	109
12	8130570-203	SHIM	6
13	8130120-301	MOUNTING PLATE PIN	2
14	20A0308C1102	SCREW-SHCS 3/8-16X1-1/2	3
15	8200121-701	NOSE HOLDER	1
16	8000120-301	NOSE PIN	1
17	23A0308C0102	SCREW-SSS 3/8-16X1/2	1
18	8158121-702	TRIGGER	1
19	18A0104X3000	PIN-SPRING 1/4X3	1
20	8010461-000	STEEL BALL	1
21	8210510-204	SPRING	1
22	8310301-200	NEEDLE ROLLER	2
23	8120510-401	NOSE SPRING	2
24	21A0516C0102	SCREW-HHCS 5/16-18X1/2	2
25	23A0104C0102	SCREW-SSS 1/4-20X1/2	1
26	8130121-701	FORMING NOSE	1
27	21A0102F3000	SCREW-HHCS 1/2-20X3	2
28	0102WILLIAMS WASHER	1/2 WILLIAMS WASHER	4
29	21A0102F1304	SCREW-HHCS 1/2-20X1-3/4	2
30	8120121-701	NOSE HOLDER SUPPORT	1
31	8130142-071	BEND LOCATING GAUGE ASSEMBLY	
	8200142-003	BEND LOCATING GAUGE ARM	1
	8130142-003	BEND LOCATING GAUGE ROD	1
	8300142-003	BEND LOCATING GAUGE BUTTON	1
	8470510-900	RETAINING RING	2
35	8130016-970	RADIUS PIN	1
36	8130120-371	LOCKING PIN ASSEMBLY	1
38	8130120-303	HOLDING PIN 1/2"	1
39	8120142-001	ANGLE GAUGE	1
40	21A0308C2104	SCREW-HHCS 3/8-16X2-1/4	2
41	61X0308	WASHER-FLAT 3/8	2
42	30X0308C	NUT-FULL 3/8-16	3
43	8100142-001	RETURN STOP	1
44	21A0308C2104	SCREW-HHCS 3/8-16X2-1/4	1

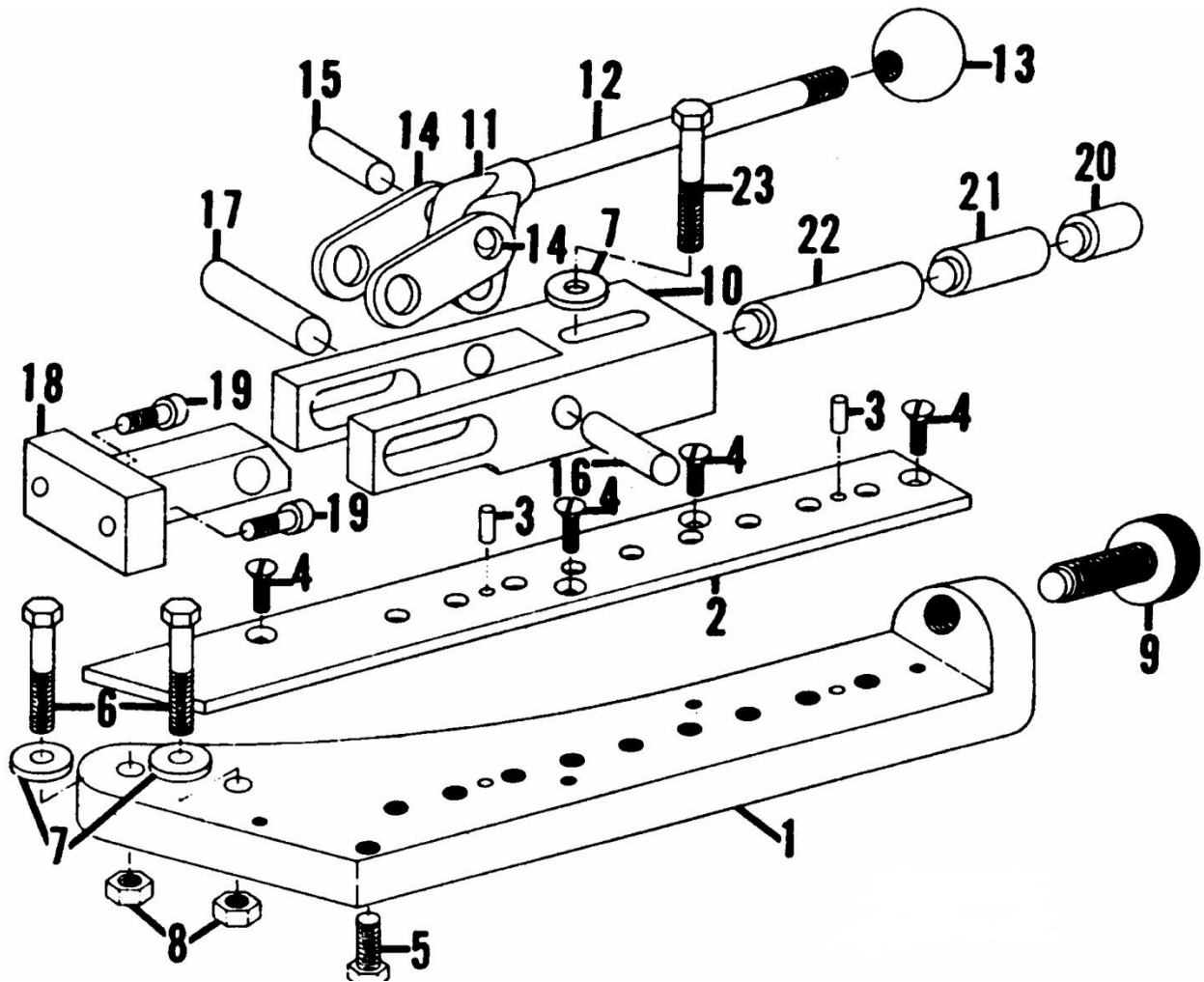
QUIK-LOK MOUNTING INSTRUCTIONS

- Remove nose and replace with Forming Roller.
- Mount grooved Radius Collar as shown below.
- Set Quik-Lok to match up with flat side of Radius Collar.
- Locate two 3/8" diameter bolts in Quik-Lok base and tighten. Make sure handle locks in forward position.



QUIK-LOK PARTS BREAKDOWN

8136111-373



PARTS LIST

8136111-373

ITEM	PART NUMBER	DESCRIPTION	QTY
1	8136111-300	BASE	1
2	8600111-300	SLIDE	1
3	19A0104X1000	PIN-DOWEL 1/ 4X1	2
4	20C0104C0304	SCREW-FHMS 1 /4-20X3/4	4
5	21A0308C2104	SCREW-HHCS 3/8-16X2-1/4	1
6	21A0308C2304	SCREW-HHCS 3/8-16X2-3/4	2
7	0308WILLIAMSWASHER	WASHER-WILLIAMS 3/8	3
8	30X0308C	NUT-FULL 3/8-16	2
9	8500111-301	KNURL HEAD SCREW	1
10	8126111-302	HANGER	1
11	8400111-300	HANDLE BLOCK	1
11A	23A0104C0104	SCREW-SSS 1/4-20X1/4	2
12	8500111-300	HANDLE ROD	1
13	8120810-700	PLASTIC KNOB	1
14	8930111-300	LINK	2
15	8156120-301	LINK PIN	1
16	19A0102X2102	PIN-DOWEL 1/ 2X2-1/2	1
17	19A0508X2102	PIN-DOWEL 5/8X2-1/2	1
18	8920111-300	NOSE WELDMENT	1
18A	23A0104C0308	SCREW-SSS 1/4-20X3/8	1
19	20A0516C0508	SCREW-SHCS 5/16-18X5/8	2
20	8156111-301	SPACER ROD A	1
21	8300111-301	SPACER ROD B	1
22	8400111-301	SPACER ROD C	1
23	21A0308C2102	SCREW-HHCS 3/8-16X2-1/2	1

SPECIFICATIONS & THE ART OF BENDING

SPECIFICATIONS OF HAND BENDER

	No. 1A		No. 2		No. 3		No. 4	
	In.	mm	In.	mm	In.	mm	In.	mm
Max. Radius Capacity	6	152.4	9	228.6	12	304.8	12	304.8
Height of Std. Forming Nose	3 /4	19.1	1	25.4	1-1/2	38.1	1-1/2	38.1
Center Pin Hole-Diameter	1 /2	12.7	1	25.4	1	25.4	1	25.4
Operating Leverage	16	406.4	29	736.6	40	1016	40	1016
Material Capacities								
Round Mild Steel Bar	5/16	7.9	1 /2	12.7	5/8	15.9	1	25.4
Square Mild Steel Bar	1 /4	6.4	3 /8	9.5	1 /2	12.7	3 /4	19.4
Steel Tube-16 Gauge	1 /2	12.7	3 /4	19.1	1	25.4	1-1/4	31.8
Standard Iron Pipe	--	---	3/8 IPS	9.5	1 /2 IPS	12.7	1 IPS	25.4
Flat Steel Bar (easy way)	3/16x1,4.8x25.4		1/4x1-1/2,6.4x38.1		1/4x2,6.4x50.8		3/8x4.9.5x101.6	
Flat Steel Bar (hard way)	1/8x1/2,3.2x12.7		1/8x3/4,3.2x19.1		1/8x1,3.2x25.4		1 /4,1,6.4x25.4	



THE ART OF BENDING

FOR A COMPLETE DESCRIPTION OF 20 BENDING OPERATIONS WITH CLEAR STEP-BY-STEP ILLUSTRATIONS OF EACH, REFER TO THE DI-ACRO **"ART OF BENDING"** THAT WAS INCLUDED ALONG 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 Bender to stand are the following:
(*Fasteners to attach stand to floor are not included.*)

PART NUMBER	DESCRIPTION	QTY
21A0102C3000	SCREW-HHCS 1/2-13X3	3
61X0102	WASHER-FLAT 1/2	3
30X0102C	NUT-FULL 1/2-13	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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