



#2 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.

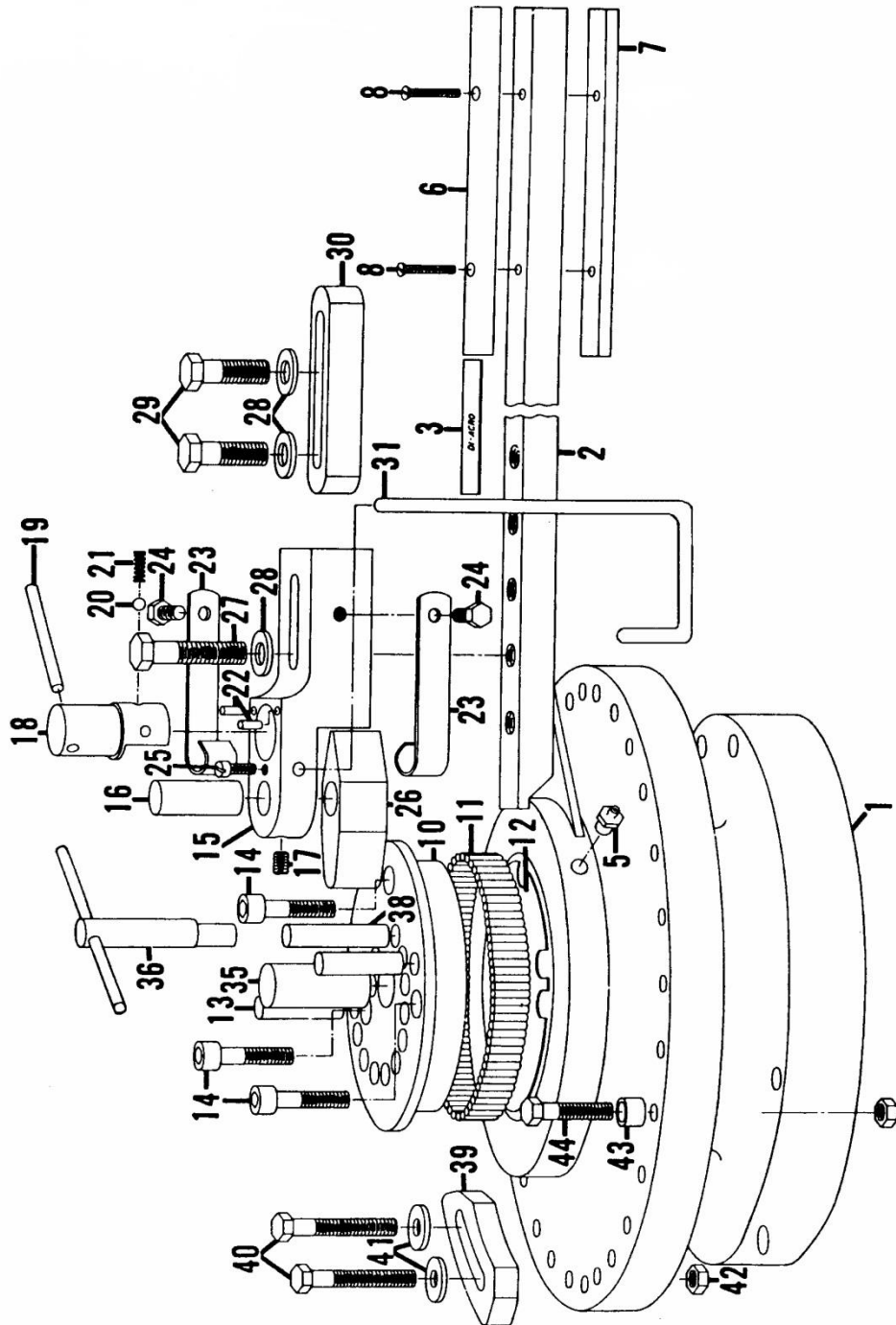
***IF BENDER IS MOUNTED ON ITS OWN STAND, SECURE STAND TO FLOOR.**

MAINTENANCE

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

#2 HAND BENDER PARTS BREAKDOWN

8120800-080

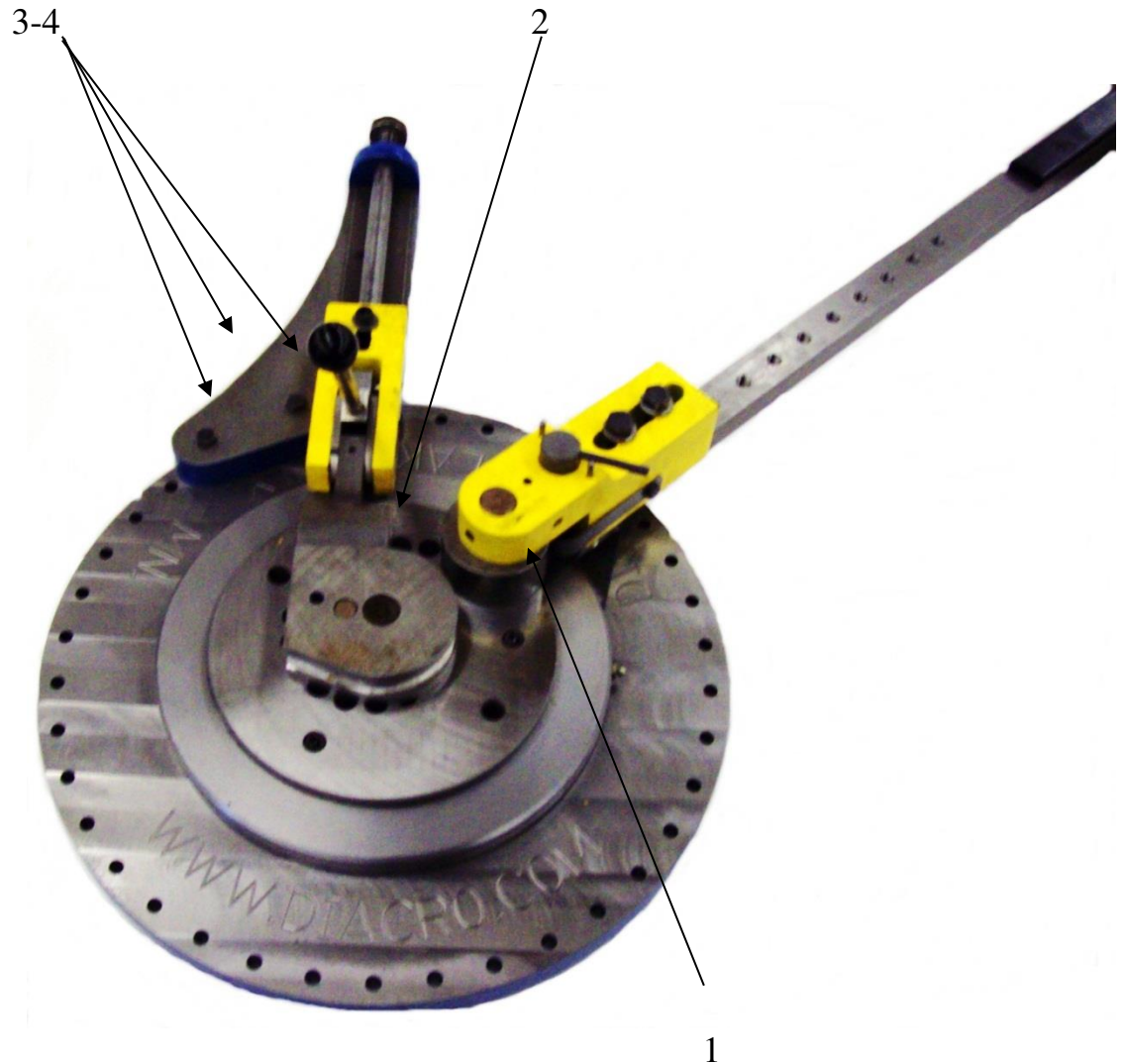


**PARTS LIST
8120800-080**

ITEM	PART NUMBER	DESCRIPTION	QTY
1	8120110-100	BASE	1
2	8220120-800	HANDLE ARM WELDMENT	1
3	8150650-110	NAMEPLATE	1
5	120-0191-P	GREASE FITTING	1
6	8120120-800	HANDLE	2
8	20C0104C0508	SCREW-FHSCS 1/4-20X5/8	4
10	8120110-501	MOUNTING PLATE	1
11	8310301-200	ROLLER BEARING	97
12	8120570-203	SHIM	6
13	8120111-201	MOUNTING PLATE PIN	2
14	20A0308C1102	SCREW-SHCS 3/8-16X1-1/2	3
15	8220121-701	NOSE HOLDER	1
16	8120120-301	NOSE PIN	1
17	23A0516C0308	SCREW-SSS 5/16-18X3/8	1
18	8120121-702	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	23A0104C0308	SCREW-SSS 1/4 -20X3/8	1
26	8020121-701	FORMING NOSE	1
27	21A0102F2000	SCREW-HHCS 1/2-20X2	1
28	0102WILLIAMS WASHER	1/2 WILLIAMS WASHER	3
29	21A0102F1304	SCREW-HHCS 1/2-20X1-3/4	2
30	8120121-701	NOSE HOLDER SUPPORT	1
31	8120142-071	BEND LOCATING GAUGE ASSY	
	8120142-003	BEND LOC GAUGE ARM	1
	8110142-003	BEND LOC ROD	1
	8100142-003	STOP BUTTON	1
	8470511-800	RETAINING RING	2
35	8120016-970	RADIUS PIN	1
36	8120120-370	LOCKING PIN ASSEMBLY	1
38	8120120-303	HOLDING PIN	1
39	8120142-001	ANGLE GAUGE	1
40	21A0308C2000	SCREW-HHCS 3/8-16X2	2
41	61X0308	WASHER-FLAT 3/8	2
42	30X0308C	NUT-FULL 3/8-16	3
43	8100142-001	RETURN STOP	1
44	21A0308C2000	SCREW-HHCS 3/8-16X2	1

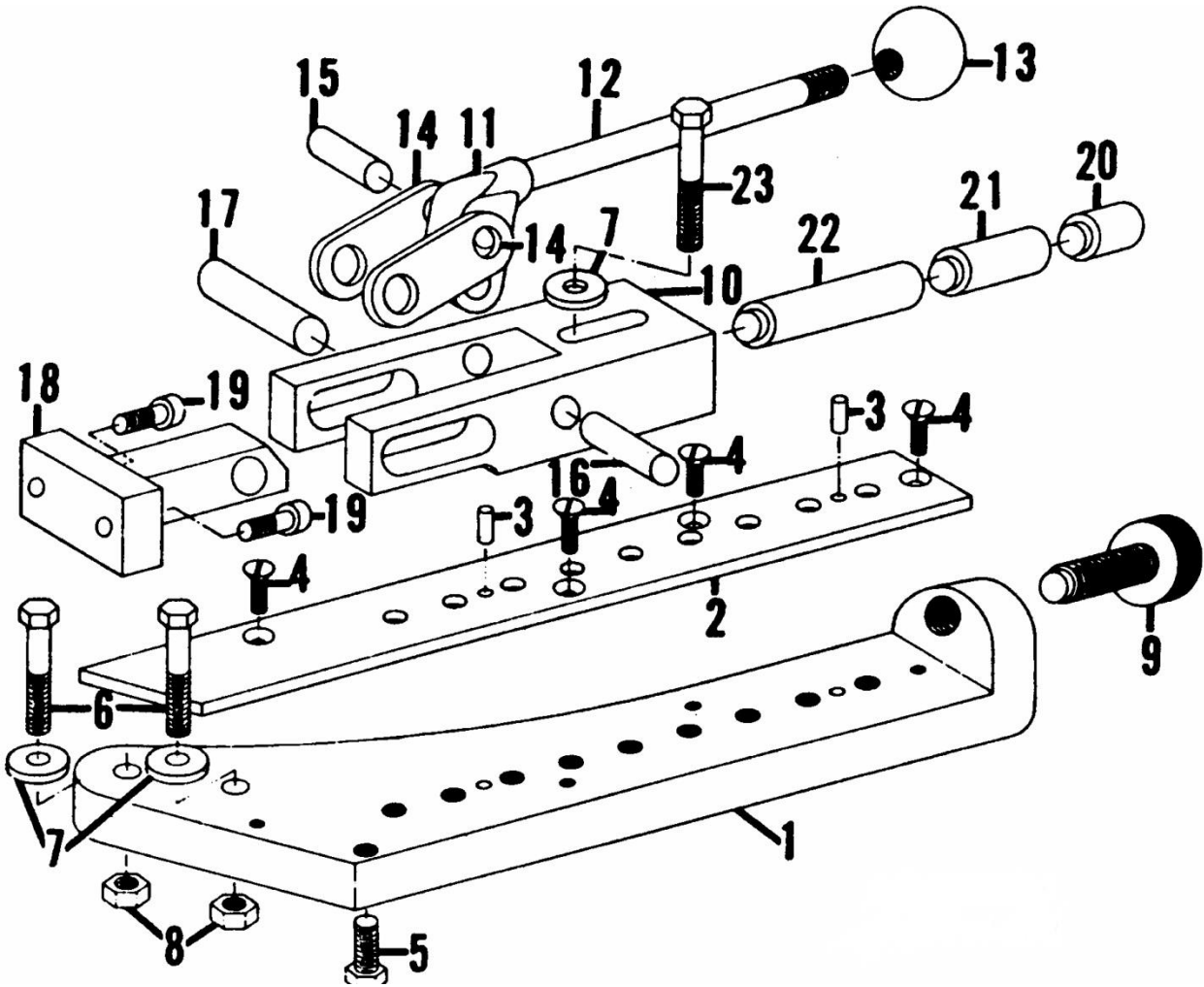
QUIK-LOK MOUNTING INSTRUCTIONS

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



#2 BENDER QUIK-LOK PARTS BREAKDOWN

8126111-373



QUIK-LOK PARTS LIST
8126111-373

ITEM	PART NUMBER	DESCRIPTION	QTY
1	8126111-300	BASE	1
2	8300111-300	SLIDE	1
3	19A0104X1000	DOWEL PIN 1/4X1	2
4	20C0104C0304	SCREW-FLAT HD 1/4-20X3/4	4
5	21A0308C2104	SCREW-HEX 3/8-16X2-1/4	1
6	21A0308C2304	SCREW-HEX 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	DOWEL PIN 1/ 2X2-1/2	1
17	19A0508X2102	DOWEL PIN 5/8X2-1/2	1
18	8920111-300	NOSE WELDMENT	1
18A	23A0104C0308	SCREW-SSS 1/4-20X3/8	1
19	20A0516C0508	SCREW-SOC HEAD 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	21A0308C2104	SCREW-HEX 3/8-16X2-1/4	1

SPECIFICATIONS

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)	3/16x1,4.8x 25.4		1/4x1-1/2,6.4x 38.1		1/4x2,6.4x50.8		3/8x4.9.5x 101.6	
Flat Steel Bar (hard way)	1/8x1/2,3.2x 12.7		1/8x3/4,3.2x 19.1		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, ORDER THE 20-PAGE DIACRO "ART OF BENDING" CATALOG WITH OVER 90 DIAGRAMS AND CHARTS TOGETHER WITH VALUABLE TOOLING SUGGESTIONS.

OPTIONAL STAND

PART NO.: 8230110-900

STAND DIMENSIONS: 20" Wide x 15" Deep x 33-1/4" High

CALL DI-ACRO FOR PRICE AND AVAILABILITY



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

PART NUMBER	DESCRIPTION	QTY
21A0102C2102	SCREW-HHCS 1/2-13X2-1/2	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.

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