



## CONDUIT BENDER AND ANGLE SETTER™ GUIDE



### Offset Bend Steps

1. Measure distance X to obstruction and height Y to clear obstruction.
2. Multiply height Y by shrink/inch. Add this to distance to obstruction X. This is first bend line.
3. Multiply height Y by constant multiplier. This is distance between bends. Mark second bend line at this distance.
4. Bend first bend using first bend line. Spin conduit 180° and perform second bend using second bend line.

### Saddle Bend Steps

1. Measure distance X to center of obstruction and height Y to clear obstruction.
2. Add distance X to center of obstruction to shrink value from Saddle Bend table. Make center bend mark at this distance.
3. Multiply height Y by constant multiplier. This is distance between bends. Mark second bend line at this distance.
4. Bend first bend using first bend line. Spin conduit 180° and perform second bend using second bend line.

ZIP GUIDE™ FOR OFFSETS	22-1/2°		30°		45°		60°	
	B	C	B	C	B	C	B	C
	Distance Between Bends	Shrink Amount	Distance Between Bends	Shrink Amount	Distance Between Bends	Shrink Amount	Distance Between Bends	Shrink Amount
Offset Depth	2"	5-1/4"	3/8"	—	—	—	—	—
	3"	7-3/4"	9/16"	6"	3/4"	—	—	—
	4"	10-1/2"	3/4"	8"	1"	—	—	—
	5"	13"	15/16"	10"	1-1/4"	7"	1-7/8"	—
	6"	15-1/2"	1-1/8"	12"	1-1/2"	8-1/2"	2-1/4"	7-1/4"
	7"	18-1/4"	1-5/16"	14"	1-3/4"	9-3/4"	2-5/8"	8-1/2"
	8"	20-3/4"	1-1/2"	16"	2"	11-1/4"	3"	9-5/8"
	9"	23-1/2"	1-3/4"	18"	2-1/4"	12-1/2"	3-3/8"	10-3/4"
	10"	26"	1-7/8"	20"	2-1/2"	14"	3-3/4"	12"

ZIP GUIDE™ FOR SADDLES	45°		60°	
	B	C	B	C
	22.5° Return Bends	30° Return Bends	22.5° Return Bends	30° Return Bends
	Distance From Center Mark	Shrink Amount	Distance From Center Mark	Shrink Amount
Obstruction Height	1"	2-1/2"	3/16"	2"
	2"	5"	3/8"	4"
	3"	7-1/2"	9/16"	6"
	4"	10"	3/4"	8"
	5"	12-1/2"	15/16"	10"
	6"	15"	1-1/8"	12"

BENDER TAKE UP TABLE	90° Stub-Up Bend	
	B	C
	Conduit Size	Stub Height
	1/2" EMT	5"
	3/4" EMT	6"
	1/2" Ridgid	6"
	1" EMT	8"

## CONDUIT BENDER — FIG. 1

- |   |  |
|---|--|
| ① Hook                                  | ⑥ Foot Pedal                                 |
| ② Alignment Arrow                       | ⑦ Angle Setter™ Storage                      |
| ③ 45° Center-of-Bend                    | ⑧ Bend Angle Multipliers                     |
| ④ 90° Back-of-Bend & 60° Center-of-Bend | ⑨ Alignment Notches (use with Angle Setter™) |
| ⑤ Bend Angle Lines                      |  |

## ANGLE SETTER™\* — FIG 2

- |                           |                  |
|---------------------------|------------------|
| ① Conduit Stop Track      | ③ Alignment Tabs |
| ② Angle Alignment Grooves | ④ Lanyard Hole   |

\*For use with EMT Conduit

## ANGLE SETTER™ INSTRUCTIONS — FIG 3

Use markings for desired bend angle (10°, 22.5°, 30°, 45°)

- ① Align the Angle Setter™ alignment groove with end of bender head angle line (30° shown).
- ② Using your palm, press Angle Setter™ firmly into place, until it is flush with the sides of the bender channel - ensure alignment tabs are fully seated into alignment notches.
- ③ Insert conduit into bender head and prepare to bend as usual.
- ④ Bend conduit until contact with the Angle Setter™ is felt. Will work for floor and air bends.

*Caution: Bending past Angle Setter™ can result in kinks in conduit*

FIG. 1

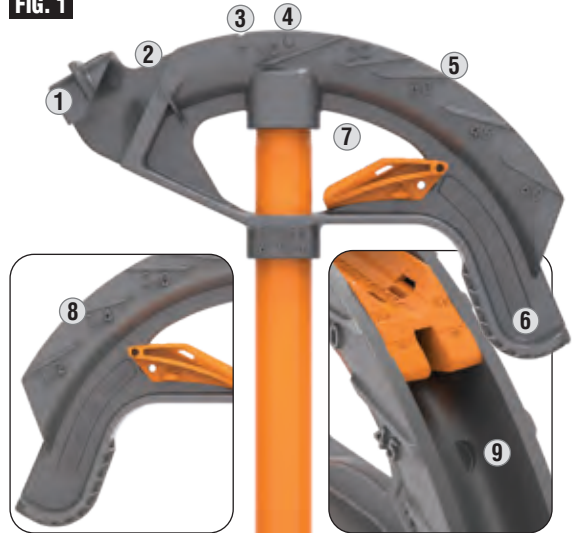


FIG. 2

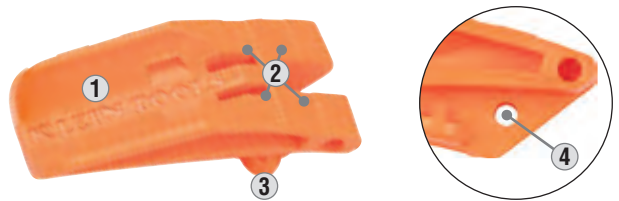


FIG. 3

