

TECHNICAL MANUAL

OPERATOR'S, ORGANIZATIONAL, DIRECT  
SUPPORT, AND GENERAL SUPPORT MAINTENANCE  
MANUAL INCLUDING REPAIR PARTS LIST  
FOR  
BENDING MACHINE, PIPE,  
MODEL 555

NATIONAL STOCK NO. 3441-00-450-0290  
(GREENLEE TOOL CO.)

## WARNING

### GROUNDING INSTRUCTIONS

This tool should be grounded while in use to protect the operator from electric shock. The tool is equipped with an approved three-conductor cord and three-prong grounding type plug to fit the proper grounding type receptacle. The green (or green and yellow) conductor in the cord is the grounding wire. Never connect the green (or green and yellow) wire to a live terminal. If your unit is for use on less than 150 Volts, the power cord is equipped with a plug that has two flat, parallel current-carrying prongs and one longer, round or "U"-shaped, ground prong which requires a mating 3-conductor grounded type receptacle, as shown in Fig. 1. An adapter, shown in Fig. 2, is available for connecting 3-prong grounding type plugs that are used on units less than 150 Volts to 2-prong receptacles. THIS ADAPTER IS NOT APPLICABLE IN CANADA. The green colored rigid ear, lug, etc., must be connected to a permanent ground such as a properly grounded outlet box, as shown in Fig. 2. If your unit is for use on 150 to 250 Volts, the power cord is equipped with a plug that has two flat current-carrying prongs in tandem, and one round or "U"-shaped, longer ground prong, as shown in Fig. 3. This plug is used only with the proper mating 3-conductor grounding type receptacle, as shown in Fig. 3. No adapter available for this type plug.

IN ALL CASES, MAKE SURE THE RECEPTACLE IN QUESTION IS PROPERLY GROUNDED.

### EXTENSION CORDS

Use only three-wire extension cords which have three prong grounding-type plugs and three-pole receptacle which accept the tool's plug. Replace or repair damaged or worn cord immediately.

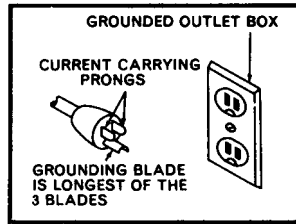


Fig. 1

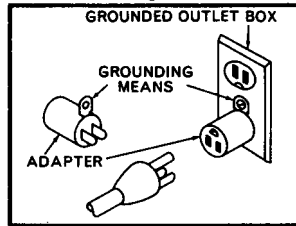


Fig. 2

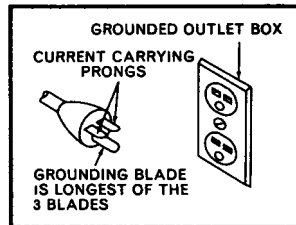


Fig. 3

### SAFETY RULES FOR ALL TOOLS

As with all power tools there is a certain amount of hazard involved with the operator and his use of the tool. Using the tool with the respect and caution demanded as far as safety precautions are concerned will considerably lessen the possibility of personal injury. However, if normal safety precautions are overlooked or completely ignored, personal injury to the operator can develop.

#### 1. KEEP WORK AREA CLEAN.

Cluttered areas and benches invite accidents.

#### 2. AVOID DANGEROUS ENVIRONMENT.

Don't expose power tools to rain. Don't use power tools in damp or wet locations. Keep work area well lit.

#### 3. KEEP VISITORS AWAY.

All visitors should be kept a safe distance from work area.

#### 4. STORE IDLE TOOLS.

When not in use, tools should be stored in a dry, high or locked up place-out of reach of unauthorized personnel.

#### 5. DON'T ABUSE CORD.

Never carry tool by cord or yank it to disconnect from a receptacle. Keep cord from heat, oil and sharp edges.

#### 6. MAINTAIN TOOLS WITH CARE.

Keep tools sharp and clean for best and safe performance. Follow instructions for lubricating and changing accessories.

#### 7. DISCONNECT TOOLS.

When not in use; before servicing; when changing accessories such as blades, bits, cutters, etc.

## INSTRUCTIONS FOR REQUISITIONING PARTS

### NOT IDENTIFIED BY NSN

When requisitioning parts not identified by National Stock Number, it is mandatory that the following information be furnished the supply officer.

- 1 - Manufacturer's Federal Supply Code Number-26289
- 2 - Manufacturer's Part Number exactly as listed herein.
- 3 - Nomenclature exactly as listed herein, including dimensions, if necessary.
- 4 - Manufacturer's Model Number Model 555.
- 5 - Manufacturer's Serial Number (End Item).
- 6 - Any other information such as Type, Frame Number, and Electrical Characteristics, if applicable.
- 7 - If DD Form 1348 is used, fill in all blocks except 4, 5, 6, and Remarks field in accordance with AR 725-50.

Complete Form as Follows:

(a) In blocks 4, 5, 6, list manufacturer's Federal Supply Code Number - 26289 followed by a colon and manufacturer's Part Number for the repair part.

(b) Complete Remarks field as follows:

Noun: (nomenclature of repair part)

For: NSN: 3441-00-450-0290

Manufacturer: Greenlee Tool Company, 2136 - 12th Street Rockford, IL 61101

Model: 555

Serial: (of end item)

Any other pertinent information such as Frame Number, Type, Dimensions, etc.

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**TM 9-3441-205-14&P**

Technical Manual  
No. 9-3441-205-14&P }  
}

HEADQUARTERS  
DEPARTMENT OF THE ARMY  
Washington, DC, 7 October 1981

**OPERATOR'S, ORGANIZATIONAL, DIRECT SUPPORT,  
AND GENERAL SUPPORT MAINTENANCE MANUAL  
INCLUDING REPAIR PARTS LIST**

**FOR**

**BENDING MACHINE, PIPE, MODEL 555  
(NSN 3441-00-450-0290)**

**REPORTING OF ERRORS**

**You can help improve this manual. If you find any mistakes or if you know of a way to improve the procedures, please let us know. Mail your letter, DA Form 2028 (Recommended Changes to Publications and Blank Forms), or DA Form 2028-2, located in the back of this manual direct to: Commander, US Army Armament Materiel Readiness Command, ATTN: DRSAR-MAS, Rock Island, IL 61299. A reply will be furnished directly to you.**

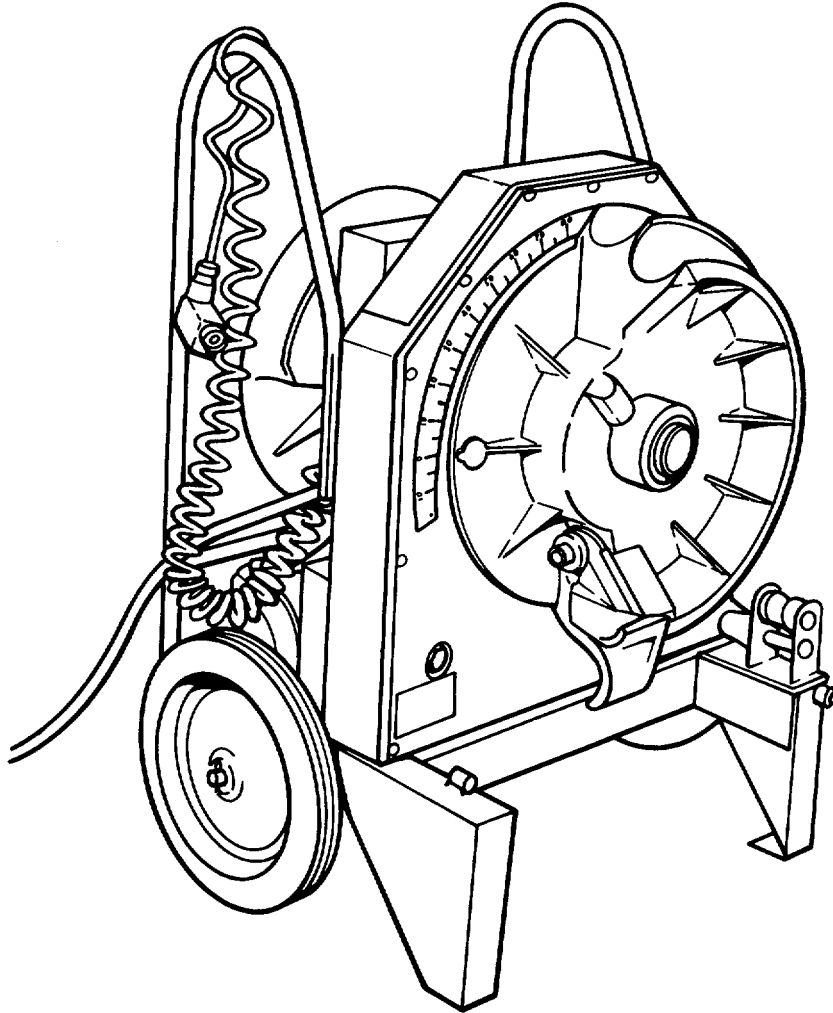
Manufactured by: Greenlee Tool Company  
2136-12th St.  
Rockford, IL 61101

Procured under Contract No. DAAA09-78-M-9218

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**This technical manual is an authentication of the manufacturers' commercial literature and does not conform with the format and content specified in AR 310-3, Military Publications. This technical manual does, however, contain available information that is essential to the operation and maintenance of the equipment.**

555  
ELECTRIC BENDER  
1/2" thru 2" Rigid and Thin-Wall E.M.T. Conduit



OPERATING, MAINTENANCE INSTRUCTIONS AND PARTS LIST

**INTRODUCTION**

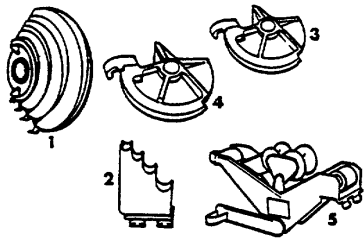
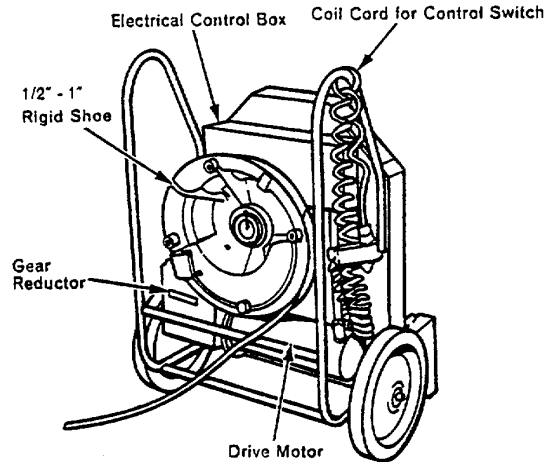
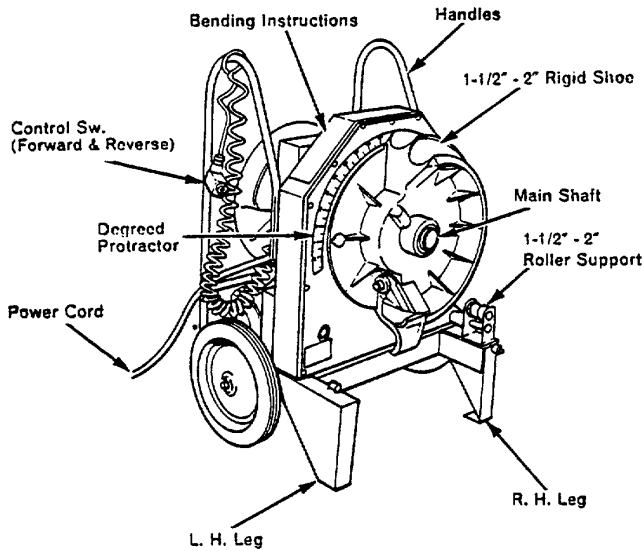
The 555 Bender is designed to bend 1/2" thru 2" Schedule #40 Rigid Steel and Aluminum Conduit and Pipe.

Optional attachments are available for bending 1/2" thru 2" E.M.T. All shoes and attachments can be removed or attached in a matter of seconds without the use of tools.

The bender operates on 115V AC 60 Hz only. The Pendant Control Switch controls the forward,

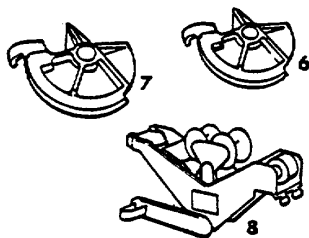
reverse and stop functions. By pushing the toggle switch forward, the shoe will rotate clockwise or in the bending direction. When the toggle switch is released, the switch will return to a neutral position and the bender will stop.

By pushing back on the switch, the shoe will rotate counterclockwise or in the unload direction.



**For bending 1 1/2" thru 1-1 /2" Thin-wall (EMT)**

Key	Control No.	Description
1	501 7944.6	Bending Shoe
2	501 7986.1	Support Roller
3	502 3499.4	1-1/2" Bending Shoe
4	502 3505.2	2" Bending Shoe
5	502 3541.9	1-1/2"-2" EMT Roller Support Unit



**For bending 1-1 /2" and 2" Thin-wall (EMT)**

Key	Control No.	Description
6	502 3499.4	1-1/2" Bending Shoe
7	502 3505.2	2" Bending Shoe
8	502 3541.9	1-1/2" - 2" EMT Roller Support Unit

## BENDING INSTRUCTIONS —1/2" thru 2" Rigid Conduit and Schedule 40 Pipe

Mount shoe of pipe size to be bent on Main Shaft. Align the 4 drive studs on the back side of shoe with 4 holes in the main drive sprocket. Push the shoe in on to the main shaft until the 4 bosses on the shoe contact with the main drive sprocket.

Mount roller support on the right hand leg of bender as when facing the front of the unit. The support for 1-1/2" thru 2" rigid has two (2) rollers and the support for 1/2" thru 1-1/4" has three (3) rollers. The lower roller on either support is closest to the bender when the support is in the bending position. The support is retained by a quick release hinge pin in the bending and storage positions.

With the control switch, position the shoe point at 5° before 0° on the scale. Insert the pipe or conduit to be bent from the right hand side, over the roller, thru the shoe groove and thru the hook. Align bending mark on conduit with front edge of shoe hook. **NOTE: Refer to bending decal or Page 5 of this manual for instructions.** Push the control switch forward, when the pointer on the shoe reaches the desired bend angle, release the control switch and the bender will stop.

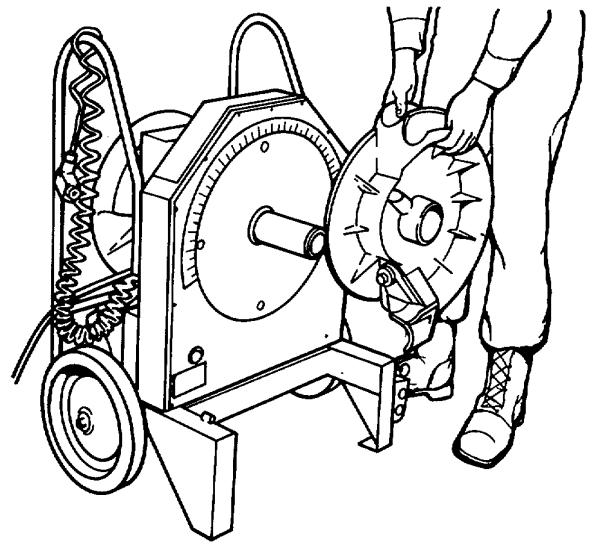
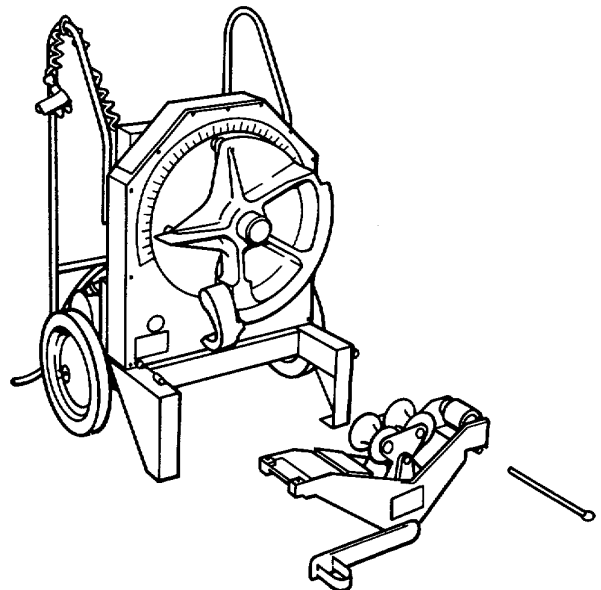


Fig. 1

## BENDING INSTRUCTIONS—1-1/2" and 2" E.M.T. Thin-Wall Conduit

Install roller support unit on bender frame and retain with quick release pin thru the bosses on the right hand leg when facing the front of the unit. Rotate the rollers that match the conduit size to be bent to the up position. Install the matching size shoe on the Main Shaft, align the 3 drive studs with any 3 holes in the main drive sprocket, and then push the shoe in until the 4 bosses on the shoe contact the main drive sprocket.





With the control switch, position the shoe pointer at 5° before 0° on the scale. Insert the conduit to be bent from the R. H. side, over the roller thru the shoe groove and thru the hook. **(NOTE: The hook may also be back in the unload position and after the conduit is in place, the hook may be moved to the bend position.)** Align the bending mark on the conduit with the front edge of the shoe hook. Refer to the bending decal or Page 5 for bending instructions. Push the loading pedal down by foot until the roller arm contacts its stop. **(NOTE: If the roller arm does not contact the stop by applying pedal pressure, apply pressure to the pedal and push the control switch forward. The clockwise rotation of the shoe will pull the rollers and roller arm into the bend position.)** If the rollers still will not go to the bend position, check the squeeze setting of the unit as follows:

The No. 502 3541.9, 1-1/2" and 2" E.M.T. Roller Support Unit is properly adjusted when the gage is in contact with the bottom of the 2" shoe groove, the steel form roller near the urethane roller and the urethane roller. The gage should not touch the forward steel form roller. The shoe, during this check, should not be near the hook end, due to the tapering of the groove near this end. If the gage will not touch the urethane roller, the roller support unit is set too high.

To adjust the roller support unit, first loosen the locking set screws with an Allen wrench. The height adjustors may now be positioned correctly by the use of the roller support gage. When the proper adjustment is obtained, retighten the locking set screws. If the roller support unit is used on another No. 555 Bender, readjustment may be necessary.

There is no adjustment for the 1-1/2" E.M.T. rollers and shoe. They will be automatically adjusted when the 2" is properly set. In normal operation, the conduit will not touch the urethane roller when bending 1-1/2" E.M.T.

Continue to hold the control switch forward until the desired bend angle is reached. Release the control switch and the bender will stop.

## MAINTENANCE INSTRUCTIONS

There is no need for periodic flushing and replacing of lube in bender gear box since they are 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 600W cylinder oil.

## INSTRUCTIONS FOR BENDING 1/2" thru 1-1 /4" E.M.T.

**NOTE: This procedure is the same as bending rigid conduit, except a pipe support without rollers is used (see Key 2 on page 2).**

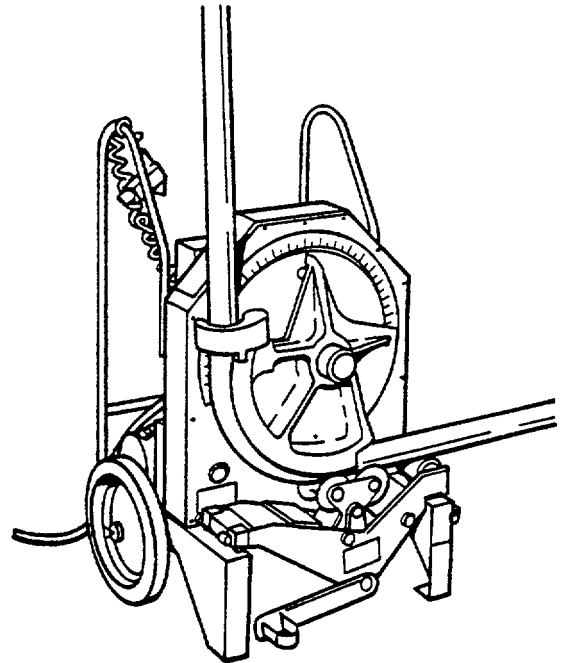
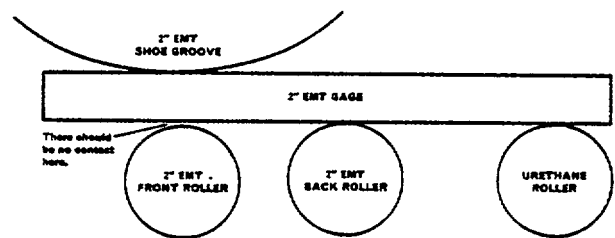


Fig. 2

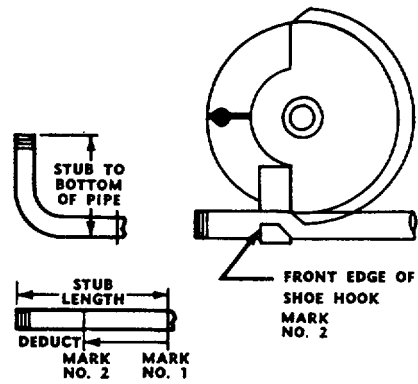


Flushing should be accomplished with *Kerosene*. This is a petroleum Hydrocarbon which will not affect seals. Aromatic Hydrocarbons such as Benzene, chlorinated solvents such as Carbon-Tetrachloride and ketones such as Acetone should never be used for flushing as they are solvents for rubber.

## TO FIND BENDING MARKS-90° STUB

To locate bending mark of 90 degree bend for a required stub.

1. Check chart A for a minimum stub length. Must be equal to or greater than minimum shown on chart.
2. Measure and mark desired stub on conduit (Mark No. 1). Subtract DEDUCT from this mark and make new mark (Mark No. 2). This is the bending mark.



## CHART A

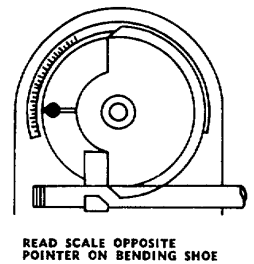
CONDUIT SIZE	1/2	3/4	1	1 1/4	1 1/2	2
DEDUCT	8 3/8	8 3/8	10	12 3/4	14 5/8	16 3/8
MINIMUM STUB LENGTH	10 3/8	10 3/8	12	14 3/4	16 5/8	18 3/8

FIGURES ARE APPROX.

## CHART B

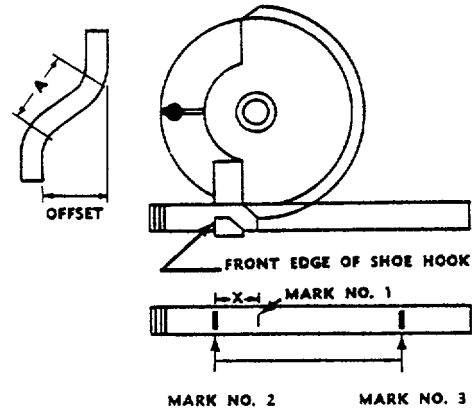
CONDUIT SIZE	15°	30°	45°	60°	90°
1/2	22	37	52	67 1/2	97 1/2
3/4	17	31 1/4	47	63	92 1/2
1	17	32 1/2	47	62	93 1/2
1 1/4	17	32	47 1/2	63	94 1/2
1 1/2	19 1/2	35	50 1/2	66	96 1/2
2	20	35	50 1/2	65	97 1/2

FIGURES ARE APPROX.



**TO FIND BENDING MARKS-OFFSET**

1. Measure distance from end of conduit to start of bend and mark conduit (No. 1).
2. Refer to chart D for measurement X. Measure this distance from mark (No. 1) only and place mark (No. 2) on conduit.
3. Refer to chart C for distance between marks. Measure this distance from mark (No. 2) and place mark (No. 3) on conduit.
4. Layout of bends is now complete. Next, place mark (No. 2) in line with front edge of the shoe hook and make first bend.
5. Rotate conduit 180 degrees. Place mark (No. 3) in line with front edge of shoe hook and complete second bend.



**CHART C**

TO LOCATE THE CENTER TO CENTER DISTANCE OF OFFSET BENDING MARKS OTHER THAN THOSE LISTED IN THE OFFSET CHART, THE FOLLOWING MULTIPLIERS SHOULD BE USED: MULTIPLY THE HEIGHT OF OFFSET REQUIRED BY 3.86 ON 15° BENDS, 2 ON 30° BENDS AND 1.4 ON 45° BENDS.

OFFSET →		2	4	6	8	10	12	14	16	18	20	22
15°	MAX CONDUIT SIZE	3/4	1 1/2	2	and smaller							
	CENTER TO CENTER	7 3/4	15 7/16	23 3/16	30 15/16	38 3/8	46 3/8	54 1/16	61 13/16	69 9/16	77 1/4	85
30°	MAX 4 CONDUIT SIZE		3/4	1	1 1/2	2	and smaller					
	CENTER TO CENTER		8	12	16	20	24	28	32	36	40	44
45°	MAX CONDUIT SIZE			1/2	1	1 1/4	1 1/2	2	and smaller			
	CENTER TO CENTER			8 1/2	11 5/16	14 1/8	16 15/16	19 13/16	22 5/8	25 7/16	28 1/4	31 1/8

FIGURES ARE APPROX.

**CHART D**

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 APPROX.

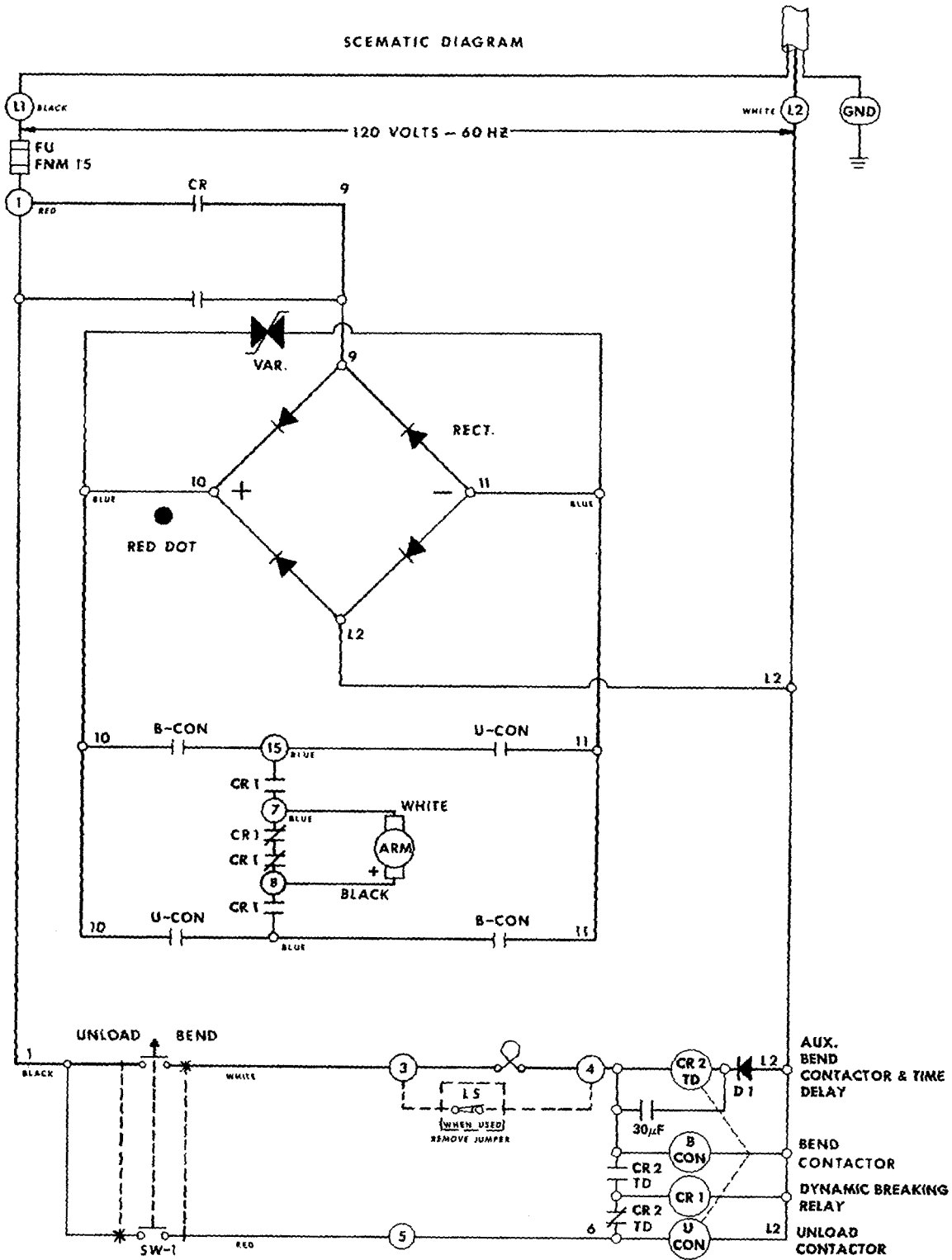


Fig. 3. Wiring Diagram No. 555 Electric Bender

## PARTS LIST

### No. 555 ELECTRIC BENDER

KEY	CONTROL NO.	DESCRIPTION	QTY.
		<b>No. 555 Electric Bender, 115 V.</b>	
		<b>No. 555-22 Electric Bender, 230 V.</b>	
1	502 3424.2	Bender Chassis	1
2	501 8005.3	Sprocket Assembly	1
3	905 2414.4	Retaining Ring	1
4	502 3443.9	Cover Plate	1
5	501 8009.6	No. 60 Chain	1
6	501 8014.2	Protractor	1
7	502 3891.4	Sprocket & Shaft Assembly	1
8	905 2412.8	Counter Shaft Bearing	2
9	905 2397.0	Hinge Pin	2
10	905 0067.9	5/8-11 X 1 Hex. H.P. Cap Screw with	1
11	905 0905.6	5/8 Lockwasher (Split)	1
12	501 8018.5	No. 60 Chain Idler	1
13	905 2398.9	Wheel	2
14	905 0658.8	3/16 "x 1-1/2" Cotter Pin	2
15	502 3461.7	Chain Guard	1
16	501 8028.2	Counter Shaft Key	2
17	502 3444.7	Sprocket	1
18	905 1051.8	Retaining Ring	1
19	502 3457.9	No. 40 Chain Idler	1
20	905 0506.9	3/8 Lockwasher (Split)	6
21	502 3418.8	No. 40 Chain	1
22	905 1435.1	3/8-16 Hex. Nut	4
23	502 3897.3	Sprocket Key	1
24	502 3450.1	Sprocket	1
25	502 3480.3	Guard	1
26	502 3419.6	Control Box Assembly (115 volt)	1
27	502 3438.2	Axle	1
28	502 3459.5	Bracket, Top Mounting	
29	502 3460.9	Bracket, Bottom Mounting	1
30	502 3477.3	Guard Plate, Bottom	1
31	502 3474.9	Spacer, Wheel	1
32	501 2121.9	Decal,	2
33	501 9053.9	Decal, Extension Cord	1
34	502 3452.8	Washer, Fiber	1
35	502 3462.5	Decal, Instruction	1
36	502 5928.8	Nameplate	1
37	905 0506.9	3/8 Lockwasher (Split)	9
38	905 0529.8	Screw, 3/8-16 x 3/4 Hex. Hd. Cap	7
39	905 0639.1	Nut, 3/8-16 Hex Regular Full	4
40	905 0852.1	Pin, 3/32 x 3/4 Long Cotter	1
41	905 0863.7	Screw, 3/8-16 x 7/8 Hex. Hd. Cap	3
42	905 1740.7	Washer, 13/16 x 1-1/2 x 9/64 Steel	2
43	905 1751.2	Screw, #6 x 3/16 Rd. Hd. Drive	4
44	905 2388.1	Reducer	1
45	905 2395.4	Link, #60 Chain Connecting	1
46	905 0532.8	Screw, 3/8-16 x 1-1/4 Hex. Hd. Cap	1
47	905 2400.4	Screw, 1/4-20 x 1/4 Cup Pt. Skt. Set	1

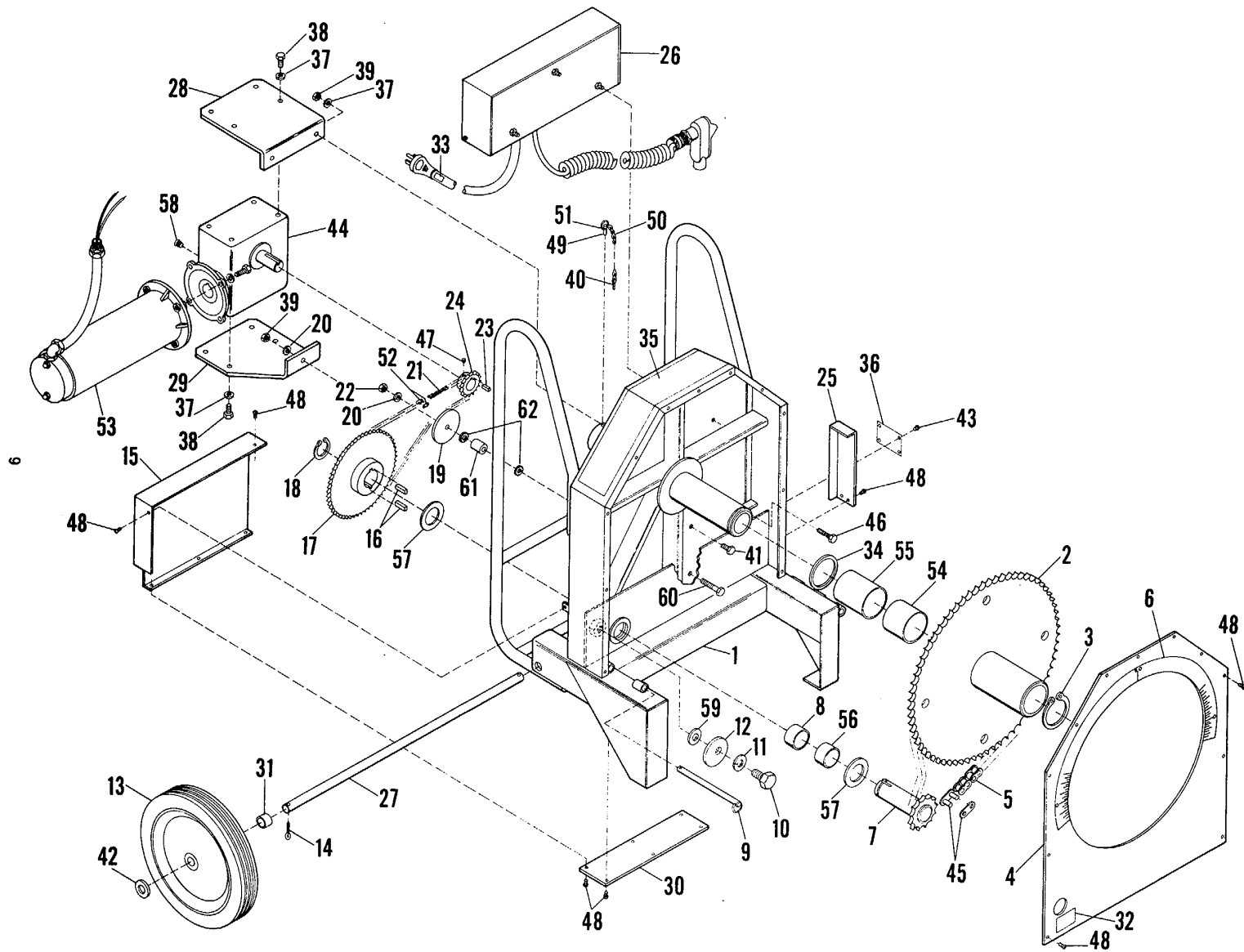


Fig.4. Exploded View No. 555 Electric Bender Eff. S/N PL24101

## PARTS LIST

### No. 555 ELECTRIC BENDER

*Order By This  
Number Only*

*When Ordering Parts Give  
Serial Number of Unit*

KEY	CONTROL NO.	DESCRIPTION	QTY.
48	905 2401.2	Screw, #10-32 x 3/8	22
49	905 2404.7	Pin, 1/4 x 1" Clinch	1
50	905 2405.5	Chain, 1/0 x 9"	1
51	905 2406.3	Ring,	1
52	905 2787.9	Link, #40 Chain Connecting	1
53	918 5775.9	Motor, Applied SR	1
54	905 2409.8	Bearing, Fiberslide Sleeve	1
55	905 2410.1	Bearing, Fiberglide Sleeve	1
56	905 2412.8	Bearing, Fiberglide Sleeve	2
57	905 2413.6	Bearing, Fiberglide Thrust	1
58	905 0503.4	Plug, 3/8 NPTF Dry Seal	1
59	905 2416.0	Washer, 5/8 Flat	1
60	905 0535.2	Screw, 3/8-16 NC x 2" Hex. Hd. Cap	1
61	502 5932.6	Spacer, Idler	1
62	905 2427.6	Lockwasher, Shake-Proof	2
	501 9102.0	Repair Kit, No. 40 Chain (Not Shown)	Optional
	501 9103.9	Repair Kit, No. 60 Chain (Not Shown)	Optional
63	502 3902.3	Contactor Unit	1
64	918 5852.6	Electrolytic Capacitor	1
65	502 3906.6	Pendant Switch Unit	1
		Includes Key Nos. 66-72 & 87	
66	502 1106.4	Conduit Cover	
67	918 5314.1	Condulet	1
68	918 5873.9	Hole Plug	1
69	502 4598.8	Retractable Cord	1
70	918 5882.8	Toggle Switch	1
71	918 5883.6	Cover Gasket	1
72	918 5887.9	Condulet Insulation	1
73	502 4689.5	Enclosure	1
74	918 5853.4	Relay	1
75	918 5866.6	Relay, Contactor	1
76	918 5997.2	Rectifier, 115 volt	1
	918 5888.7	Rectifier, 230 volt	1
77	918 5868.2	Varistor, 115 volt	1
	918 5889.5	Varistor, 230 volt	1
79	918 5995.6	Fuse Holder	1
80	918 5996.4	End Piece	1
81	918 5872.0	Terminal, 115 volt	
	918 5872.0	Terminal, 230 volt	10
82	918 5874.7	Diode	1
83	918 5875.5	1/2" Connector	1
84	918 5876.3	1/2" 90° Connector	1
85	918 5877.1	Fusetron, 15 amp-FNM-15	1
	918 5890.9	Fusetron, 8 amp-FNM-8	2
86	918 5264.1	Power Cord	1
87	918 5884.4	Cord Grip	2
88	918 5885.2	Cord Grip	1
89	918 5886.0	Jumper	1
90	918 5891.7	Transformer, 230 volt	1
91	502 2770.4	Ring, Locking	1
92	918 5868.2	Varistor, 115 volt	1

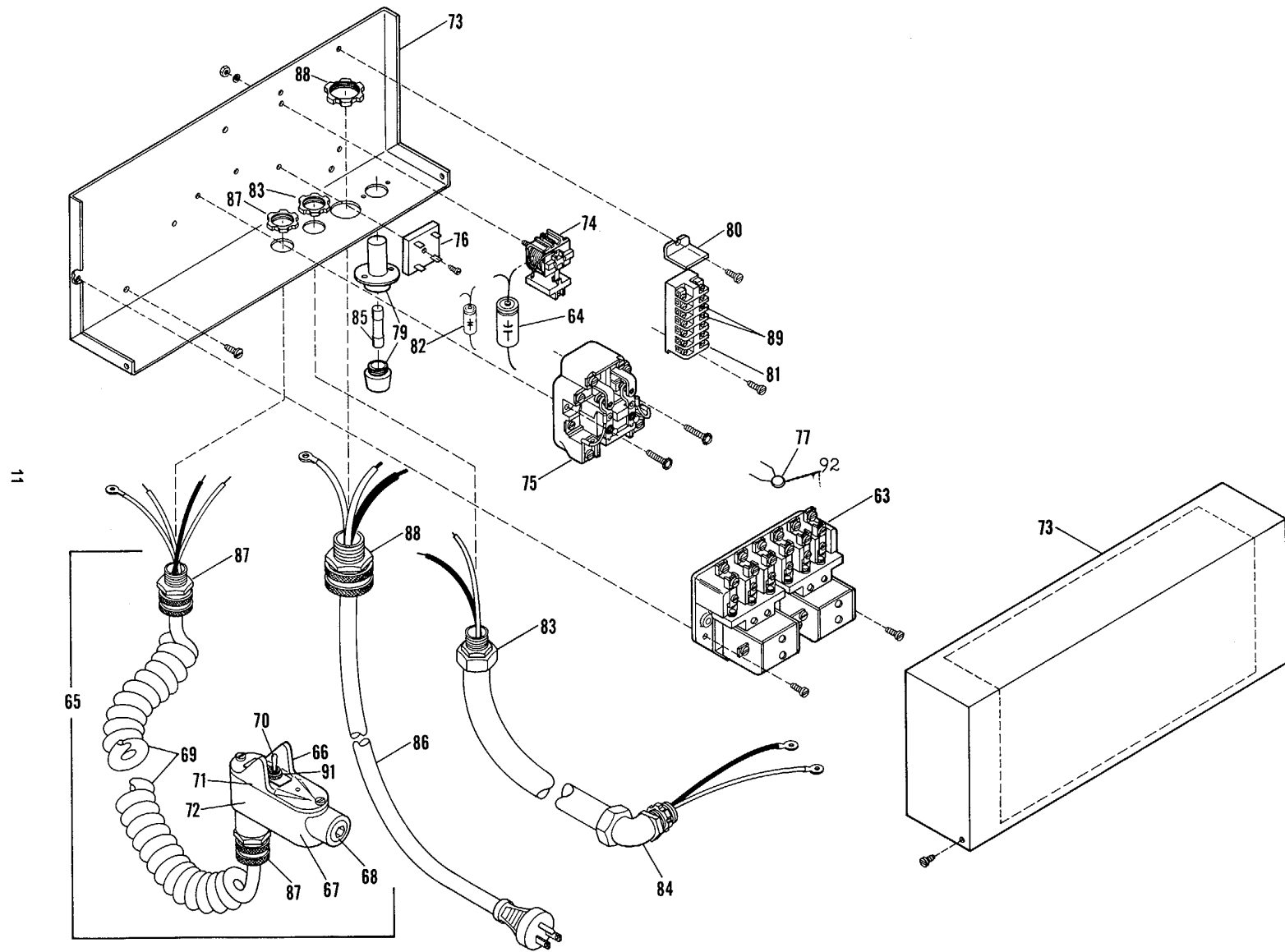


Fig. 5. Exploded View Control Box Assembly Eff. S/N PL24101



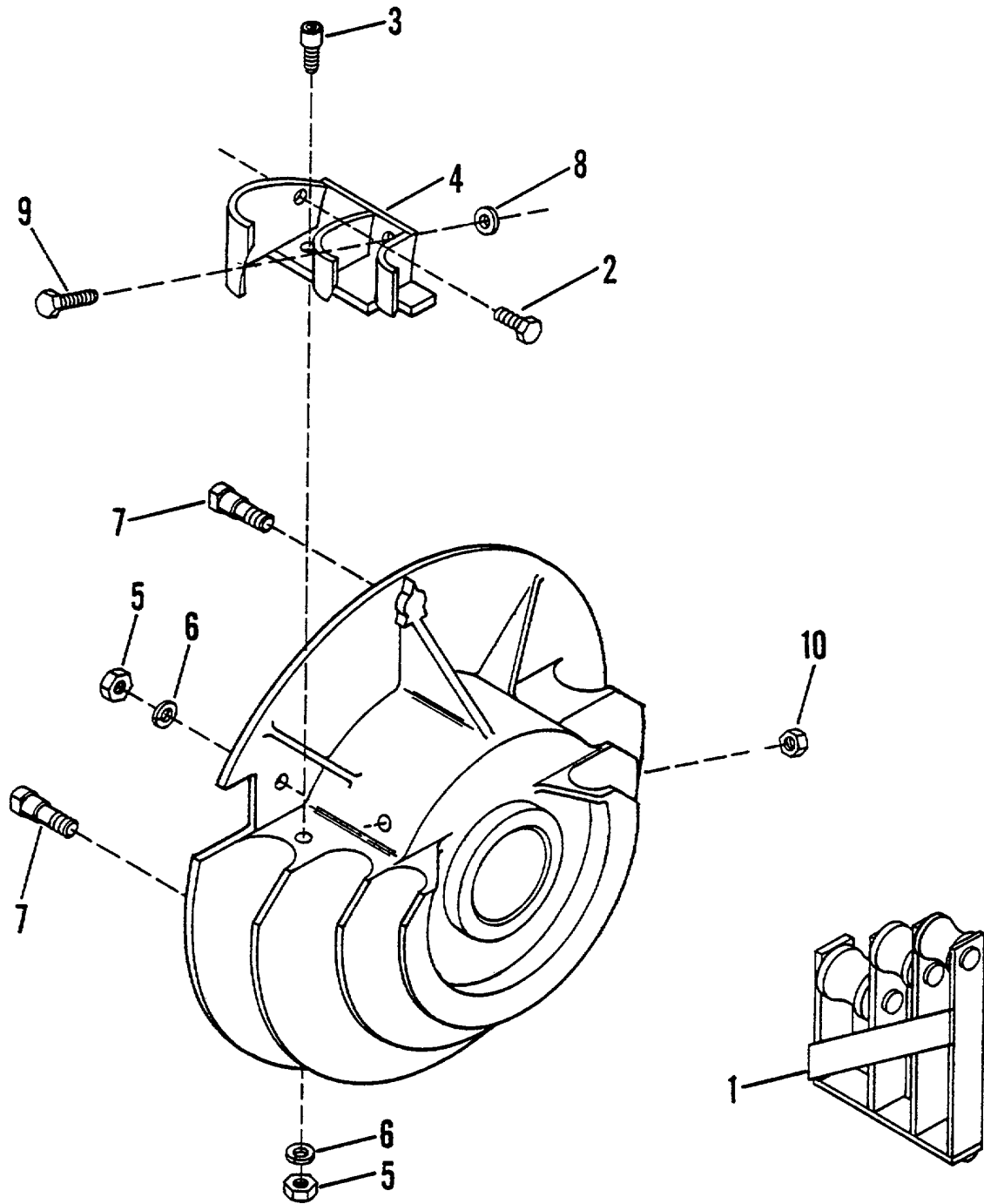


Fig. 6. Bending Shoe & Support Roller 1/2-1-1/4" Rigid Conduit

**PARTS LIST**

**No. 555 ELECTRIC BENDER**

*Order By This  
Number Only*

*When Ordering Parts Give  
Serial Number of Unit*

<b>KEY</b>	<b>CONTROL NO.</b>	<b>DESCRIPTION</b>	<b>QTY.</b>
1	<b>501 7979.9</b>	<b>Support Roller</b> 1/2 - 1-1/4 Rigid Conduit	1
	<b>501 7935.7</b>	<b>Bending Shoe Assembly</b>	1
2	<b>905 0530.1</b>	3/8-16 x 1 Hex. Hd. Cap Screw	1
3	<b>905 0597.2</b>	3/8-16 x 1 Skt. Hd. Cap Screw	1
4	<b>501 7966.7</b>	Pipe Hook	1
5	<b>905 1435.1</b>	3/8-16 Hex. Nut Cad. Plated	2
6	<b>905 0506.9</b>	3/8 Lockwasher (Split)	2
7	<b>502 3422.6</b>	Stud, Drive	4
8	<b>502 4735.2</b>	Washer, 3/4 x 7/16 x 1/8 Neoprene	1
9	<b>905 0532.8</b>	3/8-16 x 1-1/4 Hex. Hd. Cap Screw	1
10	<b>905 2646.5</b>	3/8-16 NC Lock Nut	1

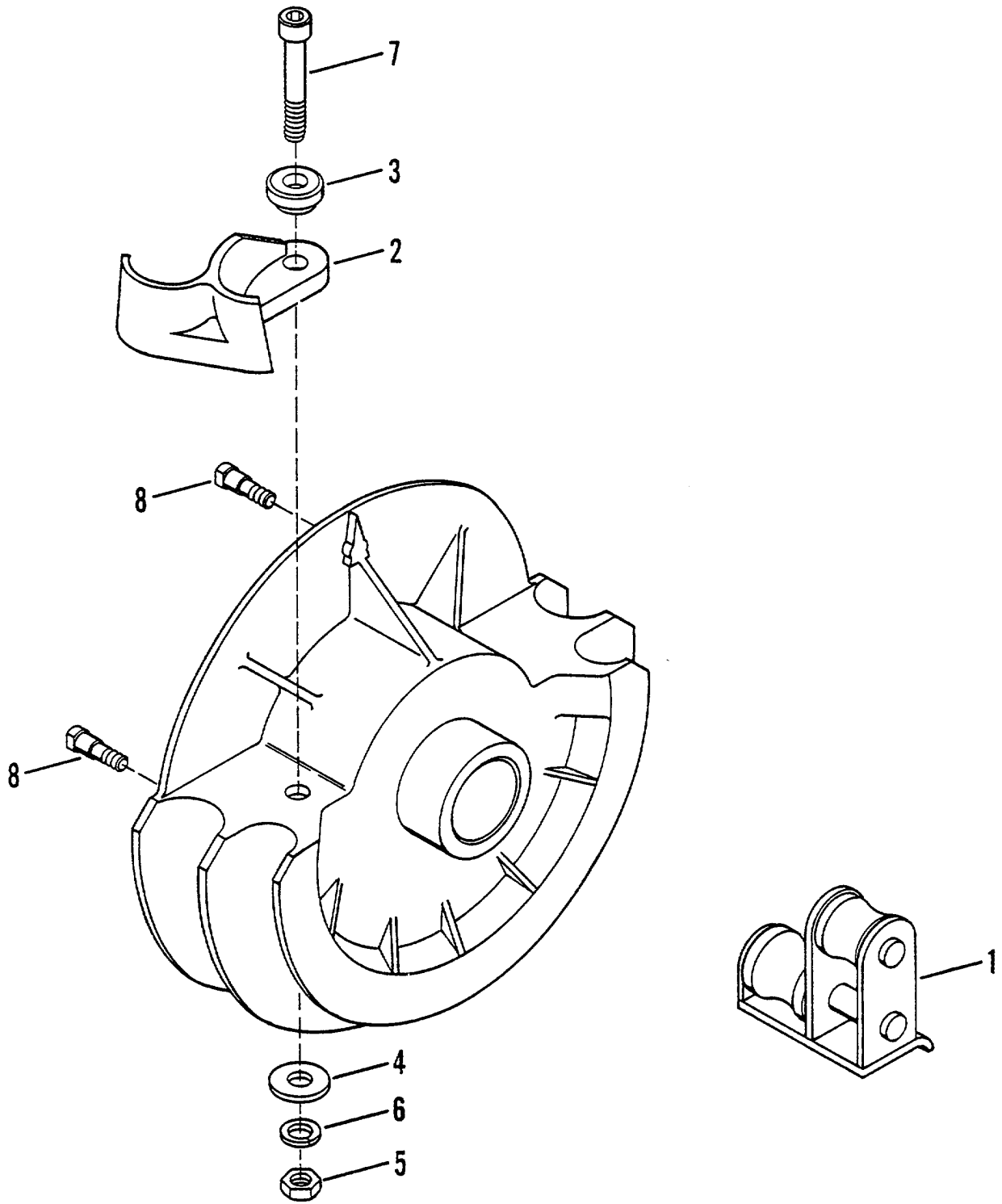


Fig. 7. Bending Shoe & Support Roller 1-1/2-2" Rigid Conduit

## PARTS LIST

### No. 555 ELECTRIC BENDER

*Order By This  
Number Only*

*When Ordering Parts Give  
Serial Number of Unit*

KEY	CONTROL NO.	DESCRIPTION	QTY.
1	501 7984.5	<b>Support Roller</b> , 1-1/2-2" Rigid Conduit	1
	501 7937.3	<b>Bending Shoe Assembly</b> , 1-1/2-2" Rigid Conduit	1
2	501 7969.1	Pipe Hook	1
3	501 7974.8	Pivot	1
4	905 2675.9	5/8-Flat Washer	1
5	905 1569.2	5/8-11 Hex. Nut	1
6	905 0905.6	5/8 Split Lockwasher	1
7	905 2426.8	5/8-11 x 3-3/4 Skt. Hd. Cap Screw	1
8	502 3422.6	Stud, Drive	4

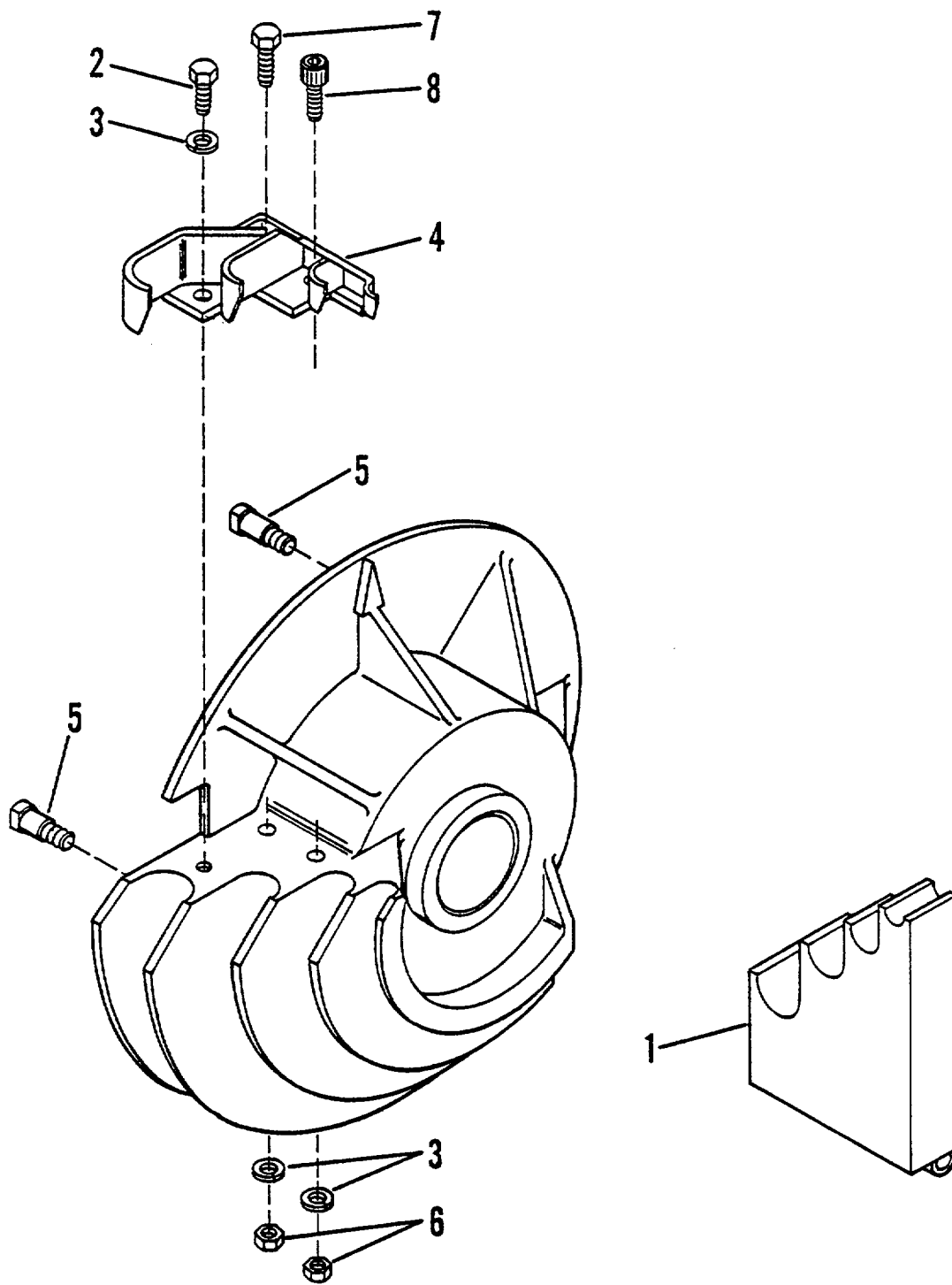


Fig. 8. Bending Shoe & Pipe Rest 1/2-1-1/4" EMT Conduit

## PARTS LIST

### No. 555 ELECTRIC BENDER

*Order By This  
Number Only*

*When Ordering Parts Give  
Serial Number of Unit*

KEY	CONTROL NO.	DESCRIPTION	QTY.
1	501 7986.1	<b>Pipe Rest Assembly</b> for 1/2 -1-1/4 EMT Conduit (Includes Key Nos. 1-5)	1
	501 7944.6	<b>Bending Shoe Assembly</b> for 1/2 -1-1/4 EMT Conduit (Includes Key Nos. 8-18)	
2	905 0530.1	3/8-16 x 1 Hex. Hd. Cap Screw, Cad Pltd	1
3	905 0506.9	3/8 Lockwasher (Split)	3
4	502 4555.4	Pipe Hook	1
5	502 3422.6	Stud, Drive	4
6	905 0639.1	3/8-16 Hex. Nut, Cad. Plated	2
7	905 0532.8	3/8-16 x 1-1/4 SAE Grade 5 Hex. Head Cap Screw	
8	905 1088.7	3/8-16 x 1-1/4 Skt. Hd. Screw 1	1

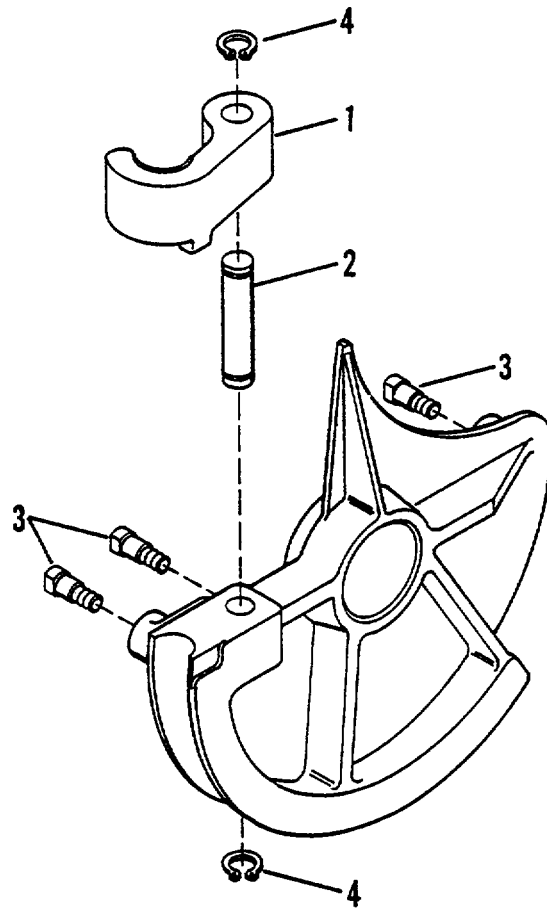


Fig. 9. Bending Shoe 1-1/2" EMT Conduit

**PARTS LIST**

**No. 555 ELECTRIC BENDER**

*Order By This  
Number Only*

*When Ordering Parts Give  
Serial Number of Unit*

<b>KEY</b>	<b>CONTROL NO.</b>	<b>DESCRIPTION</b>	<b>QTY.</b>
	<b>502 3499.4</b>	<b>Shoe Unit, 1-1/2" EMT</b> (Includes Key Nos. 1 thru 4)	1
1	<b>501 8820.8</b>	Hook, 1-1/2" EMT	1
2	<b>501 8841.0</b>	Pin, 1-1/2" EMT Hook	1
3	<b>502 3422.6</b>	Stud, Drive	3
4	<b>905 1529.3</b>	Ring, Retaining	2



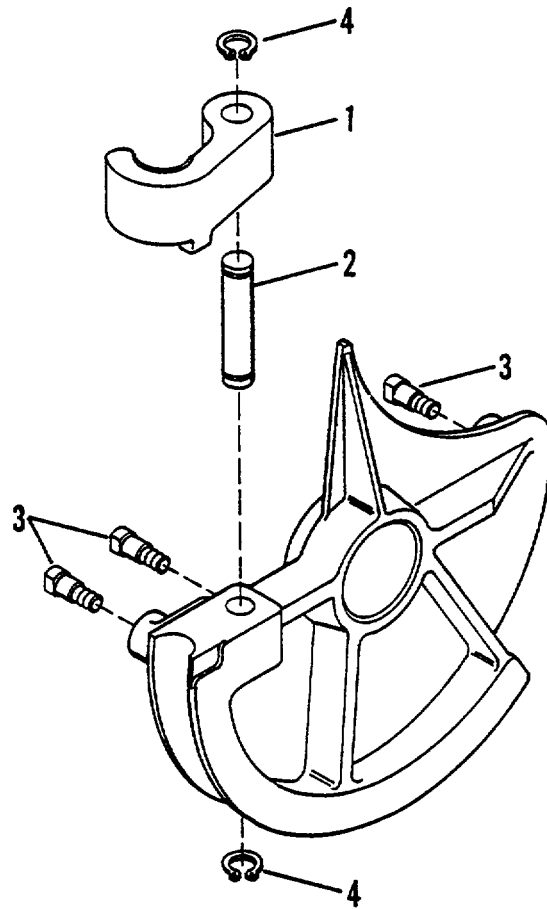


Fig. 10. Bending Shoe 2" EMT Conduit

**PARTS LIST**

**No. 555 ELECTRIC BENDER**

*Order By This  
Number Only*

*When Ordering Parts Give  
Serial Number of Unit*

<b>KEY</b>	<b>CONTROL NO.</b>	<b>DESCRIPTION</b>	<b>QTY.</b>
	<b>502 3505.2</b>	<b>Shoe Unit, 2' EMT</b> (Includes Key Nos. 1 thru 4)	1
1	<b>501 8818.6</b>	Hook, 2" EMT	1
2	<b>501 8842.9</b>	Pin, 2" EMT Hook	1
3	<b>502 3422.6</b>	Stud, Drive	3
4	<b>905 1529.3</b>	Ring, Retaining	2

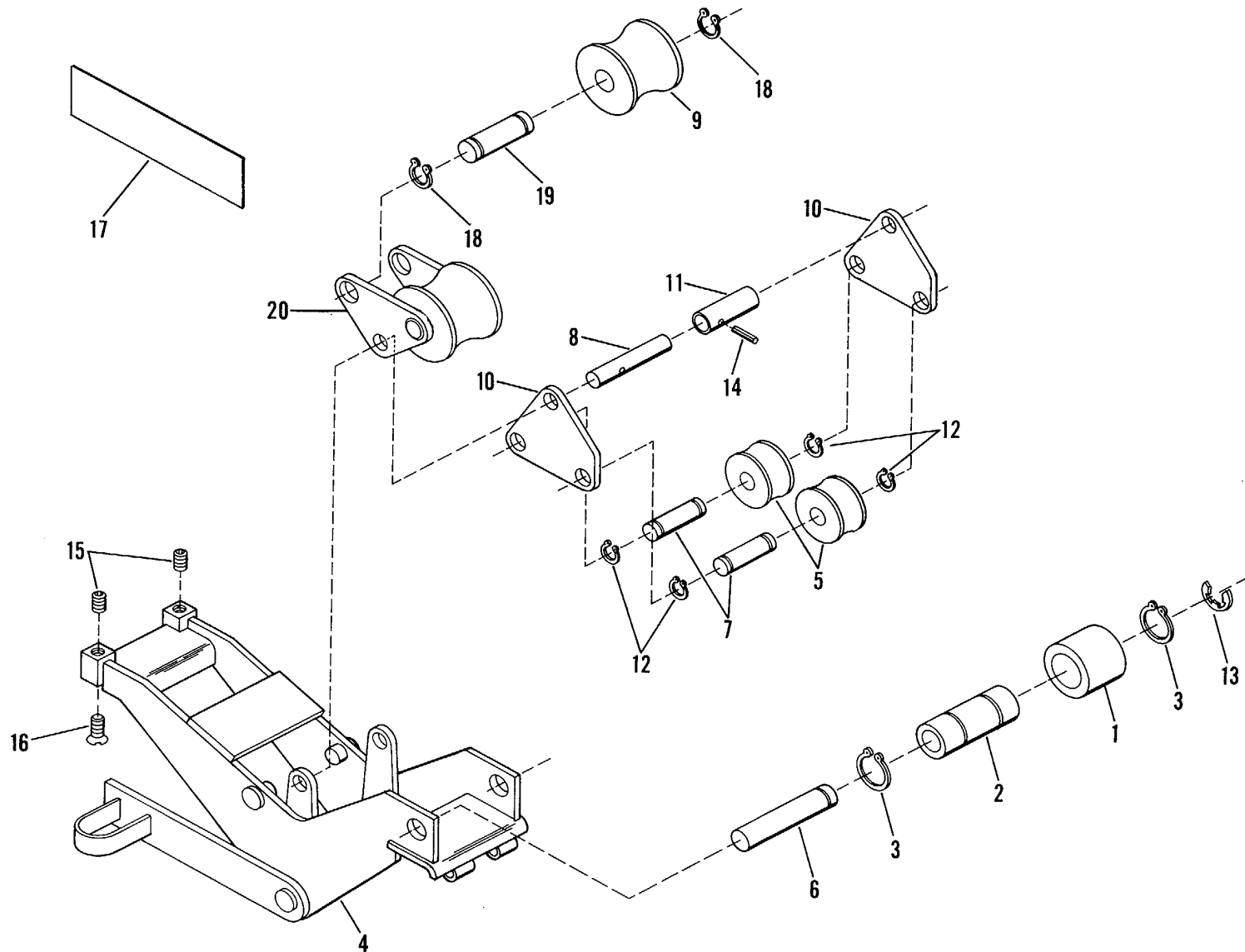


Fig. 11. EMT Roller Support Unit

## PARTS LIST

### No. 555 ELECTRIC BENDER

*Order By This  
Number Only*

*When Ordering Parts Give  
Serial Number of Unit*

KEY	CONTROL NO.	DESCRIPTION	QTY.
	<b>502 3541.9</b>	<b>Support Unit, 1-1/2" &amp; 2" EMT Roller</b>	1
		(Includes all of the following)	
	<b>502 3538.9</b>	<b>Roller Unit, Cushioned</b>	1
		(Includes Key Nos. 1 thru 3)	
1	<b>502 3056.5</b>	Cushion	1
2	<b>502 3521.4</b>	Liner	1
3	<b>905 1224.3</b>	Ring, Retaining	2
4	<b>502 3539.7</b>	Frame Unit	1
5	<b>502 3510.9</b>	Roller, 1-1/2" EMT	2
6	<b>502 3511.7</b>	Pin, Roller Support	1
7	<b>502 3932.5</b>	Pin, 1-1/2" EMT Roller	2
8	<b>502 3517.6</b>	Pin, Roller Pivot	1
9	<b>502 3519.2</b>	Roller, 2" EMT Front	1
10	<b>502 3524.9</b>	Plate, 1-1/2" EMT Pivot	2
11	<b>502 3793.4</b>	Spacer	1
12	<b>905 1528.5</b>	Ring, Retaining	4
13	<b>905 2464.0</b>	Ring, External Series E Retaining	2
14	<b>905 1491.2</b>	Rollpin, #59-040-187-1250	1
15	<b>905 2469.1</b>	Screw 1/2-13 x 3/4 Cup Pt. Skt. Set	2
16	<b>905 2470.5</b>	Screw, 1/2-13 x 1 Skt. Flat Hd. Cap	2
17	<b>502 3817.5</b>	Gage, 2" EMT Roller Support	1
18	<b>905 1301.0</b>	Retaining Ring	2
19	<b>502 3931.7</b>	Pin, 2" EMT Front Roller	1
20	<b>502 4788.3</b>	Back Roller Unit	1

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