NTMA PRECISION

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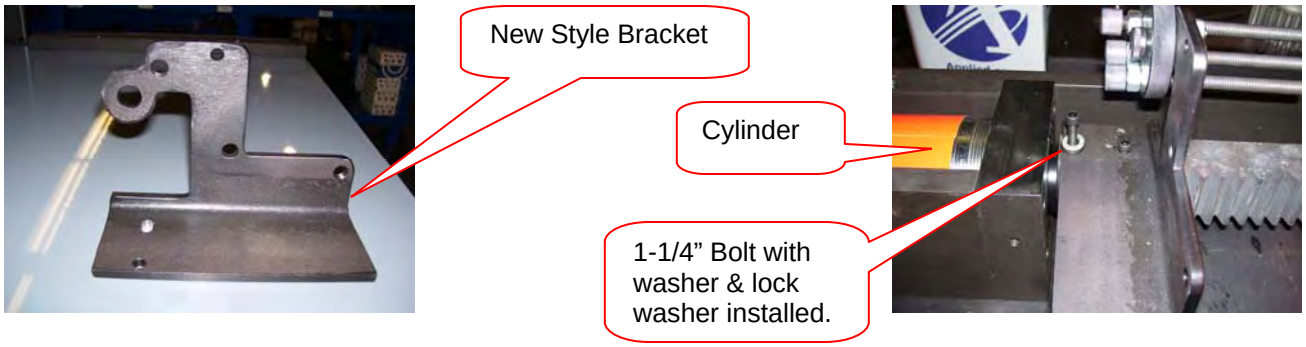
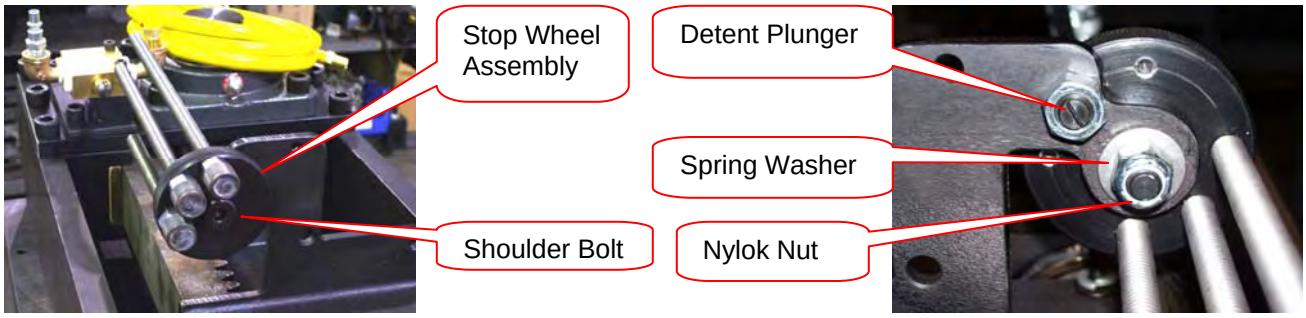
2500-400 Bend Stop

For 2500 180° Hydraulic Bender

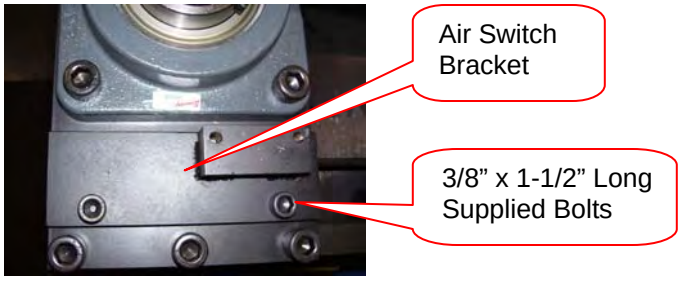
1. Check to see if your bender has the old style (simple angle iron) or new style mount as shown below. If you have the old style bracket go to step **#2**. If you have the new style bracket go to step # **3**.
2. If you have the old style mount, remove the return spring carefully and then unbolt the bracket from the rack.
3. Mount the new style bracket to the rack being sure to use the 1-1/4" long allen bolt, flat washer & lock washer in the hole closest to the cylinder. ***This is critical so the rack does not bind on the cylinder.***



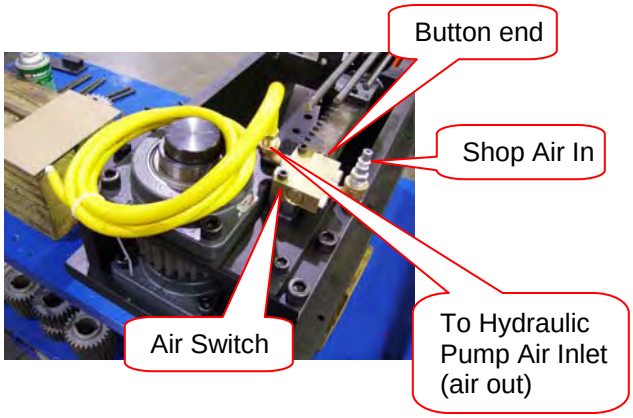
4. Bolt the **STOP WHEEL** assembly to the new style bracket. Use the supplied shoulder bolt, spring washer and Nylock nut installed as shown below. Install the **DETENT BUTTON** as shown, set the tension and then jam the nut.



5. Bolt the Air Switch bracket to the bearing mounting block. Remove the installed bolts and use the supplied 1-1/2" allen bolts to attach the bracket. Be sure the bolts are **TIGHT**.



6. Bolt the **AIR SWITCH** to the mounting block using the ¼" x 1" allen bolts as shown below. Be sure the button end is pointed toward the cylinder end of the bender and that the elbow fitting without anything screwed into it is pointed to the bearing.



7. Hook your shop air supply to the **Elbow Fitting** as shown above.

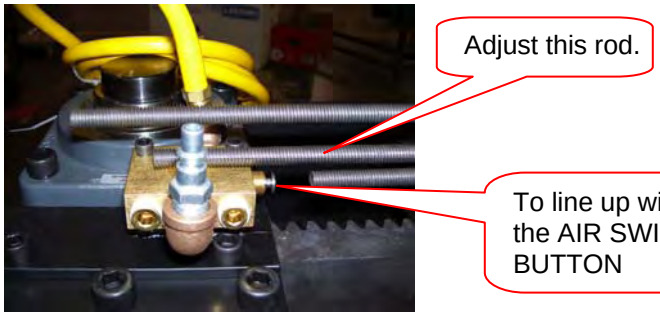
8. Hook one end end of the **Supplied Hose** to the **Air Out Elbow** and then to the air inlet of your air-hydraulic pump.

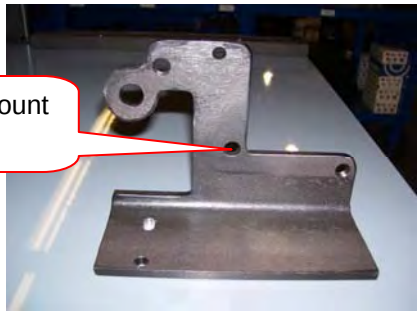
9. Be sure the **STOP WHEEL** is rotated so no rods will contact the **AIR SWITCH BUTTON** when the bender is actuated.

10. Reattach the return spring to the bracket as shown below in step #**12**.

11. Bend a sample piece of tubing to the desired degree using the Digital readout set MM. Stop the bender but do not release the pedal.

12. Rotate the **STOP WHEEL** to a position that will allow one of the **STOP RODS** to be adjusted to just touch the **AIR SWITCH Button** as shown in the example below. Once the length is set be sure the STOP WHEEL is in a detent.





13. Rotate the **STOP WHEEL** until the **Adjuster Bolt** just touches the **Air Switch Button**, and then adjust the rod into the button until you hear the air flow to the pump quit. Tighten the jam nut on the **STOP ROD**.

14. Make one more test bend using this setting. Fine tune this adjustment as needed by following repeating steps #**11** & #**12** above.

15. This stop is now set to your desired degree of bend for this tube size and shoe radius. This may have to be readjusted for time to time because of variances in tubing wall thickness and material quality.

16. The other two stops can be set in the same way for other degrees or tubing sizes. A “cheat” sheet with STOP ROD lengths for different sizes will help you get a quick adjustment before fine tuning.

KIT CONTENTS:

1ea. Air Switch Mounting Bracket
1ea. Air Switch (w/ two elbows & one air fitting)
1ea. Air Hose
1ea. Stop Wheel Assembly (knurled knob w/ threaded rods installed)
1ea. Stop Wheel / Spring Return Bracket
2ea. ¼-20 x 1” SHCS for mounting air switch
2ea. 3/8-16 x 1-1/2” SHCS for mounting air switch bracket
1ea. Shoulder bolt for mounting stop wheel assembly
1ea. Spring washer for mounting stop wheel assembly
1ea. Detent ball assembly for stop wheel
1ea. 3/8 Nylok Nut foe shoulder bolt on stop wheel
1ea. ¼-20 x 1-1/4” SHCS for bracket to rack mount at cylinder end
1ea. ¼” Lock washer
1ea. Air Flat washer
1ea. Instruction sheet

We appreciate your business and hope that you enjoy your new Mittler Bros. Product. If you have any questions or concerns please feel free to call us at 1-800-467-2464 for help.