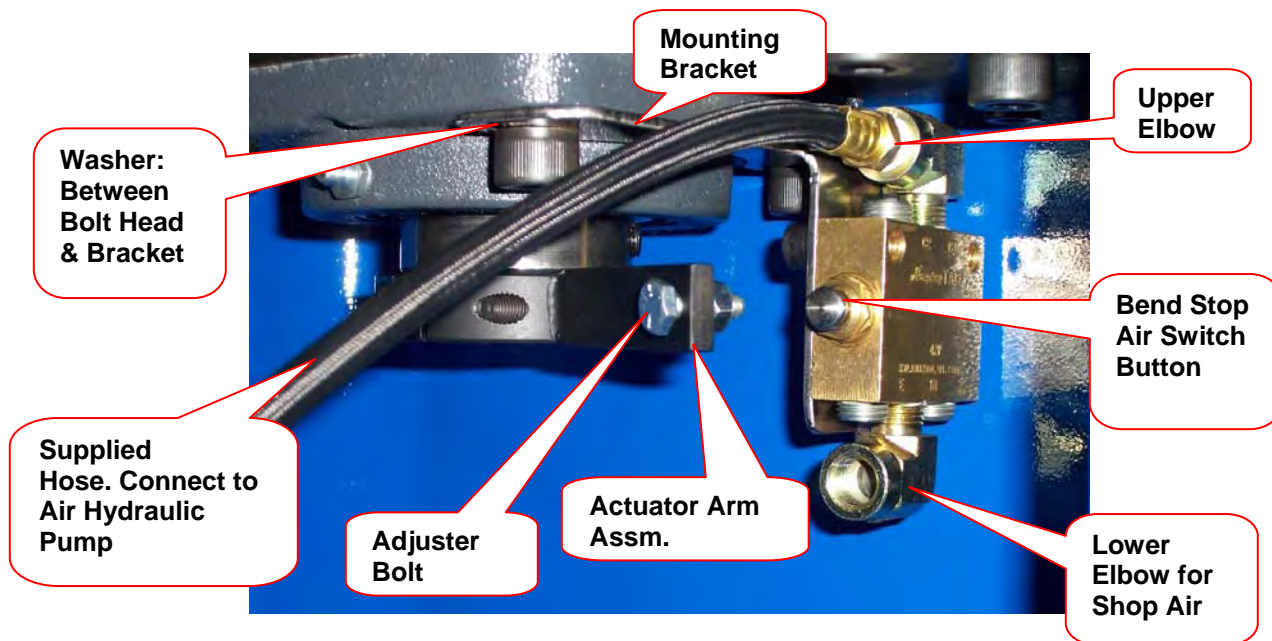


Division of Mittler Corp.
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2500-400 Bend Stop For 2500 180° Hydraulic Bender

1. Bolt the bend stop air switch and **Mounting Bracket** assembly onto the machine. Position yourself at the side of the machine so your left hand is near the hydraulic cylinder and your right hand is closest to the digital read out. Underneath the machine top, the two bolts closest to you that hold the bearing block in place need to be removed. (see next page for orientation of machine)
2. Slip the supplied **Washers** over the bolts and then slip the bolts through the stop **Mounting Bracket**. Thread the bolts back into the bearing mounting holes. Tighten these bolts back down.
3. Hook your shop air supply to the **Lower Elbow Fitting** on the bend stop.
4. Hook the loose end end of the **Supplied Hose** to the **Upper Elbow** and then to the air inlet of your air-hydraulic pump.

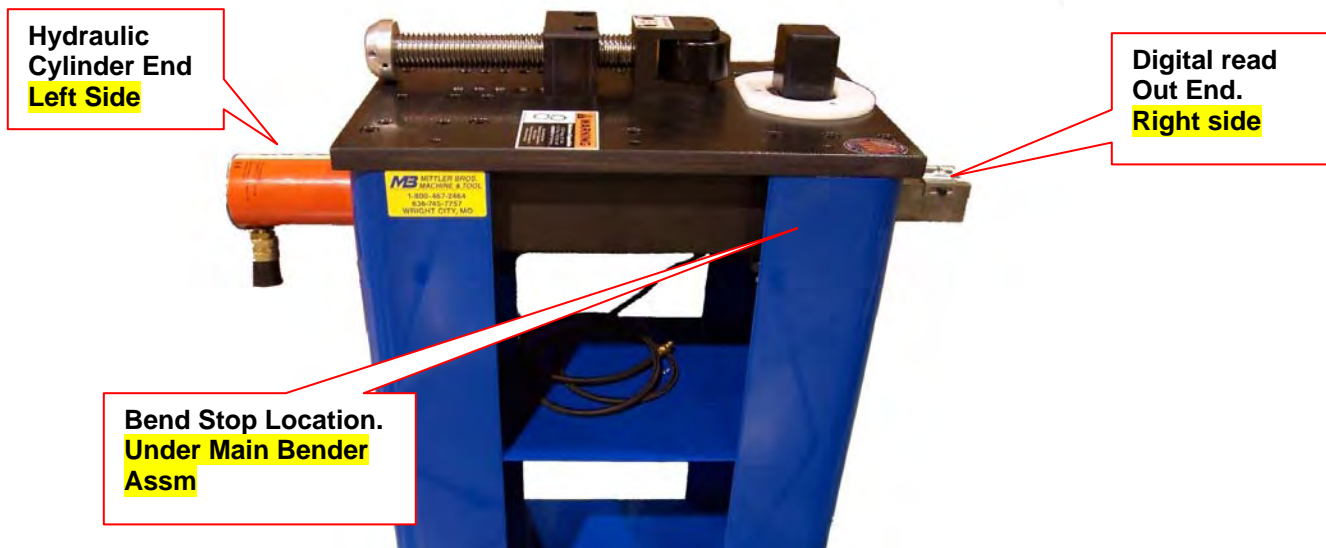


5. Leave the **Actuator Arm Assm.** off. Check the benders operation by stepping on the air-hydraulic unit pedal and be sure the bender operates correctly.
6. Bend a sample piece of tubing to the desired degree using the Digital readout set MM. Stop the bender but do not release the pedal.
7. Slip the **Actuator Arm Assm.** over the main shaft and lightly tighten the clamping bolts.

8. Rotate the **Actuator Arm Assm.** until the **Adjuster Bolt** just touches the **Air Switch Button**, then tighten down the clamping bolts the rest of the way.
9. Once the clamping bolts are tight, screw the **Adjuster Bolt** toward the **Air Switch Button** until the button is about half way depressed. Step on the pedal and see if the pump pumps. If the pump starts to pump let up on the pedal immediately and adjust the **Adjuster Bolt** in a little more. Repeat until the pump does not try to pump any more.
10. Tighten the jam nut and then repeat the bend process and double check the bend and make any adjustments needed to the **Adjuster Bolt**. This may take a few bends to get exactly what you need.
11. Remember to remove the **Actuator Arm Assm.** if you not going to be making repeat bends.

KIT CONTENTS:

- 1ea. Mounting Bracket
- 1ea. Air Switch
- 2ea. Elbows
- 1ea. Pre Made Hose (goes from to pump to air switch)
- 2ea. ½" Hard Washers
- 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.