Read and understand this material and the instruction manual supplied with the bender before operating or servicing this product. Failure to understand how to safely operate the bender could result in an accident causing serious injury or death.
**Introduction**

The new 500 4615.2 Frame Unit has replaced the 503 0176.8 frame weldment. The large roller support has been modified with the new 500 4615.2 Frame Unit. New components have been provided to accommodate this modification. Only units with serial number ZW0001 through ZW1999 will require installing these new components.

New components are:

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<tbody>
<tr>
<td>(A)</td>
<td>500 0528.6</td>
<td>1-1/2&quot; Support Weldment</td>
</tr>
<tr>
<td>(B)</td>
<td>500 0543.0</td>
<td>1-1/2&quot; Outer Support Plate</td>
</tr>
<tr>
<td>(C)</td>
<td>500 0860.9</td>
<td>1-1/2&quot; Support Shaft</td>
</tr>
<tr>
<td>(D)</td>
<td>905 0540.9</td>
<td>7/16&quot;-14 x 1&quot; Hex Head Cap Screw</td>
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</table>

Assembly of New Components (ZW0001 to ZW1999 units only):

Rework the 1-1/2" - 2" Roller Support Unit (500 0145.0) before reinstalling onto the 500 4615.2 Frame Unit.

1. Loosen set screw (98) in the 1-1/2" sleeve (87), and remove handle (86), and 1-1/2" roller assembly.

2. Remove the hex head screw (93), retaining ring (94), and side plate (75) from the 1-1/2" roller assembly.

3. Remove the 1-1/2" tail roller (84), spring guide (115), pivot balls (78), O-rings (116), half rollers (77), two Belleville washers (100) and clean parts thoroughly.

4. Lubricate all mating surfaces and roller shafts with a high quality grease.

   Reinstall the 1-1/2" tail roller (84), spring guide (115), pivot balls (78), O-rings (116), half roller (77), two Belleville washers (100), and new 1-1/2" support shaft (C) onto the new 1-1/2" support weldment (A).

   Note: Slip O-rings (116) over side plates until 1-1/2" roller unit reassembly is complete and then slip O-ring back between the half roller and pivot ball.

5. Install the new 1-1/2" outer support plate (B), and two 7/16" x 1" hex head cap screws (D) to the 1-1/2" support weldment (A). Use Loctite 271 thread adhesive on screw threads and tighten screws to 40-45 foot-pounds torque.

6. Install the 1-1/2" roller assembly, handle (86), and 1-1/2" sleeve (87) to the support arm (71) and tighten set screw (98).

7. Reinstall the 1-1/2" - 2" roller support unit, pivot shaft (91), adapter sleeve (92), three adapter sleeve screws (96), adjustment arm (74), and adjustment arm screw (97) into the new 500 4615.2 Frame Unit.

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**WARNING**

Electric shock hazard:
Disconnect bender from the power source before servicing or changing accessories.

Wear eye protection when servicing this tool. Failure to wear eye protection can result in serious eye injury from flying debris.
Drive lugs closest to hooks must engage in these holes.

Protruding Bolts
1-1/2" Roller - Exploded View (new)

New Parts

(A) 500 0528.6 1-1/2" Support Weldment ........................ 1
(B) 500 2618.6 1-1/2" Outer Roller Plate .......................... 1
(C) 500 0860.9 Support Shaft ........................................... 1
(D) 905 0540.9 7/16"-14 x 1" Hex Head Cap Screw ........ 2

(Apply Loctite 271 Adhesive to threads and tighten to 40-45 foot-pounds.)