SERVICE BULLETIN

501 0299.0
Selector Switch Upgrade Kit
for the 855 Bender
with Serial Code ABL

Read and understand all of the instructions and safety information in this manual before operating or servicing this tool.
Description

The Direction Switch Upgrade Kit for the 855 bender with serial code ABL allows a user to change from the plastic selector switch (500 1084.0) to a new metal selector switch.

If your 855 bender has a serial code of ZW, please return this component and exchange it for a Switch with Harness (503 8645.0), which is the proper repair part for the ZW series bender.

All the parts needed to upgrade the toggle switch are included in this kit:

500 8151.9 Selector Switch

Note: Washer and nut included with selector switch assembly.

Installation Instructions

WARNING
Wear eye protection when performing this procedure.
Failure to wear eye protection can result in serious eye injury from flying debris.

Required Tools

- 5/16" socket wrench
- Slot screwdriver with narrow tip (3/32")
- 9/16" open-ended wrench
- 1/2" open-ended wrench
- .156∅ metal drill bit
- Hand drill

Procedure

1. Turn off and unplug the tool.
2. Remove the top rounded shroud by removing four 5/16" hex head sheet metal screws.
3. Unplug selector switch from I/O board.
5. Use 9/16" wrench to remove nut on shaft of selector switch. Remove and discard switch assembly.
6. Using the template provided, mark location and drill .156hole. Be sure that this small hole is below the .406mounting hole so that the switch will give the proper bend and unload directions.
7. Connect direction switch to I/O board.
8. Inside bender, insert direction switch through hole.
9. On the outside, stack the lock washer and nut onto each switch’s mounting shaft.
10. Tighten the nuts with 1/2" wrench.
11. Replace knobs. Use screwdriver to tighten setscrew in each selector switch knob. Be sure to align setscrew with flat on shaft so that the switch position will line up with decal markings.
12. Replace top rounded shroud and hand-tighten four 5/16" hex head sheet metal screws.
Template for Drilling Anti-Rotation Holes

(Existing) .406\(\text{\(\phi\)}\) x 2 REF

.531

(New) .156\(\text{\(\phi\)}\) x 2