

# **Huth Tube Benders**

## **Models**

**2008**

**2806**

**1600**

**HB-10**

**2600HD**

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# ELECTRICAL SCHEMATICS

The following schematics may be used as a diagnostic tool in troubleshooting electrical problems.

**Electrical Wiring Diagram - 2008-2806, 230 VOLTS**

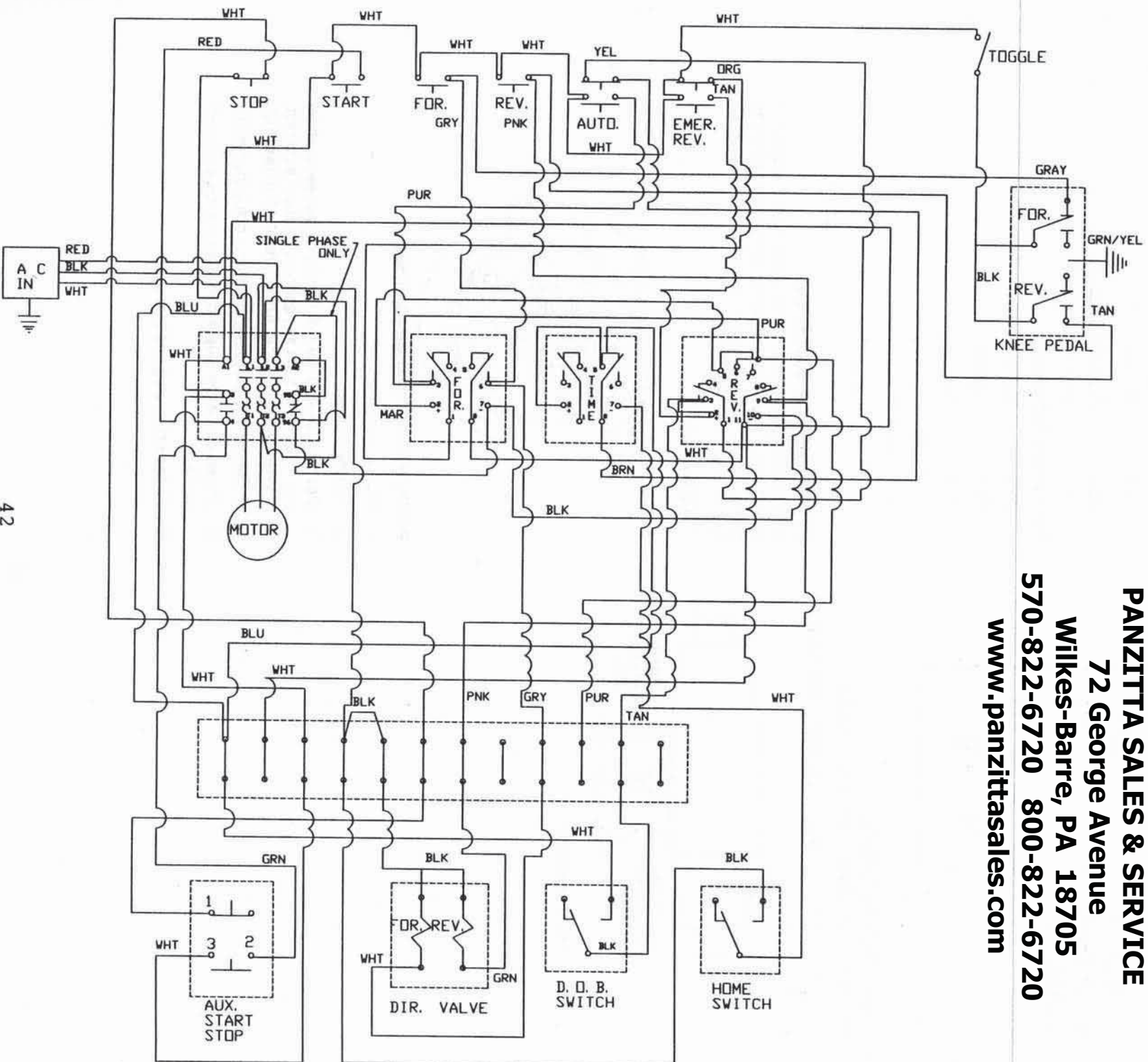
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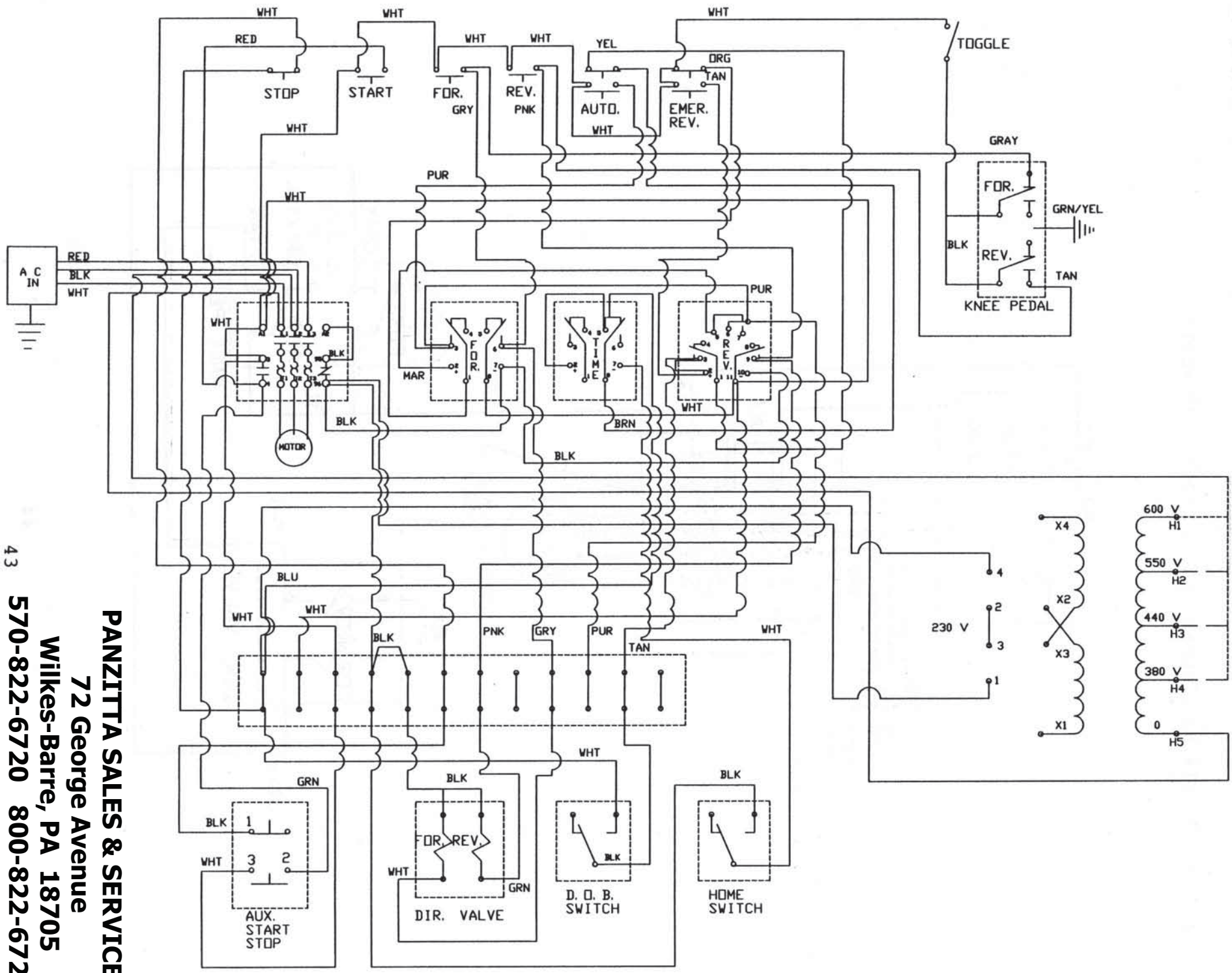
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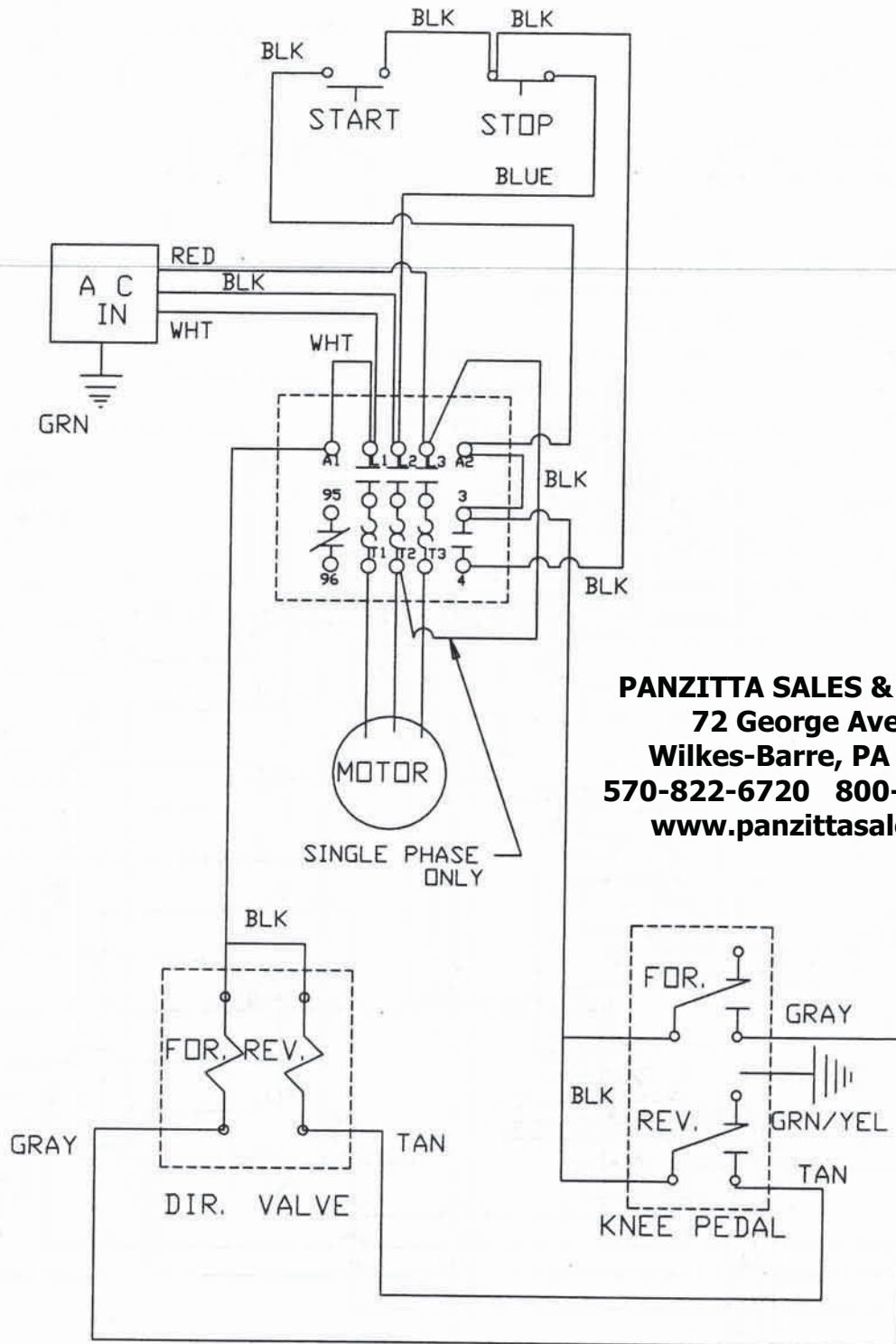
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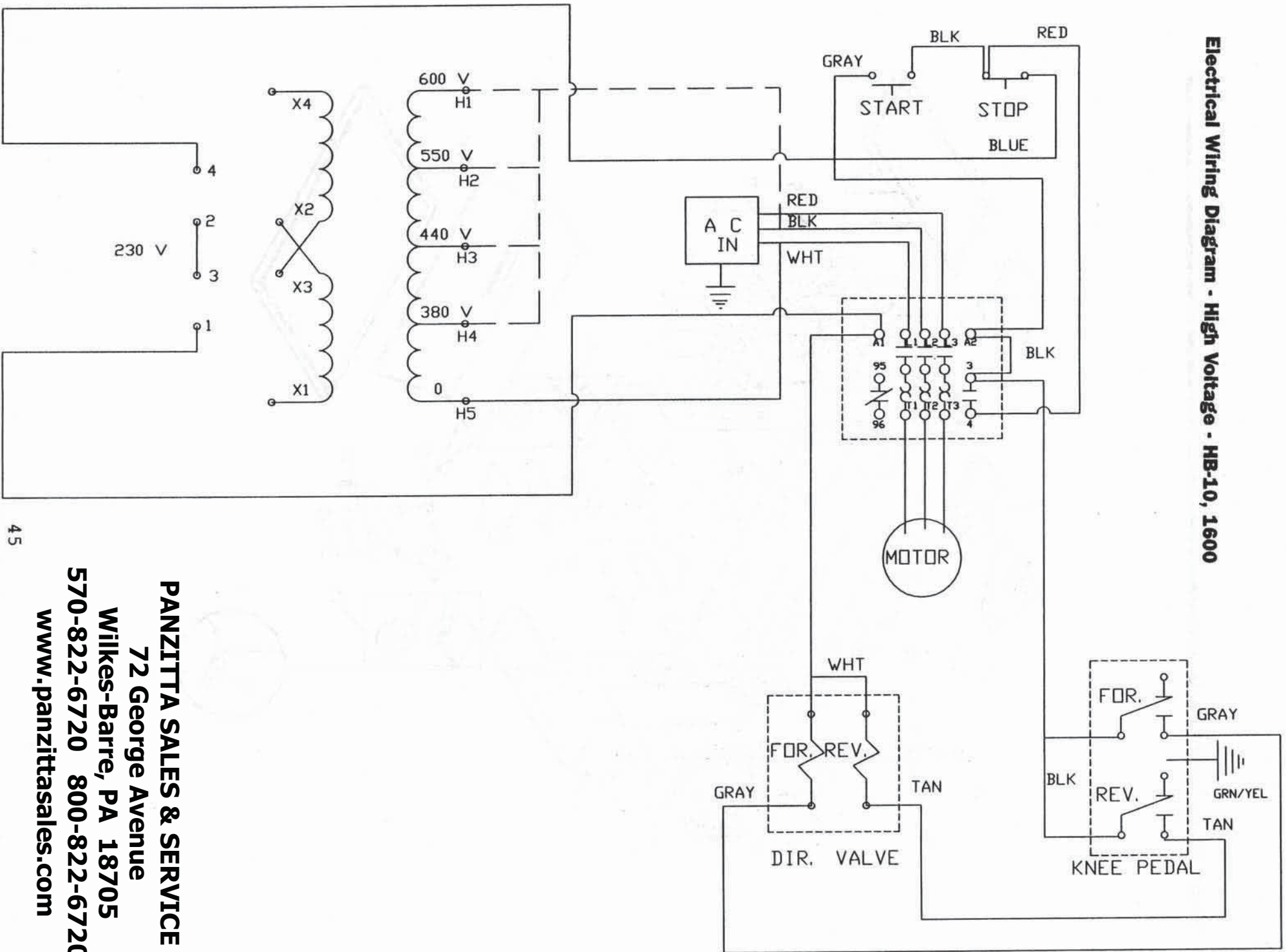
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ELECTRICAL WIRING DIAGRAM HB-10, 1600 230 VOLTS



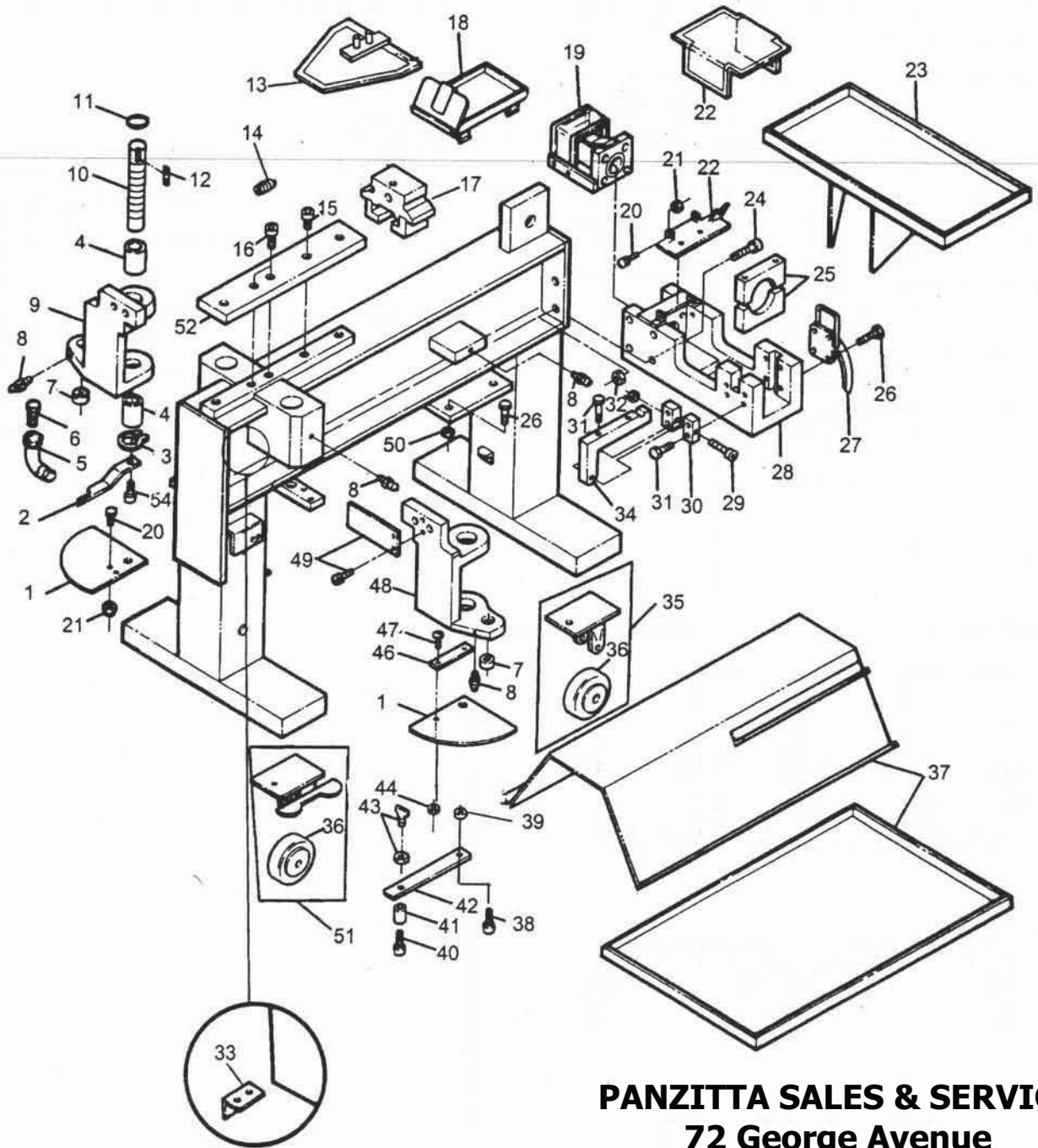
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**Electrical Wiring Diagram - High Voltage - HB-10, 1600**



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# Frame Replacement Parts

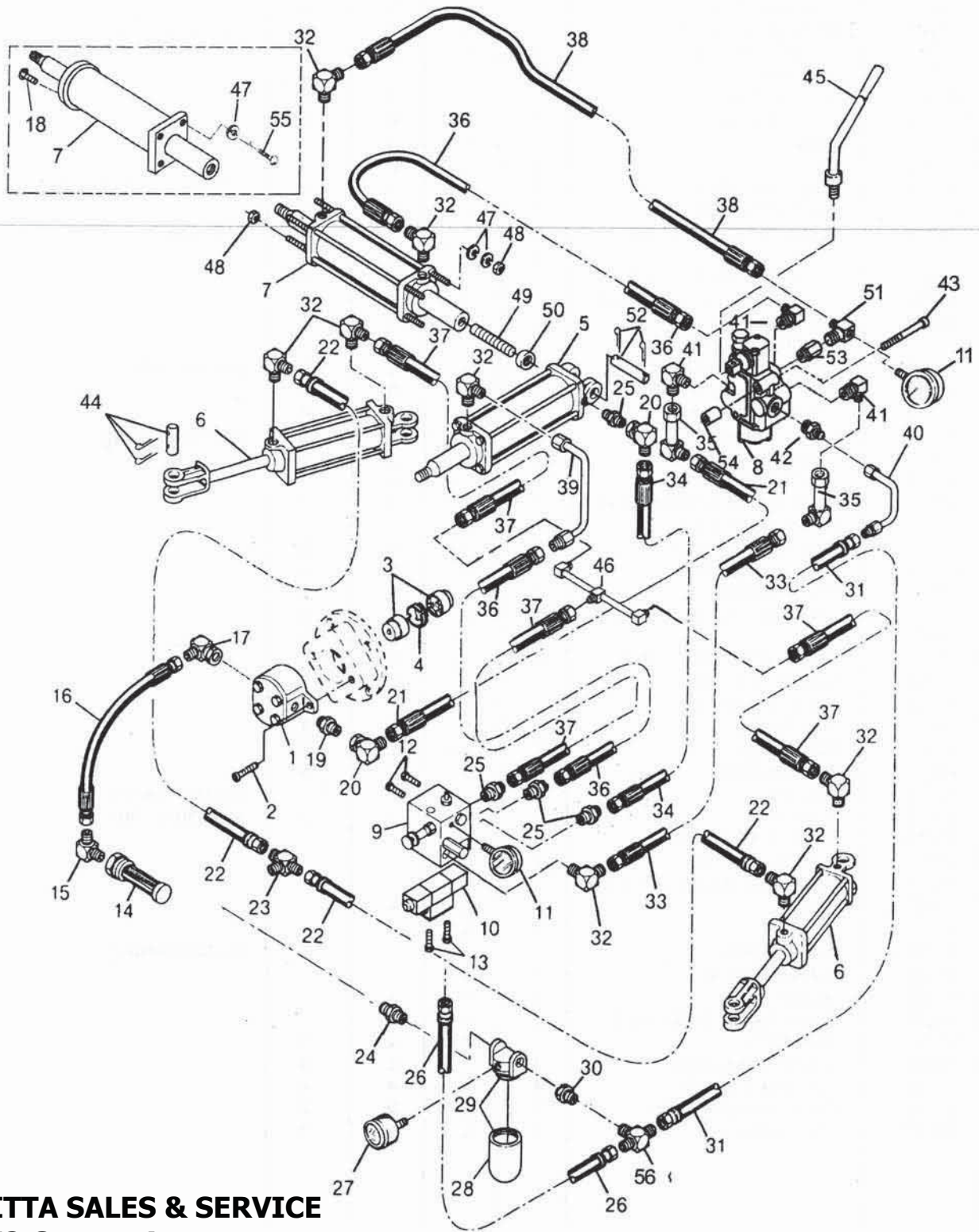


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## Frame Replacement Parts

KEY	PART NO.	DESCRIPTION	Quantity				REMARKS
			2008	2806	1600	HB-10	
1	91160	Plate, Depth Of Bend	2	2	1	1	
2	91153	Pointer	1	1	1	1	For Man.Bending
3	90094	Ring, Outside Snap	2	2	2	2	
4	91050	Bushing, Head Block	4	4	4	4	
5	92042	Elbow, Street 3/4	1	1	1	1	
6	839	Cap, Vent	1	1	1	1	
7	91052	Bushing, Gate	2	2	2	2	
8	97234	Fitting, Grease	6	6	6	6	
9	91034	Gate, Left	1	1	1	1	
10	91042	Pin, Gate	2	2	2	2	
11	90093	Ring, Inside Snap	2	2	2	2	
12	90092	Key, 5/16 x 5/16	2	2	2	2	
13	41040	Guard, Radius Die Retainer	1	1	1	1	5" Radius
14	97050	Spring	1	1	1	1	
15	97204	Screw, Soc. Hd. 1/2 - 13 x 1	3	3	3	3	
16	97205	Screw,Soc.Hd.1/2-13 x 2-1/4	2	2	2	2	
17	91033	Sled	1	1	1	1	
18	995	Tray, Program Card	1	1	-	-	
19	41047	Adjustable Collar Guard Assy.	1	1	1	1	Incl. Adj.Collar
20	97260	Bolt, Hex. 1/4 - 20 x 3/4	4	4	4	4	
21	97210	Nut, Lock 1/4 - 20	4	4	4	4	
22	41043	Guard, Swager Box	1	1	1	1	Incl. Handle,Hinge
	41011	Guard, Swager Plastic	1	1	1	1	
23	91078	Tray, Swager Tooling	1	-	0	-	
24	97217	Screw,Soc.Hd.1/2-13 x 1-1/2	4	4	4	4	
25	891	Holder, Collet, Short	1	1	1	1	
26	97267	Bolt, Hex. 3/8 - 16 x 1	8	8	8	8	
27	97176	Clamp, Swager Arm	1	1	1	1	
28	34012	Frame, Swager	1	1	1	1	
29	97232	Screw, Soc. Hd. 1/2 - 13 x 4	1	1	1	1	
30	91061	Hinge	2	2	2	2	
31	97231	Bolt, Hex 3/8 - 16 x 1-3/4	6	6	6	6	
32	97208	Nut,Jam 1/2 - 13	5	5	5	5	
33	91098	Home Switch Bracket	1	1	-	-	
34	91060	Arm, Swager	1	1	1	1	
35	97062	Caster, Rigid	2	2	2	2	
36	97060	Wheel, Phenolic	4	4	4	4	
37	91096	Tray, Die	1	-	-	-	Industrial, Deluxe
	91025	Tray, Die	-	1	1	1	Agricultural, Flat
38	97211	Bolt 1/2 -13 x 1-1/2	1	1	-	-	
39	97222	Nut,Lock 1/2 - 13	2	2	-	-	
40	97226	Screw, Soc. Hd.1/4 - 20 x 7/8	1	1	-	-	
41	97000	Cam	1	1	-	-	
42	91152	Handle	1	1	-	-	
43	91150	Pointer, Brass	1	1	-	-	For Auto Bending
44	97224	Nut, Lock 10 -32	1	1	-	-	
46	91151	Support	1	1	-	-	
47	97239	Screw, Rd. Hd. 10-32 x 1/2	1	1	-	-	
48	91035	Gate, Right	1	1	1	1	
49	41044	Guard, Gate w/rivets	1	1	1	1	
50	97225	Nut, Lock 3/8 - 16	4	4	4	4	
51	97061	Caster, Swivel w/Brake	2	2	2	2	
52	91047	Plate, Guide	1	1	1	1	

# Hydraulic Replacement Parts



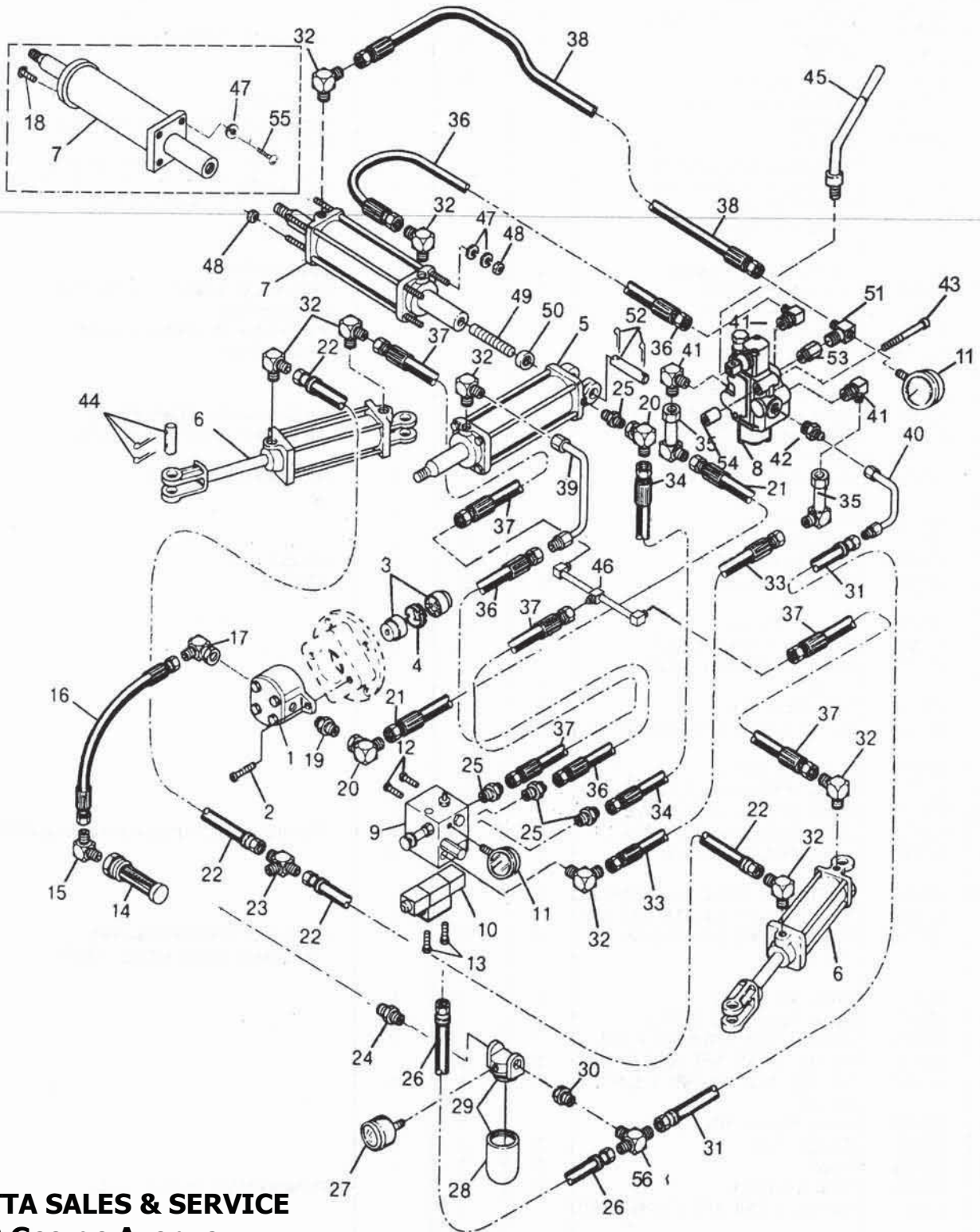
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## Hydraulic Replacement Parts -

KEY	PART NO.	DESCRIPTION	QUANTITY			REMARKS
			2008	2806	HB-10 1600	
1	92116	Pump, Hydraulic	1	1	-	For 7½ HP motor. Not available for HB-10
	92117	Pump, Hydraulic (High Speed)	1	1	-	
	92114	Pump, Hydraulic	-	-	1	
2	97267	Bolt, Hex Hd. 3/8"-16 x 1"	2	2	2	
3	92357	Coupler	1	1	-	Includes P/N 92358 Spyder
	92356	Coupler	-	-	1	
4	92358	Spyder, Rubber	1	1	1	
5	92169	Cylinder, Main Industrial	1	-	-	Includes Pin
	92235	Seal Kit	1	-	-	Includes All Seals for P/N 92169
	92161	Rod, Tie	4	-	-	For P/N 92169
	92048	Cartridge, Packing Gland	1	-	-	Sold without Seals for P/N 92169
	92158	Cylinder, Main Agricultural	-	1	-	Includes Pin
	92208	Seal Kit for 92158	-	1	-	For Benders Built After 3/1/91
	92172	Cylinder, Main Welded	-	-	1	Includes Pin
6	92150	Cylinder, Side Industrial	2	-	-	Includes Pins
	92236	Seal Kit for 92150	1	-	-	Includes All Seals for P/N 92150
	92159	Cylinder, Side Agricultural	-	2	-	Includes Pins
	92207	Seal Kit for 92159	-	1	-	For Benders Built After 3/1/91
	92173	Cylinder, Side Welded	-	-	2	Includes Pins
7	92256	Cylinder, Double End, Ag. 3½"	1	1	1	
	92355	Cylinder, Double End, Ind. 3"	1	-	-	For Benders Built Before 5/90
	92209	Seal Kit for 92256	1	1	-	For Benders Built After 3/1/91
	92205	Seal Kit for 92355	1	-	-	
	92174	Cylinder, Double End	-	-	1	Sold as Assembly Only
8	92103	Valve, Swager	1	1	1	
9	92165	Valve, Sequence	1	1	1	
10	92168	Valve, Directional	-	-	-	24 Volt
	92164	Valve, Directional	1	1	1	220 Volt
11	92100	Gauge, Pressure	2	2	2	
12	97221	Bolt, Hex 3/8"-16 x 1/2"	2	2	2	
13	97377	Screw, Sk. Hd. Cap 10-24 x 7/8"	4	4	4	
14	92045	Filter, Easy Flow	1	1	1	
15	92010	90 Ftg, 1/2ML NPT x 3/8ML JIC	1	1	1	
16	92272	Hose, #8, 18" Lg.	1	1	1	
17	92077	Elbow, 90 Degrees, 1/2-3/4	1	1	-	
	92078	Elbow, 90 Degrees, 1/2-5/8	-	-	1	
	92075	Elbow, 90 Degrees, 3/4-3/4	1	1	1	(For high speed pump, not avail. on HB-10)
18	97256	Bolt, Hex 1/2" - 13 x 1	-	-	2	
19	92026	Str Ftg, 5/8 SAE O'R x 3/8ML JIC	1	1	-	
	92006	Str, 3/8ML JIC x 1/2ML SAE O'R	-	-	1	
20	92021	90 Elb, 3/8ML JIC x 3/8FM JIC SVL	2	1	1	For rear of Main Cyl.-Use Ref. #32 (Mdl. 2806, HB-10, 1600)
21	92273	Hose, #6, 41" Lg.	1	1	1	
22	92277	Hose, Return, #6, 24" Lg.	2	2	2	
23	92015	Branch, T Ftg, 3/8 x 3/8 x 1/4	2	2	2	
24	92028	Str Ftg, 1/2ML NPT x 3/8ML NPT	1	1	-	
25	92002	Str. Ftg., 1/2" ML NPT x 3/8" ML JIC	5	4	5	
26	92280	Hose, Return, #6, 13" Lg.	1	1	1	
27	92292	Gauge, Filter	1	1	-	
28	92290	Filter	1	1	-	
29	92289	Filter Assembly	1	1	-	Includes Filter, Head & Gauge
30	92027	Str Ftg, 1/2ML NPT x 1/4FM NPT	1	1	-	
31	92279	Hose, Return, #6, 56" Lg.	1	1	1	
32	92009	90 Ftg, 1/2ML NPT x 3/8ML JIC	9	10	9	

# Hydraulic Replacement Parts - 2008, 2806, 2100, 2007, 2801, HB-10, 1600

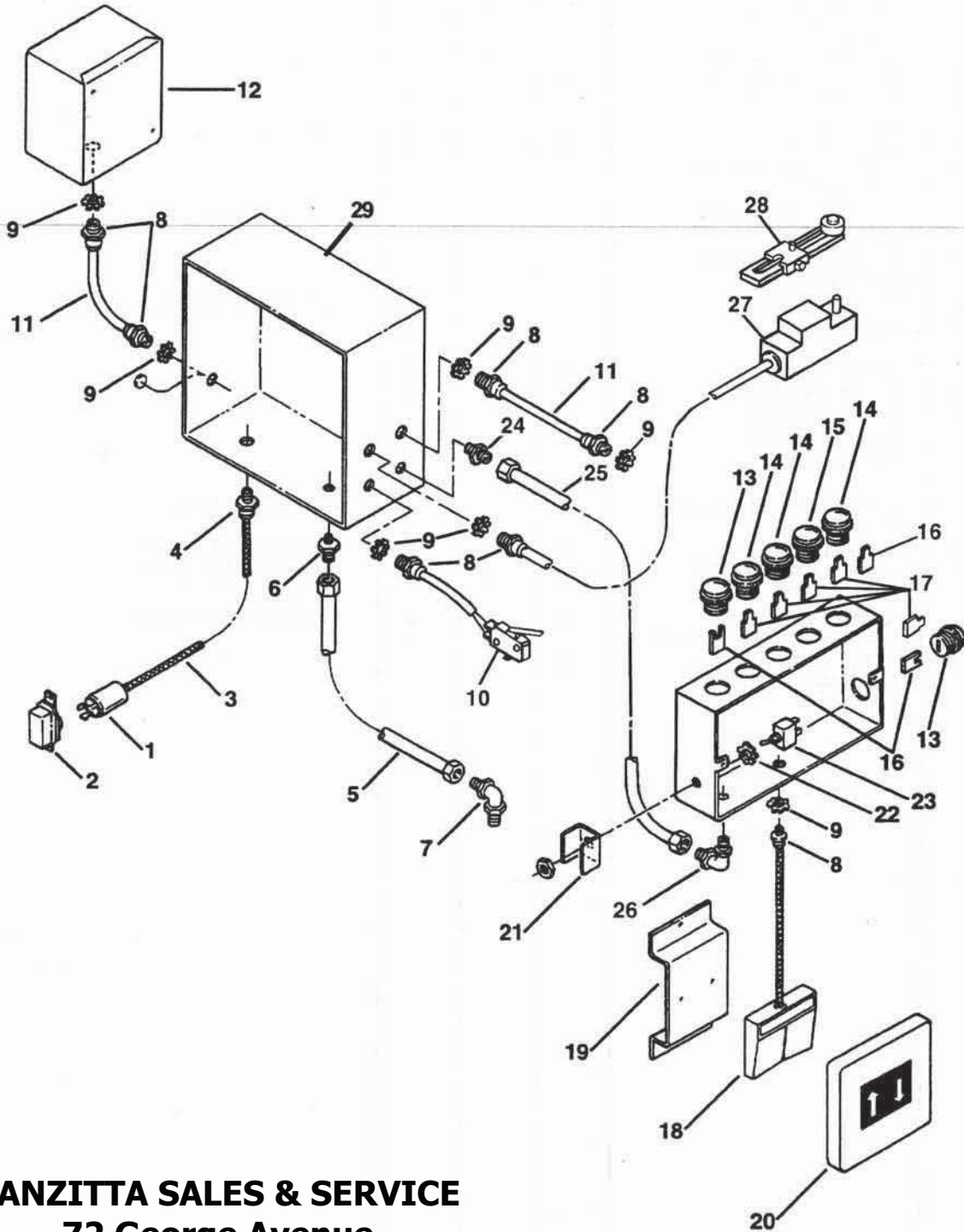


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## Hydraulic Replacement Parts -

KEY	PART NO.	DESCRIPTION	QUANTITY			REMARKS
			2008	2806	HB-10 1600	
33	92275	Hose, #6, 58" Lg.	1	1	1	
34	92274	Hose, #6, 50" Lg.	1	1	1	
35	92023	90 Lg Elb, 3/8 ML JIC x 3/8FM JIC	2	2	2	
36	92264	Hose, #6, 23-1/2" Lg.	2	2	2	
37	92261	Hose, #6, 15-1/2" Lg.	3	3	3	
38	92263	Hose, #6, 19" Lg.	1	1	1	
39	92312	Tube, 6-6	1	1	1	Cylinder Valve
40	92313	Tube, 6-6	1	1	1	
41	92004	90 Elb, 1/2ML SAE O'R 3x8ML JIC	3	3	3	
42	92006	Str, 3/8ML JIC x 1/2ML SAE O'R	1	1	-	
43	97206	Socket Head Cap Screw, 3/8"-16 x 3-1/4"	2	2	2	
44	92202	Pin, Side Cylinder	4	4	4	Industrial & Agricultural
45	92109	Handle, Swager	1	1	1	
46	92314	Fitting, 3-Way	1	1	1	
47	97383	Washer, Lock 1/2"	8	8	4	
48	97208	Nut, Jam 1/2"-13	6	6	-	
49	97051	Stud, Thread 1-14	1	1	1	
50	97100	Nut, Knurl	1	1	1	
51	92009DT	90 Ftg, 1/2ML NPT x 3/8ML JIC, DT	1	1	1	For Pressure Gauge
52	92203	Pin, Main Cylinder	1	1	1	Industrial & Agricultural
53	92008	Str Ftg, 1/2ML SAE O'R x 1/2 FM NPT	1	1	1	Industrial & Agricultural
54	70045	Bushing, Steel	2	2	2	Industrial & Agricultural
55	97217	Screw, Socket 1/2-13, 1-1/2	-	-	4	
56	92028	Str Ftg, 1/2ML NPT x 3/8ML NPT	1	1	-	

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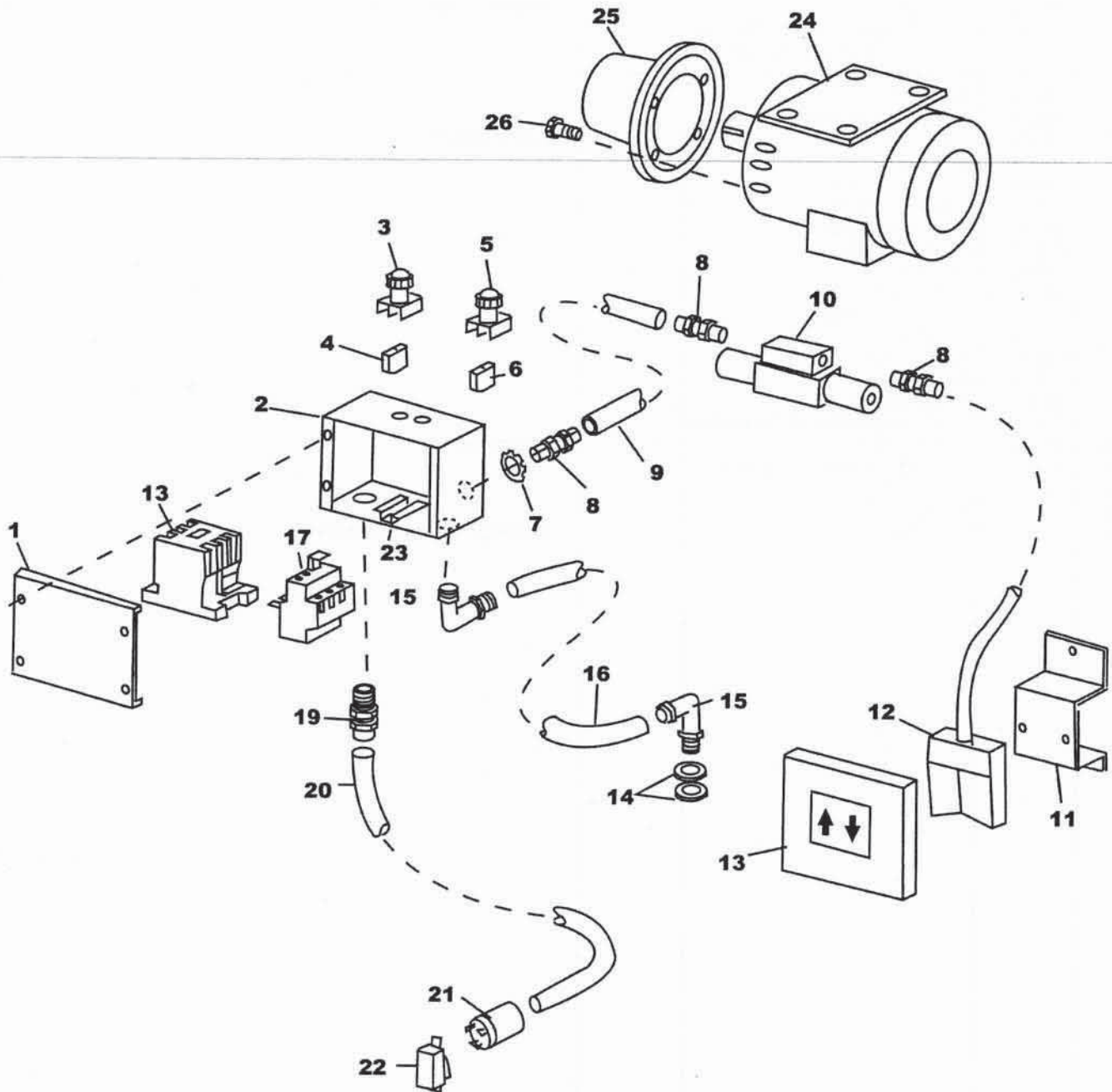
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**Electrical Components - 2008 & 2806**

REF.	PART NO.	DESCRIPTION	QUANTITY	REMARKS
1	95206	Plug	1	Single Phase
1	95208	Plug	1	Three Phase
2	95207	Receptacle	1	Single Phase
2	95209	Receptacle	1	Three Phase
3	95370	Power Cord	1 each	Single Phase (Sold by the foot)
3	95371	Power Cord	1 each	Three Phase (Sold by the foot)
4	95172	Kellum	1	
5	95234	3/8" Conduit	1 each	Sold by the inch
6	95235	3/8" Straight Connector Conduit	1	
7	95236	3/8" 90° Connector Conduit	1	
8	95449	Cord Grip	7	
9	95429	Lock Nut	7	
10	95420	Home Position Switch	1	
11	95508	16-3 Cord	1 each	Sold by the inch
12	95509	Sub Station	1	
13	95511	Red Push Button	2	
14	95512	Green Push Button	3	
15	95513	Black Push Button	1	
16	95514	Closed Contact	3	
17	95515	Open Contact	5	
18	95419	Pedal Control	1	
19	97447	Pedal Mount Plate	1	
20	97448	Knee Pad	1	
21	95091	Switch Cover	1	
22	97254	Star Washer	1	
23	95087	Toggle Switch	1	
24	95227	1/2" Straight Conduit Connection	1	
25	95228	1/2" Conduit	1 each	Sold by the inch
26	95226	1/2" 90° Conduit Connection	1	
27	95522	Limit Switch	1	
28	95523	Roller Arm	1	
29		Control Box		See page 56 for components

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**Electrical Components - HB-10, 1600**



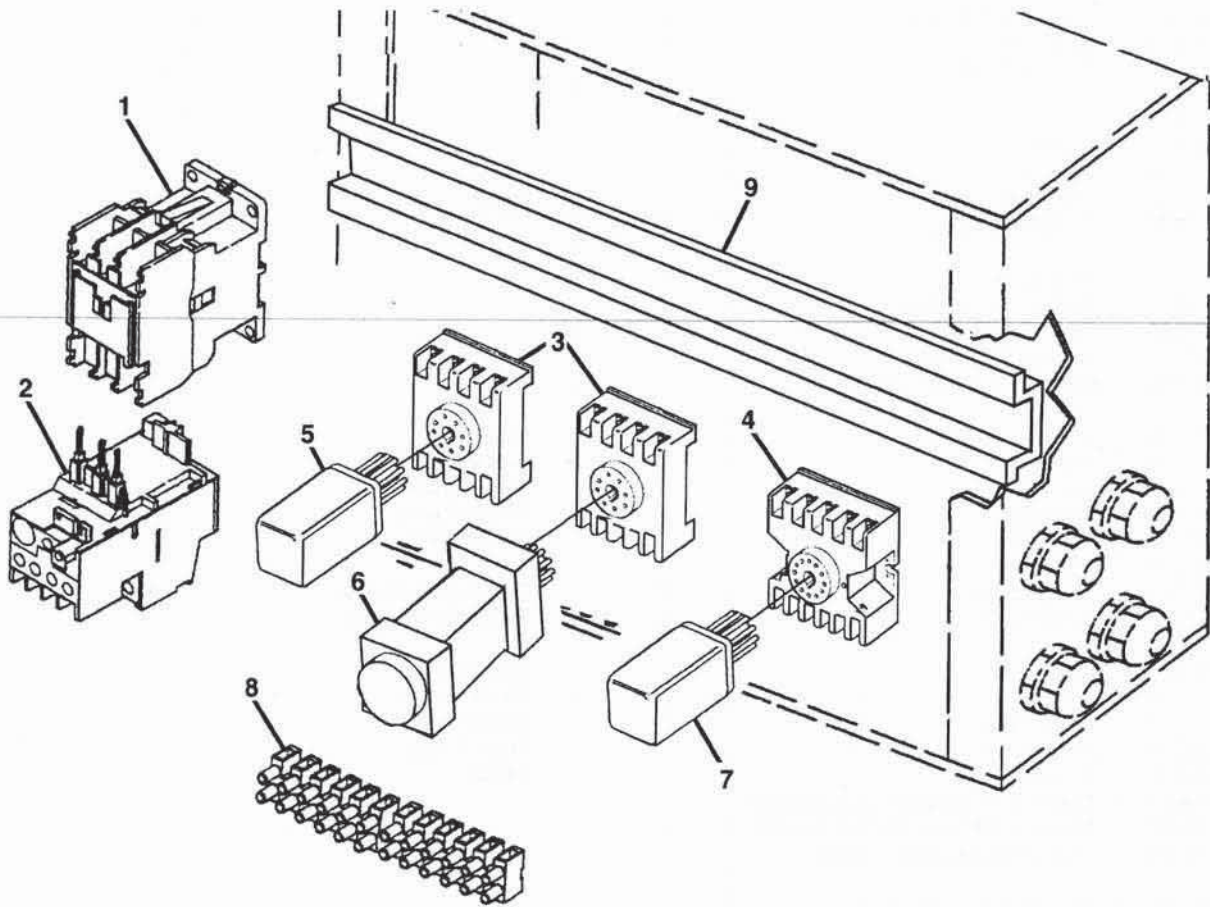
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**Electrical Components - HB-10, 1600**

REF.	PART NO.	DESCRIPTION	QUANTITY	REMARKS
1	95108	Lid, Control Box	1	
2	95107	Control Box	1	
3	95512	Green Push Button	1	
4	95515	Open Contact	1	
5	95511	Red Push Button	1	
6	95514	Closed Contact	1	
7	95429	Locknut	1	
8	95549	Cord Grip	3	
9	95508	16-3 Cord	39	Inches
10	92164	Directional Valve	1	
11	97469	Mount, Pedal	1	
12	95419DT	Switch, Knee Pedal	1	
13	97448	Pad, Knee Pedal	1	
14	97248	Washer, Reducing	2	
15	95236	Conduit, 3/8" 90 Degree	2	
16	95234	Conduit, 3/8"	36	Inches
17	95503	Overload	1	Single Phase
	95518	Overload	1	Three Phase
18	95502	Contacto	1	Single Phase
	95519	Contacto	1	Three Phase
19	95457	Cord Grip	1	
20	95370	Cord, Power	20	Feet, Single Phase
	95371	Cord, Power	20	Feet, Three Phase
21	95206	Plug	1	Single Phase
	95208	Plug	1	Three Phase
22	95207	Receptacle	1	Single Phase
	95209	Receptacle	1	Three Phase
23	95510	DIN Rail	2	Inches
24	95019	Motor, 5 HP Single Phase, Leeson	1	
	95020	Motor, 5 HP Three Phase, Leeson	1	
25	95021	Motor Pump Mount, Leeson	1	
26	97400	Bolt, Hex 1/2-13 x 3/4	4	

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# Electrical Control Box Components - 2008 & 2806



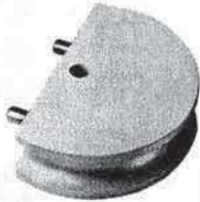
REF.	PART NO.	DESCRIPTION	QUANTITY		REMARKS
			2008	2806	
1	95502	Contactors	1	1	Single Phase
	95519	Contactors	1	1	3 Phase
2	95503	Overload Relay	1	1	Single Phase
	95518	Overload Relay	1	1	3 Phase
3	95462	8-Pin Relay Socket	2	2	
4	95463	11-Pin Relay Socket	1	1	
5	95460	DPDT Relay	1	1	
6	95461	Timer Relay	1	1	
7	95435	3P3T Relay	1	1	
8	95507	Terminal Strip	1	1	
9	95510	DIN Rail	1	1	

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# Bending Dies

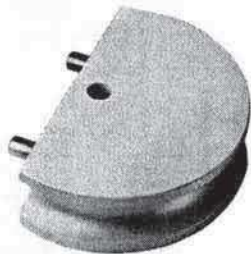
## Full 5" Radius Dies\*



No.	Size
5812	1-1/2"
5834	1-3/4"
5878	1-7/8"
5820	2"
5824	2-1/4"***
5825	2-1/2" **

\* Requires 41041 Retainers

## Full 4" Radius Dies



No.	Size
4858	1-5/8"
4834	1-3/4"
4820	2"

## 5" Radius Dies

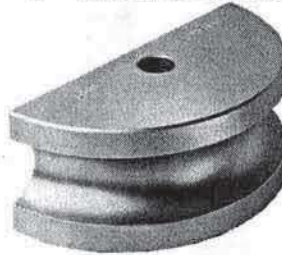


English No.	Size
5034	3/4"
5100	1"
5118	1-1/8"
5114	1-1/4"
5056	1-5/16"
5138	1-3/8"
5112	1-1/2"
5158	1-5/8"
5134	1-3/4"
5178	1-7/8"
5200	2"
5218	2-1/8"***
5414	2-1/4"***
5438	2-3/8"***
5412	2-1/2"***
5534	2-3/4"***
5530	3"***

Metric No.	Size
5040	40mm
5042	42mm
5045	45mm
5048	48mm
5050	50mm
5218	54mm***
5055	55mm
5060	60mm

\*\*\*2-1/8"= 54mm

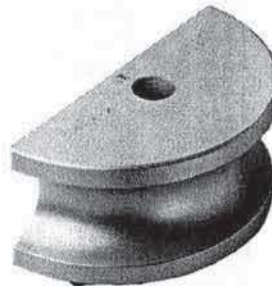
## 4" Radius Dies



Metric No.	Size
4040	40mm
4042	42mm
4045	45mm
4048	48mm
4050	50mm
4218	54mm***
4055	55mm
4060	60mm

\*\*\*2-1/8"= 54mm

## 3" Radius Dies



Metric No.	Size
3040	40mm
3042	42mm
3045	45mm
3048	48mm
3050	50mm
3218	54mm***
3055	55mm

\*\*\*2-1/8"= 54mm

## Square Dies



No.	Size
5314	1-1/4" (5" Rad.)
5312	1-1/2" (5" Rad.)
4334	3/4" (4" Rad.)
4310	1" (4" Rad.)
4314	1-1/4" (4" Rad.)
3334	3/4" (3" Rad.)
3310	1" (3" Rad.)

## Square Tube Back Shoe\* (2 Required)

1000 All Sizes  
\* (4) #855 Pins Required

English No.	Size
4012	1/2"
4058	5/8"
4034	3/4"
4078	7/8"
4100	1"
4118	1-1/8"
4114	1-1/4"
4056	1-5/16"
4138	1-3/8"
4112	1-1/2"
4158	1-5/8"
4134	1-3/4"
4178	1-7/8"
4200	2"
4218	2-1/8"***
4414	2-1/4"***
4438	2-3/8"***
4409	2-1/2"***

\*\* 4" Thick

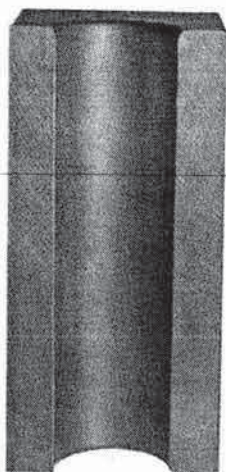
English No.	Size
3012	1/2"
3058	5/8"
3034	3/4"
3078	7/8"
3100	1"
3118	1-1/8"
3114	1-1/4"
3056	1-5/16"
3138	1-3/8"
3112	1-1/2"
3158	1-5/8"
3134	1-3/4"
3178	1-7/8"
3200	2"
3218	2-1/8"***
3414	2-1/4"***
3438	2-3/8"***

\*\* 4" Thick

All returned parts are subject to a restocking charge

# Shoes

## Back Shoes\* (2 Required)



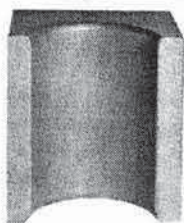
\* (2) #855 pins required

English No.	Size
1012	1/2"
1058	5/8"
1034	3/4"
1078	7/8"
1100	1"
1118	1-1/8"
1114	1-1/4"
1256	1-5/16"
1138	1-3/8"
1112	1-1/2"
1158	1-5/8"
1134	1-3/4"
1178	1-7/8"
1200	2"
1218	2-1/8"***
4211	2-1/4"***
4237	2-3/8"***
4412	2-1/2"***
1234	2-3/4"***
1350	3"***

Metric No.	Size
1340	40mm
1342	42mm
1345	45mm
1348	48mm
1349	50mm
1218	54mm***
1355	55mm
1360	60mm

\*\*\*2-1/8" = 54mm

## Half Shoes\* (1 Required)

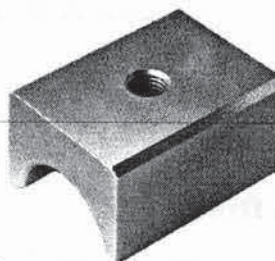


\* (1) #855 pin required

Metric No.	Size
1405	40mm
1425	42mm
1455	45mm
1448	48mm
1450	50mm
1051	54mm***
1445	55mm
1460	60mm

\*\*\*2-1/8" = 54mm

## Three-Quarter Shoes\* (1 Required)



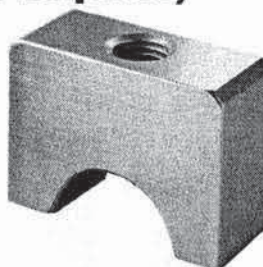
\* (1) #855 pin required

No.	Size
1036	1-3/4"
1044	1-7/8"
1046	2"
1053	2-1/8"***
4413	2-1/4"***
4415	2-1/2"***
1235	2-3/4"***
1351	3"***

Metric No.	Size
1540	40mm
1542	42mm
1545	45mm
1548	48mm
1550	50mm
1053	54mm***
1555	55mm
1560	60mm

\*\*\*2-1/8" = 54mm

## Quarter Shoes\* (1 Required)



\* (1) #855 pin required

No.	Size
1084	1-1/4"
1083	1-3/8"
1082	1-1/2"
1081	1-5/8"

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# End Finishing Tools - Swager

## Swage Dies



### Metric

No.	Size
140	40mm
142	42mm
145	45mm
148	48mm
149	50mm
128	54mm***
155	55mm
160	60mm

### English

No.	Size
110	1"
118	1-1/8"
114	1-1/4"
138	1-3/8"
112	1-1/2"
158	1-5/8"
134	1-3/4"
178	1-7/8"
120	2"
128	2-1/8"***
125	2-1/4"
123	2-3/8"
150	2-1/2"
129	2-3/4"
130	3"

\*\*\*2-1/8" = 54mm

## Reducing Dies\*



\* Requires clamp collet 890 or 891

No.	Size
780	2" to 1-3/4"
781	2-1/4" to 2"
782	2-1/2" to 2-1/4"
783	3" to 2-1/2"
784	2" to 1-7/8"
785	1-3/4" to 1-5/8"
786	1-5/8" to 1-1/2"
787	1-1/2" to 1-3/8"
788	1-3/8" to 1-1/4"
789	1-1/4" to 1-1/8"
790	3" to 2-3/4"

### Metric

No.	Size
760	(50mm to 45mm OD)
761	(55mm to 50mm OD)
762	(60mm to 55mm OD)

## Ball Joint Tools



550



555



557

No.	Size
550	1-3/4" (Male)
551	1-7/8" (Male)
552	2" (Male)
553	2-1/4" (Male)
554	2-1/2" (Male)
557	1-3/4" to 2-1/2" (Domer)
558	2-5/8" to 2-3/4" (Domer)
555	1-3/4", 1-7/8", 2" (Female)
556	2-1/4" to 2-1/2" (Female)
564	2-3/4" to 3" (Female)

## Flaring/Flanging Tools



518



519



853

### No.

Description
518 Flare Tool 1-1/2", 2" (2" requires 1720DF)
519 Flare Tool 1-3/4", 1-5/8"
853 Pipe Flanger 1-1/2" to 3" (Replaces Pipe Flangers 848, 849, 850, 851)

## Header Collector Tool



### No.

Size
101 3"
102 3-1/2"

## Clamp Collets (All Models After Jan '85)



### English

No.	Size
1710	1"
1718	1-1/8"
1714	1-1/4"
1756	1-5/16"
1738	1-3/8"
1712	1-1/2"
1758	1-5/8"
1734	1-3/4"
1778	1-7/8"
1720	2"
1720DF	2"
1728	2-1/8"***
1725	2-1/4"
1723	2-3/8"
1750	2-1/2"
1729	2-3/4"
1730	3"*

### Metric

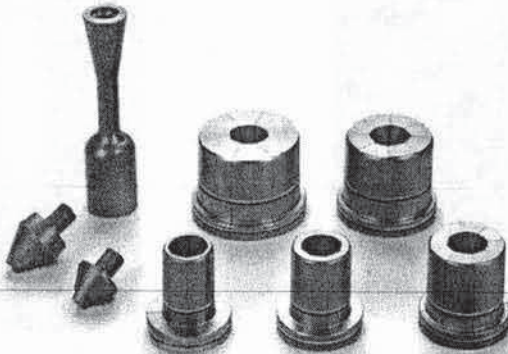
No.	Size
1740	40mm
1742	42mm
1745	45mm
1700	48mm
1705	50mm
1728	54mm***
1755	55mm
1760	60mm

\*Requires 892 Collet Holder

\*\*\*2-1/8" = 54mm

# End-Finishing Tools - Expander

## Accu-Sizer™ System



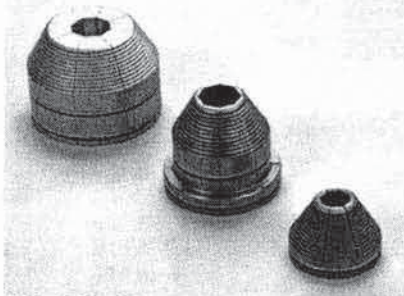
498, 499 508

477, 476,  
475, 474, 473

No.	Size
508	Arbor, 1-3/8" to 3-1/2"
498	Tip: 1-1/2" to 1-3/4"
499	Tip: 1-3/4" to 3-1/2"
473	Segment 1-3/8" to 1-3/4" (YELLOW)
474	Segment 1-3/4" to 2-1/8" (RED)
475	Segment 2-1/8" to 2-1/2" (BLACK)
476	Segment 2-1/2" to 3" (GREEN)
477	Segment 3" to 3-1/2"

**All sizes are I.D.**

## 45° Flaring

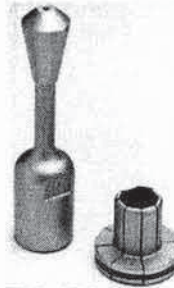


441, 440, 405

405	Flaring Segment Set* 1-1/8" to 1-1/2" Tube
440	Flaring Segment Set 1-1/2" to 2-1/2" Tube
441	Flaring Segment Set 2-1/2" to 3-1/2" Tube

\*Requires 575 Arbor 570 Spacer

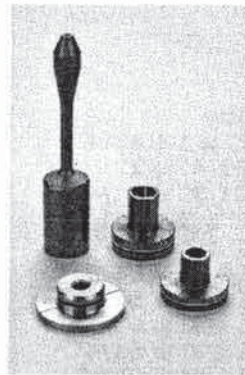
## Pre Accu-Sizer™ System



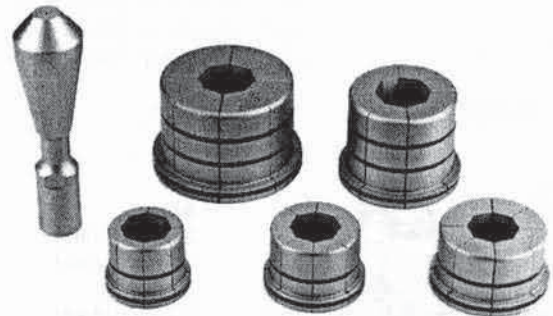
500, 400

No.	Size
575*	Arbor 15/16" to 1-1/4"
500	Arbor 1-1/4" to 1-1/2"
503	Arbor 2-3/4" to 5-1/2"
470	Segment 15/16" to 1-3/32"
404	Segment 1-3/32" to 1-1/4"
400	Segment 1-3/16" to 1-1/2"
403	Segment 2-3/4" to 3-1/8"
406	Segment 3-1/8" to 3-1/2"
408	Segment 3-1/2" to 4"
450	Segment 4" to 4-7/8"
451	Segment 4-7/8" to 5-1/2"

All sizes are I.D.  
\*570 Spacer Required



575, 570, 470, 404

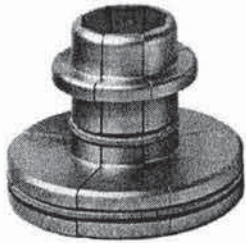


503, 451, 450,  
403, 406, 408

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# End-Finishing Tools - Expander

## Flanges



411



413

No.	Size
411	Segment 2", 2-1/4"
413	Flange Ring 2"
414	Flange Ring 2-1/4"
412	Segment 2-1/2"
418	Flange Ring 2-1/2"

## Ball Joints



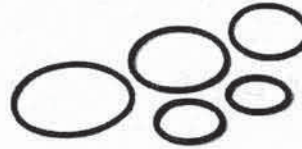
419

No.	Size
410	Segment 1-3/4"
419	Segment 2"
420	Segment 2-1/4"
421	Segment 2-1/2"
452	Segment 3"

## O-Rings, Rubber

No.  
870

Size  
Assortment of 50 (10 each size) for Segment Sets:  
400, 403, 404, 405, 406, 408, 410, 411, 412, 419, 420, 421, 422, 423, 424, 425, 440, 441, 452, 470, 473, 474, 475, 476, 477, 570 Spacer for Arbor 575



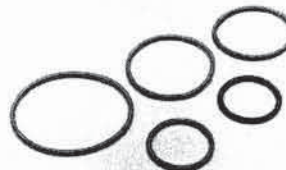
871

Assortment of 10 (2 each size) for Segment Sets:  
400, 403, 404, 405, 406, 408, 410, 411, 412, 419, 420, 421, 422, 423, 424, 425, 440, 441, 452, 470, 473, 474, 475, 476, 477, 570 Spacer for Arbor 575

## O-Rings, Steel

No.  
859

Size  
Assortment of 25 (5 each size) for Segment Sets:  
400, 403, 406, 408, 410, 411, 412, 419, 420, 421, 422, 423, 424, 425, 440, 450, 451, 452, 470, 473, 474, 475, 570 Spacer for Arbor 575



## O-Rings, Urethane

No.	For Segments
872	481
873	482
875	483
877	408, 450
878	450, 481, 482
879	451, 483, 485
880	451, 484, 486
881	484
882	485, 486



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# Silhouette Chart - Segment Set Teeth

These silhouettes are full scale. To identify the tooth you need, simply match it up with its mate on these pages. You'll get its part number, the part of the segment it belongs to, plus the part numbers and quantity of stainless steel, urethane and/or rubber O-Rings to use.

## Expanding Segment Teeth



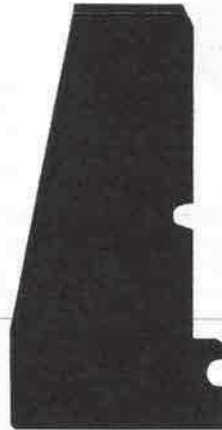
Tooth	670
Segment	470
<b>O-Rings:</b>	
Steel	1-867
Rubber	1-862



Tooth	600
Segment	400
<b>O-Rings:</b>	
Steel	1-867
Rubber	1-862



Tooth	604
Segment	404
<b>O-Rings:</b>	
Steel	1-867
Rubber	1-862



Tooth	606
Segment	406
<b>O-Rings:</b>	
Steel	2-869
Rubber	2-864



Tooth	603
Segment	403
<b>O-Rings:</b>	
Steel	1-868
	1-869
Rubber	1-863
	1-864



Tooth	625
Segment	425
<b>O-Rings:</b>	
Steel	1-868
	1-869
Rubber	1-863
	1-864

**All returned parts are subject to a restocking charge**

# Silhouette Chart - Segment Set Teeth



Tooth Segment 673  
**O-Rings:**  
 Steel 1-874  
 1-867  
 Rubber 1-860  
 1-862



Tooth Segment 624  
**O-Rings:**  
 Steel 1-867  
 1-868  
 Rubber 1-862  
 1-863



Tooth Segment 674  
**O-Rings:**  
 Steel 1-866  
 1-868  
 Rubber 1-861  
 1-863



Tooth Segment 623  
**O-Rings:**  
 Steel 1-866  
 1-868  
 Rubber 1-861  
 1-863



Tooth Segment 675  
**O-Rings:**  
 Steel 1-867  
 1-868  
 Rubber 1-862  
 1-863



Tooth Segment 622  
**O-Rings:**  
 Steel 1-865  
 1-867  
 Rubber 1-860  
 1-862

**All returned parts are subject to a restocking charge**

# Silhouette Chart - Segment Set Teeth



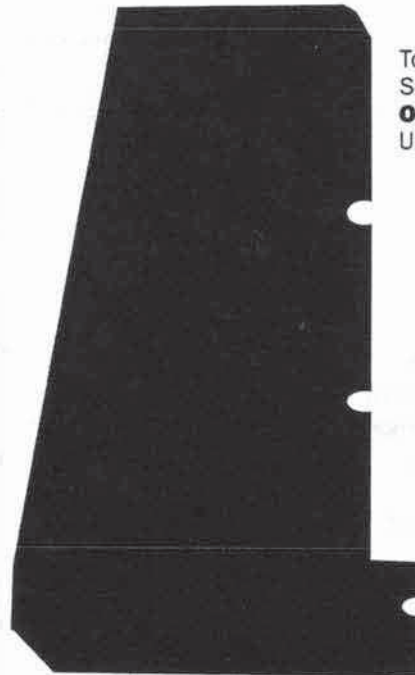
Tooth Segment  
**O-Rings:**  
 Rubber 1-864  
 Urethane 1-877



Tooth Segment  
**O-Rings:**  
 Urethane 1-878  
 2-877



Tooth Segment  
**O-Rings:**  
 Steel 2-869  
 Rubber 2-864



Tooth Segment  
**O-Rings:**  
 Urethane 1-880  
 2-879



Tooth Segment  
**O-Rings:**  
 Steel 1-868, 1-869  
 Rubber 1-863, 1-864

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# Silhouette Chart - Segment Set Teeth

## Flaring Segment Teeth



Tooth 605  
 Segment 405  
**O-Rings:**  
 Steel 1-867  
 Rubber 1-862



Tooth 640  
 Segment 440  
**O-Rings:**  
 Steel 1-868  
 1-869  
 Rubber 1-863  
 1-864

## Ball-Joint Segment Teeth



Tooth 610  
 Segment 410  
**O-Rings:**  
 Steel 2-869  
 Rubber 2-864



Tooth 619  
 Segment 419  
**O-Rings:**  
 Steel 2-869  
 Rubber 2-864



Tooth 620  
 Segment 420  
**O-Rings:**  
 Steel 2-869  
 Rubber 2-864



Tooth 621  
 Segment 421  
**O-Rings:**  
 Steel 2-869  
 Rubber 2-864

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# Silhouette Chart - Segment Set Teeth



Tooth	652
Segment	452
<b>O-Rings:</b>	
Steel	3-869
Rubber	3-864



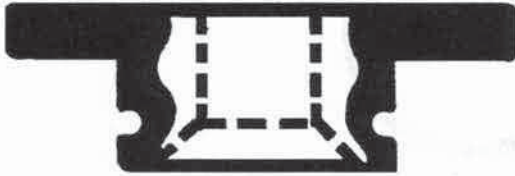
Tooth	641
Segment	441
<b>O-Rings:</b>	
Steel	869
Rubber	864

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# Silhouette Chart - Segment Set - O-Rings

## Spacer for Arbor 575

Segment 570  
**O-Rings:**  
 Steel 1-865  
 Rubber 1-860



## Flanging Segment Teeth

Tooth 611  
 Segment 411  
**O-Rings:**  
 Steel 1-865  
 1-869  
 Rubber 1-860  
 1-864

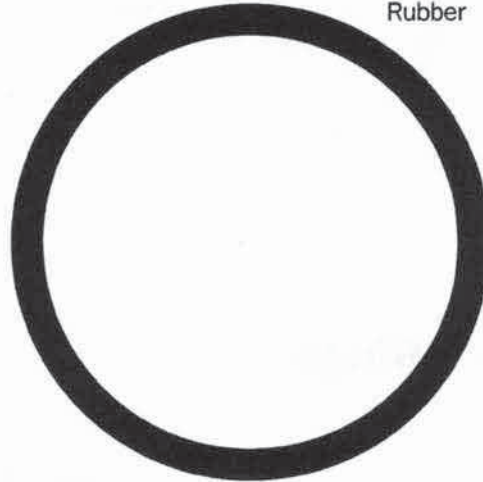


Tooth 612  
 Segment 412  
**O-Rings:**  
 Steel 1-867  
 1-869  
 Rubber 1-862  
 1-864

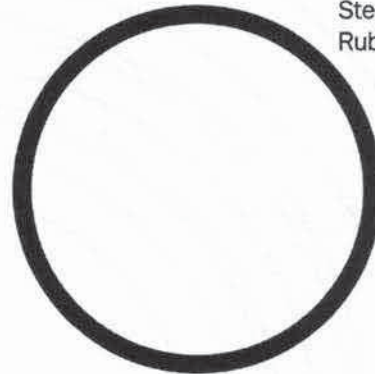


## O-Rings

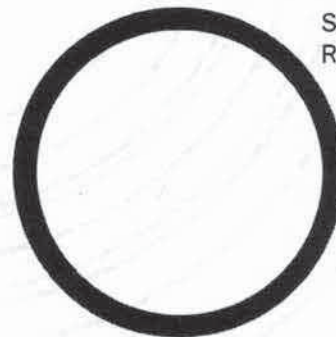
Steel 869  
 Rubber 864



Steel 868  
 Rubber 863

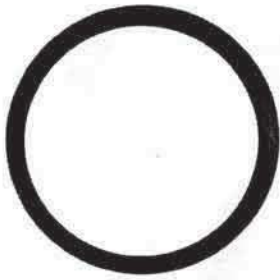


Steel 867  
 Rubber 862



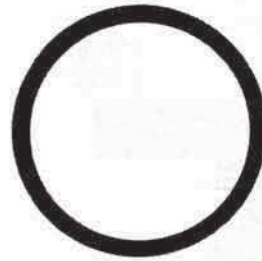
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# Silhouette Chart - O-Rings



Steel  
Rubber

866  
861

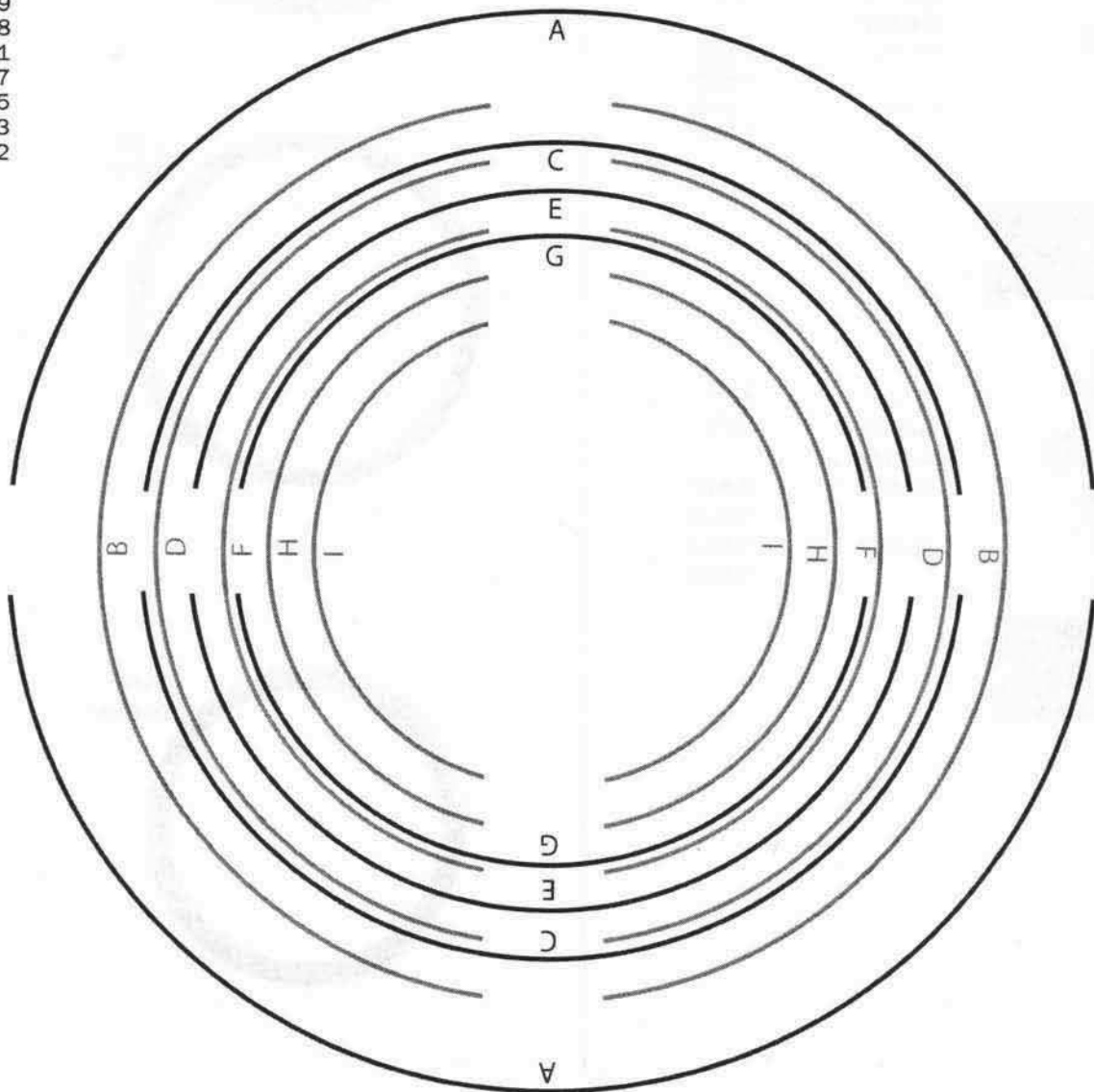


Steel  
Rubber

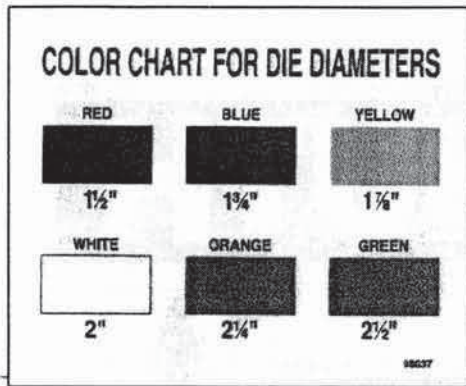
865  
860

## Urethane O-Rings

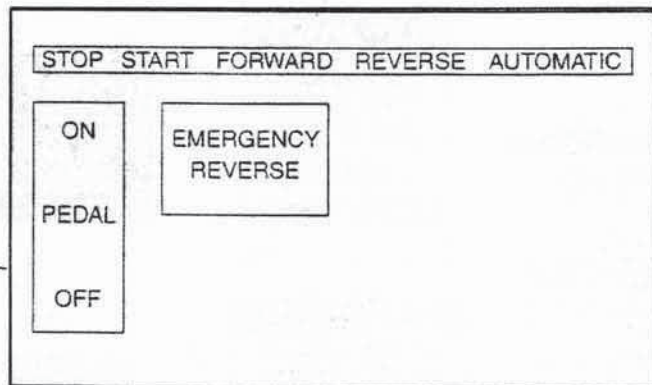
- A. 882
- B. 880
- C. 879
- D. 878
- E. 881
- F. 877
- G. 875
- H. 873
- I. 872



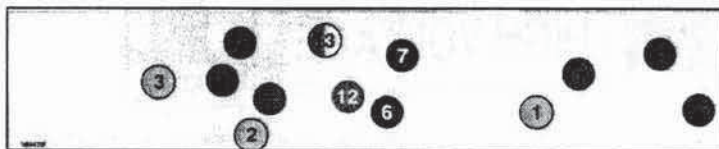
# Decals



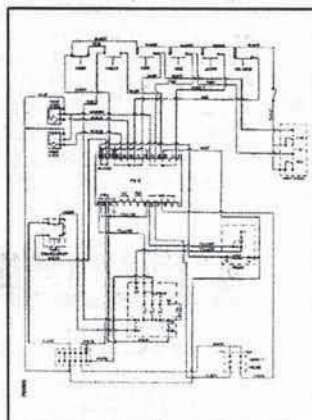
1



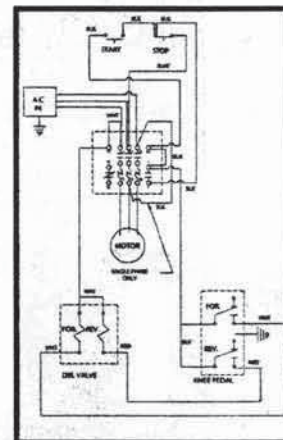
2



3



4



5

REF.	PART NO.	DESCRIPTION	QUANTITY	REMARKS
1	98037	Decal, Color Chart	1	
2	98085	Decal Kit	1	
3	98043	Decal, Accu-Sizer	1	
4	98086	Decal, Schematic	1	Models 2008, 2806
5	98091	Decal Schematic	1	Models 1600, HB-10

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# Decals

**1**

**WARNING**

DO NOT EXCEED 1000 PSI ON SEQUENCE VALVE.

**2**

**WARNING**

UNPLUG FROM POWER SOURCE BEFORE SERVICING

ELECTRICAL SHOCK MAY RESULT

**3**

**WARNING**

KEEP ARBORS AND SEGMENTS WELL GREASED

**4**

**WARNING**

DO NOT EXCEED 3000 PSI ON SWAGER VALVE.

**5**

**WARNING**

DO NOT WELD ON BENDER

DO NOT USE BENDER AS FIXTURE FOR WELDING

DAMAGE TO ELECTRICAL COMPONENTS MAY RESULT

WARRANTY WILL BE VOIDED

**6**

**CAUTION**

TOOLS MUST BE SNUG TO SHAFT SO AS NOT TO DAMAGE THREADS

**7**

**CAUTION**

DO NOT OPERATE WITHOUT GUARDS

**ATTENTION**

NE FAITES PAS FONCTIONNER SANS DISPOSITIFS DE SECURITE

**CUIDADO**

NO SE OPERE SIN BARRA DE SEGURIDAD

**8**

**CAUTION**

NOT FOR USE BELOW GARAGE FLOOR OR GRADE LEVEL


**9**

↑

↓

REV FOR

**10**



**11**

DO NOT RUN WITHOUT DIES

GREASE BARRELS WEEKLY

**12**

**DANGER**

HIGH VOLTAGE

**13**

↑

ROTATION

**14**

**WARNING**

RISK OF EXPLOSION. THIS EQUIPMENT HAS INTERNAL ARCING OR SPARKING PARTS WHICH SHOULD NOT BE EXPOSED TO FLAMMABLE VAPORS. IT SHOULD NOT BE LOCATED IN A RECESSED AREA OR BELOW FLOOR LEVEL.

**15**

**WARNING**

DO NOT WELD ON BENDER

DO NOT USE BENDER AS FIXTURE FOR WELDING

DAMAGE TO ELECTRICAL COMPONENTS MAY RESULT

WARRANTY WILL BE VOIDED

**16**

**WARNING**

THIS EQUIPMENT UTILIZES EARTH GROUNDING PROTECTION FOR OPERATOR SAFETY. THIS EQUIPMENT MUST BE GROUNDED. IF GROUND IS BROKEN DO NOT USE THIS EQUIPMENT UNTIL IT IS REPAIRED BY A QUALIFIED SERVICEPERSON.

**17**

**DANGER**

KEEP HANDS CLEAR

**18**

**DANGER**

KEEP HANDS CLEAR WHILE DIES ARE IN MOTION

**19**

**WARNING**

**ATTENTION**

1. REMOVE HANDS FROM TO FORMING, SWAGING, OR FLARING TUBING. AVOID PINCH POINTS.

2. RETIREZ LES MAINS DE LA MACHINE AVANT DE D'ENLARGIR OU DE TRAVAILLER L'EXTREME (OU TUYAU) D'UN TUBE. EVITEZ DE TOUCHER AUX POINTS DE PINCEMENT. RETENEZ VOS MAINS AWAY DE FORMER.

3. ABOGVAR EL TUBO, EVITAR LOS PUNTOS DE CONTACTO.

4. ONLY ONE PERSON SHOULD OPERATE THE MACHINE AT A TIME

5. REMOVE EXCESS TOOLING FROM SWAGER WHEN NOT IN USE.

6. TO AVOID BREAKING SEGMENTS, USE PROPER SEGMENTS AND ARBORS.

7. WEAR PROPER SAFETY EQUIPMENT.

8. REFER TO YOUR OWNERS MANUAL FOR MORE INFORMATION ON SAFETY.

9. CONSULTEZ VOTRE MANUEL DE PROPRIETAIRE POUR PLUS DE RENSEIGNEMENTS DES MESURES DE SECURITE.

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**WARNING**

THIS EQUIPMENT UTILIZES EARTH GROUNDING PROTECTION FOR OPERATOR SAFETY. THIS EQUIPMENT MUST BE GROUNDED. IF GROUND IS BROKEN DO NOT USE THIS EQUIPMENT UNTIL IT IS REPAIRED BY A QUALIFIED SERVICEPERSON.

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SETTING	SIZE	REQUIRE	TP
2	1 1/4 ID	4	4
1	1 1/4 ID	7	9
3	1 1/4 ID	3	8
4	1 7/8 ID		
5	2 ID		
8	2 OD		
9	2 1/4 OD		4
10	2 1/2 ID		9
11	2 1/4 OD		9
6	2 1/4 ID	4	9
7	2 1/2 ID	5	
12	2 1/4 ID		
13	3 ID		
13	3 1/4 ID	477	

REF.	PART NO.	DESCRIPTION	QUANTITY	REMARKS
1	98016	Decal, Warning	1	Model 2100
2	98039	Decal, Warning	1	
3	98020	Decal, Warning	1	
4	98070	Decal, Warning	1	
5	98076	Decal, Warning	1	
6	98015	Decal, Warning	1	
7	98033	Decal, Caution	1	
8	98030	Decal, Caution	1	
9	98036	Decal, Forward, Reverse	1	
10	98031	Decal, Huth	1	
11	98018	Decal, "Do not run..."	2	
12	98017	Decal, "Grease Barrels Weekly"	2	
13	98040	Decal, Danger	1	
14	98028	Decal, "Rotation"	1	
15	98014	Decal, Caution	1	
17	98032	Decal, Danger	1	
18	98010	Decal, Danger	1	
19	98013	Decal, Warning	1	
20	98074	Decal, Warning	1	
21	98042A	Decal, Expanding Chart	1	

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