



Exactol® Crank-Operated Benders

Models 412/424

These portable benders are vise or bench mountable for easy action and fast accurate bending to 180°. Two models are available to bend tube sizes 4 (1/4") through 24 (1 1/2"). Exactol benders are designed with a worm-gear drive with a 60 to 1 gear ratio to allow accurate bending with minimum effort. They bend aluminum, copper, annealed steel and annealed stainless steel without kinks or wrinkles. Easy crank operation permits continuous production without excessive operator fatigue; for use in tube fabrication shops, in the field, or in factory maintenance departments.

A video (on DVD) is included to provide proper instructions for use.

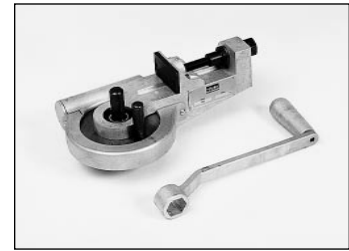


Fig. S10 — 412 Bender

Exactol® Model 412

The Exactol Model 412 will bend tube from size 4 (1/4") through size 12 (3/4") and 6mm through 20mm inclusive and is completely portable. Accessories include a sturdy metal carrying case, which accommodates the 412 bender, slide block, and selected radius blocks. See page S7 for wall thickness capabilities. May be held in a vise or bench mounted using the bench mounting adapter. Bulletin 4391-B400S and DVD are included with bender, which describe the operation in detail.

NOTE: The 412 must be bench mounted if mandrels are used.

COMPONENTS REQUIRED

The minimum components required are a Model 412 Bender with a slide block and a radius block which match the tube O.D. to be bent.

Part Name	Part No.
Exactol Model 412 Bender (for 1/4" through 3/4" O.D.).....	560569
Slide Block (for sizes 4-5-6-8-10-12)	550585
Slide Block (for sizes 6mm-8mm-12mm-12mm-14mm)	820091
Slide Block (for sizes 15mm-16mm-18mm-20mm).....	820092
Radius Blocks (for sizes 4-5-6-8-10-12 and 6mm thru 38mm) ...	See pages S10 – S11



Fig. S11 — Slide Block

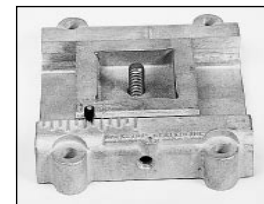


Fig. S12 — Bench Mount Adapter

OPTIONAL ACCESSORIES

Carrying Case (for bender, slide block and selected radius blocks)	550572
Bench Mounting Adapter	550570

Mandrel Bending Components

for 412 and 424 Benders See pages S16 – S18

Dimensions and pressures for reference only, subject to change.