



Exactol® Model 412 Kit

This 412 kit contains all the basic tool requirements for bending tube from 1/4" through 3/4".

Part No.
412 KIT

The following part numbers are included in the kit:

Part Name	Part No.
Exactol Model 412 Bender	560569
Carrying Case	550572
Slide Block for 1/4" through 3/4" tube	550585
Radius Block – 1/4" O.D. tube	550579
Radius Block – 3/8" O.D. tube.....	550581
Radius Block – 1/2" O.D. tube.....	550582
Radius Block – 5/8" O.D. tube.....	550583
Radius Block – 3/4" O.D. tube.....	550584



Fig. S13 — 412 Kit

Exactol® Model 424

The Exactol Model 424 will bend tube from size 4 (1/4" O.D.) through size 24 (1 1/2" O.D.) and 6mm through 38mm inclusive. See page S7 for wall thickness capabilities. It is completely portable and may be vise or bench mounted. Bulletin 4391-B400S and video are included with the bender, which describe the operation in detail.

NOTE: The 424 must be bench mounted if mandrels are used.

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

COMPONENTS REQUIRED

The minimum components required are a Model 424 Bender with a slide block and a radius block that match the tube O.D. to be bent.

Part Name	Part No.
Exactol Model 424 bender (for 1/4" through 1 1/2" O.D.).....	621044
Slide Block (for sizes 4-5-6-8-10-12)	550585
Slide Block (for sizes 14-16-18-20).....	621045
Slide Block (for size 24)	870150
Slide Block (for sizes 6mm-8mm-10mm-12mm-14mm)	820091
Slide Block (for sizes 15mm-16mm-18mm-20mm).....	820092
Slide Block (for sizes 22mm-25mm-28mm-30mm).....	820093
Slide Block (for size 35mm)	820094
Slide Block (for size 38mm)	870150
Radius Blocks (for sizes -4 thru -24 and 6mm thru 38mm)	See pages S10 – S11

OPTIONAL ACCESSORIES

Bench Mounting Adapter.....	631156
Mandrel Bending Components for 412 and 424 Benders	See pages S16 – S18

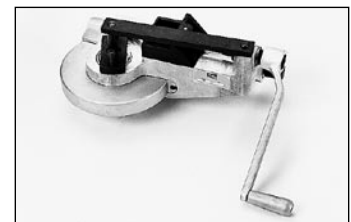


Fig. S14 — 424 Bender



Fig. S15 — Slide Block

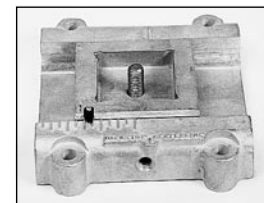


Fig. S16 — Bench Mount Adapter

Dimensions and pressures for reference only, subject to change.