# Instructions for Model Mega Bender® 030

⚠ **WARNING!** Thoroughly read operators manual before attempting to operate machine
(Machine must be connected to correct power source before switching power on! **DO NOT USE** extension cord.)

Rotate power switch to the **(ON)** position.
Display will read: "Forward C. Bend. Die"
Ercolina machines have (30) thirty bending programs.
Each program can store (9) nine individual bends.

```
Forward C. Bend. Die
mm 000.0     P001  90°
```
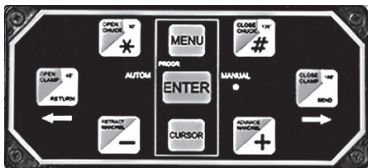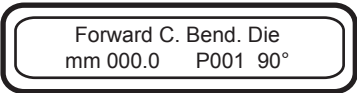

- Control panel keys and their functions (see FIG. A) -

(RETURN) .... Returns tool shaft to "0" position

(BEND) .... Moves tool shaft to desired bend angle

(CURSOR)............................ Positions cursor to desired field for editing

Plus (+)................................ Increase value when editing

Minus (-).............................. Decrease value when editing

(MENU)................................. Selects mode

(ENTER) .... Confirms selection

Asterisk (*)........................... Resets data in program

(FIG. A)

Entering a Bend Angle

- Data entry mode -
Depress	**(MENU)** button
Display reads	" MAIN MENU " 1-DATA ENTRY MODE
Depress	**(ENTER)** button
Display reads	"GRP RPM" or similar 1 1.52

"GRP" refers to program number. Depress **Plus (+)** or **Minus (-)** buttons to change program number
Display will periodically flash to following message: "TO INPUT DATA PUSH FOR 3 SECONDS"

- Select program number -
Depress   **Asterisk (*)** button for 3 seconds once program number is selected. Display will read
"Angle 000 Bend 1"

- Enter bend angle -
NOTE: While in programming mode, hot keys quickly move closer to desired angle **(BEND)** = 90°, **(RETURN)** = 45° and **(CURSOR)** = 135°
Depress   **Plus (+)** or **Minus (-)** buttons to enter desired bend angle
Depress   **(ENTER)** to store bend angle
Display will prompt you to enter another bend angle within the same program. If additional bends are required within the same program, input them in the same manner. If no additional bends are required depress (**ENTER**).
Display reads   "END OF DATA ENTRY" momentarily
Display reads   "GRP RPM" or similar
                1   1.52

- Exit data entry mode -
Depress   **(ENTER)**

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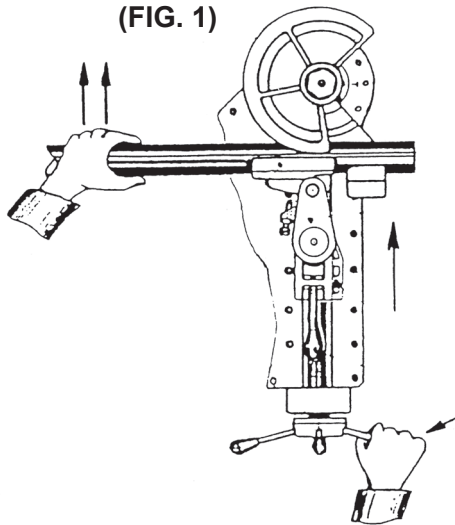
Setting Springback Value ➡

Setting Springback Value

- Before the bend -
Mount center former and counterbend die
Lubricate face of counterbend die ⟶

Use ONLY Ercolina
Spray Grease Part# 810 to
Lubricate Counterbending Die

Place material into former with weld seam up, if applicable
Move counterbend die vise forward until die contacts
material (see FIG. 1)
Depress **(ENTER)** to zero display of the counterbend die
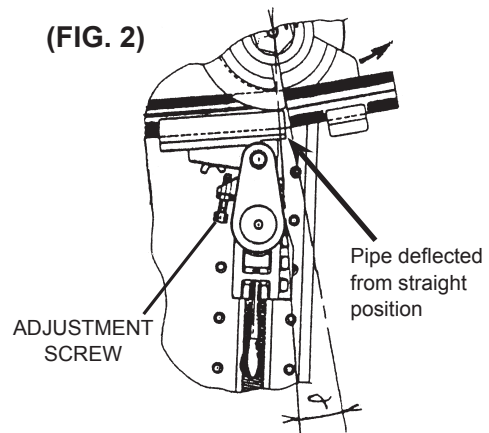position

(FIG. 1)

- Determine initial springback -
Initiate bend cycle by depressing **(BEND)** key or foot pedal
Stop bend cycle when material begins to deflect (see FIG. 2)
Observe degree reading on control panel display
Depress **(ENTER)** to insert springback value into program
Springback must be set for each angle within program
(**Note:** Springback value can be edited as necessary)

- Adjust counterbend die support screw -
Using Allen wrench, rotate screw to contact back of vise
(see FIG. 2)
Secure screw with locking jam nut
Properly adjusted screw improves quality of bend

(FIG. 2)

Pipe deflected
from straight
position

ADJUSTMENT
SCREW

- Finish bend -
Depress and hold **(BEND)** key or foot pedal to complete
bend cycle (see FIG. 3)

(FIG. 3)
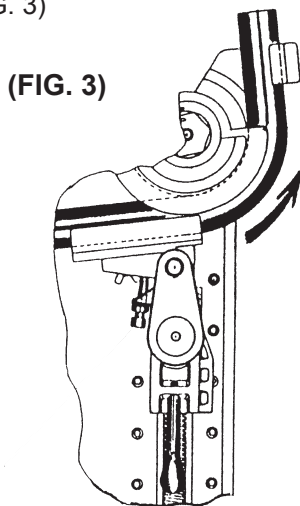
- Return center former to home position -
Depress and hold **(RETURN)** key or foot pedal until bender
returns to "0" home position (see FIG. 4)
Note: Display will automatically advance to next bend within
program

(FIG. 4)
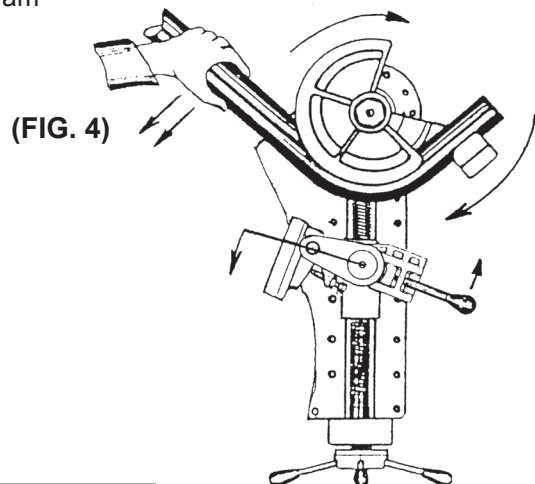
To edit bend angle or springback value after programming
Initiate bend cycle and stop
Depress **(CURSOR)** key once - cursor will flash in the springback field; **(+)** and **(-)** keys can then be used to edit settings
Depress **(CURSOR)** key twice - cursor will flash in the bend angle field; **(+)** and **(-)** keys can then be used to edit settings
Depress **(ENTER)** key to store changes

Entering a Bend Angle ➤