

Instructions for Super Bender® Plus & Top Bender® Plus

 **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.





Turn and release “Emergency Stop” button if depressed.

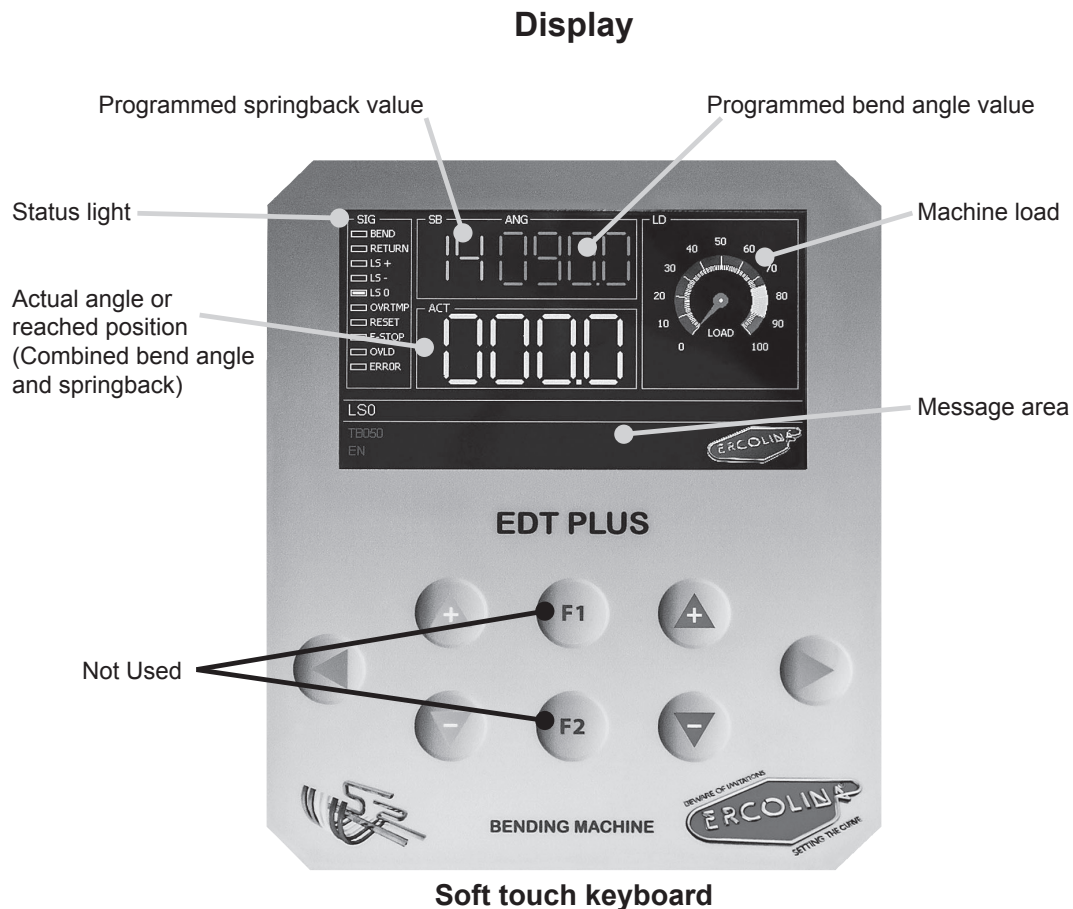
Depress “Reset” button to activate motor circuit.

Entering a Bend Angle

- Bend execution -

Plus control panel programs one bend angle.

1. Set desired bend angle [ANG] value – press **red** program button  or .
2. Set desired springback [SB] value – press **yellow** program button  or .



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Setting Springback Value 

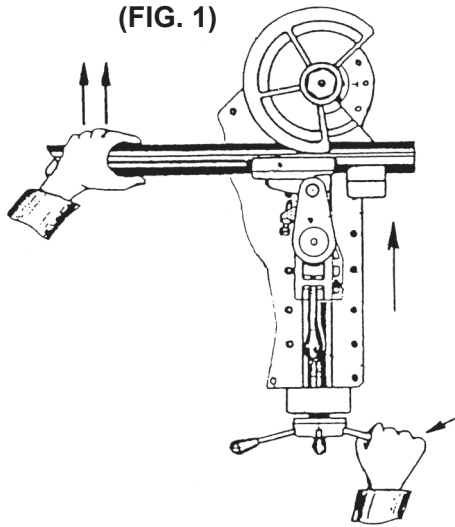
Setting Springback Value

- Before the bend -

Mount center former and counterbend die
Lubricate face of counterbend die



Place material into former with weld seam up, if applicable
Move counterbend die vise forward until die contacts material (see FIG. 1)

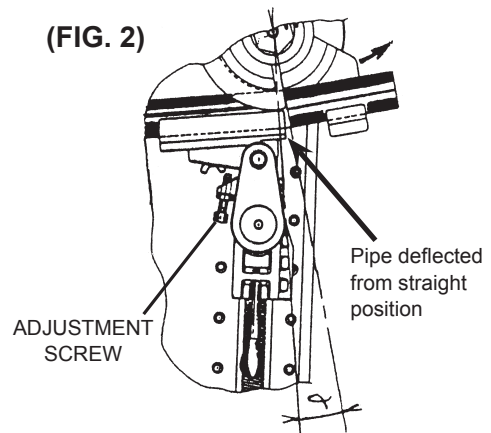


- Determine initial springback -

Initiate bend cycle by depressing or foot pedal
Stop bend cycle when material begins to deflect (see FIG. 2)
Observe degree reading on control panel display
Use **yellow** arrows or to input or edit springback value

- Adjust counterbend die support screw -

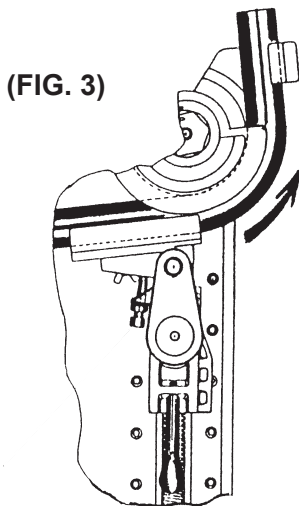
Using Allen wrench, rotate screw to contact back of vise (see FIG. 2)
Secure screw with locking jam nut
Properly adjusted screw improves quality of bend



- Finish bend -

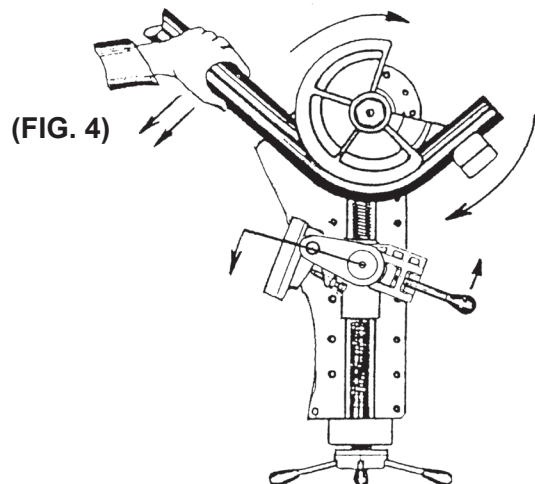
Depress and hold or foot pedal to complete bend cycle (see FIG. 3)

NOTE: A combined value of 210° is the maximum setting allowed.



- Return center former to home position -

Depress and hold or foot pedal until bender returns to "0" home position (see FIG. 4)



Entering a Bend Angle