Southwire™

TOOLS & EQUIPMENT

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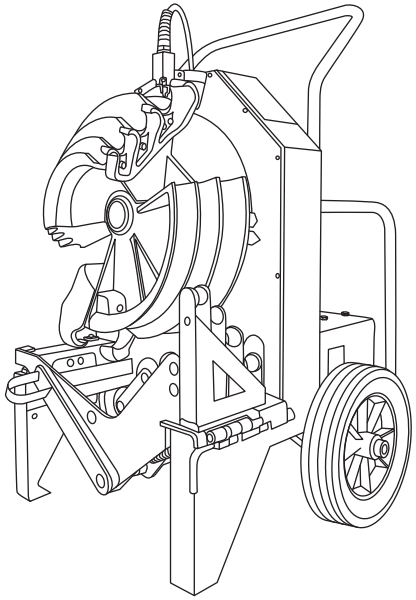
MXB2000 manual

Southwire™

TOOLS & EQUIPMENT

OPERATING INSTRUCTIONS
MAXIS™ Xtreme™ Bender
MXB2000



Southwire™

⚠ WARNING

READ AND UNDERSTAND ALL THE INSTRUCTIONS AND SAFETY INFORMATION IN THIS MANUAL BEFORE OPERATING OR SERVICING THE MXB2000

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SAFETY FIRST

Safety is essential in the use and maintenance of Southwire Equipment. This instruction manual and any placards or markings on the bender provide information for avoiding hazards and unsafe practices related to the use of this bender. Observe all the safety information provided.

SAFETY ALERT SYMBOLS

These symbols are used to call attention to hazards or unsafe practices that could result in injury or property damage. The three safety words defined below indicate the severity of the hazard. The message after the safety word provides information for preventing or avoiding the hazard.

- DANGER – Immediate hazards that if not avoided WILL result in severe injury or death
- WARNING – Hazards that if not avoided COULD result in severe injury or death
- CAUTION – Hazards or unsafe practices that, if not avoided MAY result in severe injury or death

IMPORTANT SAFETY INFORMATON

⚠ WARNING

• Read and understand all instructions and safety information in this manual before operating or servicing this bender.

FAILURE TO OBSERVE THESE WARNINGS COULD RESULT IN SEVERE INJURY OR DEATH.

⚠ WARNING – Personal Safety Hazards

• Only trained and qualified persons should use the MXB2000 (Southwire Maxis™ Xtreme™ Bender)
• Wear eye protection, hard hat, cut resistant gloves, and safety toe shoes when using this bender.
• Do not use this bender while tired or under the influence of drugs, alcohol, or medication.

• Keep body parts and loose clothing away from moving parts.
• Always follow safety procedures as shown in this manual.
• Never stand on the bender. Serious injury could occur if the bender is tipped.
• Do not overreach. Always keep proper footing and balance.
• Keep hands away from bending shoe, rollers, and conduit when bender is in use.
• Support conduit when unloading. Conduit can become loose and fall if not properly supported.

FAILURE TO OBSERVE THESE WARNINGS CAN RESULT IN SEVERE INJURY OR DEATH

GROUNDING INSTRUCTIONS

⚠ DANGER – Electrical Shock Hazards

- This is not an insulated tool, contact with live circuits could result
- Inspect the power cord before use. Repair or replace the cord if damaged.
- Connect the power cord to a 120-volt, 20 amp receptacle on a ground-fault protected circuit only.
- Do not modify the power cord or plug.
- Disconnect the unit from power before servicing.
- This bender must be grounded. In the event of a malfunction or breakdown, an electrical ground provides a path of least resistance for the electric current. This path of least resistance is intended to reduce the risk of electric shock. This bender's electrical cord must have a grounding conductor and a grounding plug. Do not modify the plug. Connect the plug to a corresponding receptacle that is properly installed and grounded in accordance with all national and local codes and ordinances. Do not use an adapter.
- Improper connection of the equipment-grounding conductor can result in a risk of electric shock. Check with qualified electrician or service personnel if the grounding instructions are not completely understood, or if in doubt as to whether the bender is properly grounded.

FAILURE TO OBSERVE THESE WARNINGS CAN RESULT IN SEVERE INJURY OR DEATH

⚠ WARNING – Entanglement Hazard

- Do not operate this bender while wearing loose fitting clothing. Retain long hair.
- Keep guards in place and in working order.
- Remove any tools from the bender before operating. Form a habit of checking to see that all tools are removed from bender before turning it on.

FAILURE TO OBSERVE THESE WARNINGS CAN RESULT IN SEVERE INJURY OR DEATH

⚠ WARNING – Bender Use Hazards

- Use this bender for the manufacturers intended purpose only. Use other than that described in this manual can result in injury or property damage.
- Only trained and qualified persons should use the MXB2000 (Southwire Maxis™ Xtreme™ Bender)
- Do not use in dangerous environments. Do not use power tools in damp or wet locations. Do not expose them to rain. Keep your work area well lit.
- Do not immerse the pendant in water or any other liquid.
- Do not use this bender in a hazardous environment. Hazards include flammable liquids, gases, or other materials. Using this bender in a hazardous environment can result in a fire or explosion.
- Reduce the risk of unintentional starting. Make sure on/off switch is in off position before plugging in the power cord.

• Never leave the bender running unattended. Turn the power off. Do not leave the bender until it comes to a complete stop.
• Turn off and unplug the bender before servicing and when changing accessories such as shoes and rollers. Accidental start-up could result in serious injury.
• Make sure that the handle is properly installed and secured with the bolts before lifting or moving the bender. An improperly installed handle could allow the bender to fall, injuring nearby personnel.

FAILURE TO OBSERVE THESE WARNINGS CAN RESULT IN SEVERE INJURY OR DEATH

⚠ WARNING – Extension Cords

• Use only a three-wire, 12 AWG extension cord that has a three-prong, grounding-type plug and three-hole receptacle that accept the bender's plug.
• Do not use extension cords that are longer than 100 feet.
• Repair or replace damaged extension cords.

FAILURE TO OBSERVE THESE CAUTIONS CAN RESULT IN SEVERE INJURY, PROPERTY DAMAGE, OR DEATH.

⚠ CAUTION

• Read and understand all the instructions and safety information in this manual before operating or servicing this bender.
• Conduit moves rapidly as it is bent. The path of the conduit must be clear of obstructions. Be sure clearance is adequate before starting the bend.

• Wear proper apparel. Do not wear loose clothing, neckties, rings, bracelets, or other jewelry which may get caught in moving parts. Steel toe footwear is recommended. Wear protective hair covering to contain long hair.
• Do not force rollers or alter the bender.
• Use the right tool. Do not force tool or attachment to do a job for which it was not designed.
• Inspect the bender before use. Replace worn, damaged, or missing parts with Southwire replacement parts. A damaged or improperly assembled component could break and strike nearby personnel.
• Maintain the bender with care. Keep the bender clean for best and safest performance. Follow instructions for changing accessories.
• Check damaged parts. Before further use of the bender, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.

FAILURE TO OBSERVE THESE CAUTIONS CAN RESULT IN INJURY OR PROPERTY DAMAGE

⚠ CAUTION

• Do not use if any parts are damaged as this can cause an unsafe condition and lead to bender malfunction or failure.
• If bender is in disrepair, DO NOT USE. Have bender inspected and repaired prior to use.

FAILURE TO OBSERVE THESE CAUTIONS CAN RESULT IN INJURY OR PROPERTY DAMAGE

PURPOSE OF THIS MANUAL

1. This manual is intended to familiarize all personnel with the safe operation of the Southwire MXB2000 Maxis™ Xtreme™ Bender.
2. Keep this manual with the bender and accessible to all personnel. Replacement manuals are available upon request at no charge at www.southwiretools.com.
3. All specifications are nominal and may change as design improvements occur. Southwire Company, LLC shall not be liable for damages resulting from misapplication or misuse of its products.

DESCRIPTION

The Southwire MXB2000 Maxis™ Xtreme™ Bender is your best tool for bending 1/2" to 2" conduit and pipe. This bender has the capability to accommodate the following types of conduit and pipe with its diverse bending shoe groups.

- Galvanized Electrical Metallic Tubing
- Galvanized Intermediate Metallic Conduit
- Galvanized Rigid Conduit

Bending Shoe Groups

Model Numbers for the Southwire MXB2000 Bender with Included Shoe Group

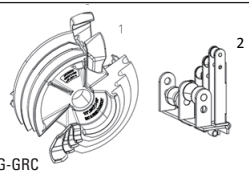
Rigid
Model Number: MXB2000R
Stock Number: 66138940
Description: MXB2000 with single shoe bending attachments to bend 1/2" to 2" rigid conduit and pipe

EMT
Model Number: MXB2000E
Stock Number: 66136340
Description: MXB2000 with single shoe bending attachments to bend 1/2" to 2" EMT conduit

IMC
Model Number: MXB2000I
Stock Number: 66119040
Description: MXB2000 with single shoe bending attachments to bend ½" to 2" IMC conduit

Model Numbers for the Southwire MXB2000 Shoe Groups

RIGID SHOE GROUP

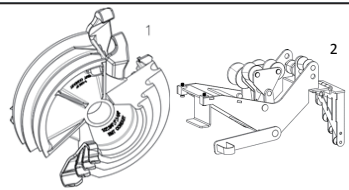


Model Number: MBSG-GRC
Material Number: 66276040
Description: ½" to 2" Rigid Bending Shoe and Roller Support Unit for ½" to 2"

Contents of Material #: 66276040

Key	Description	Material #
1	½" to 2" Rigid/IMC Bending Shoe	66154640
2	½" to 2" Rigid Roller Support Metal Storage Box	66161140

EMT SHOE GROUP



Model Number: MBSG-EMT

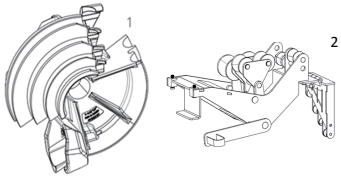
Material Number: 66276140

Description: ½" to 2" EMT Bending Shoe and Roller Support Unit for ½" to 2"

Contents of Material #: 66276140

Key	Description	Material #
1	½" to 2" EMT Bending Shoe	66132240
2	½" to 2" EMT Roller Support	66142540
	Metal Storage Box	

IMC SHOE GROUP



Model Number: MBSG-IMC

Material Number: 66151240

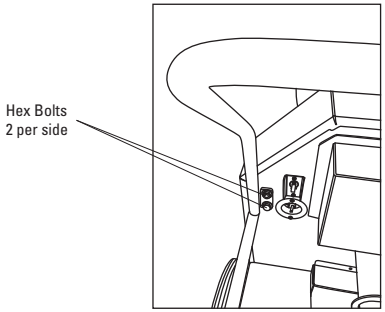
Description: ½" to 2" IMC Bending Shoe and Roller Support Unit for ½" to 2"

Contents of Material #: 66151240

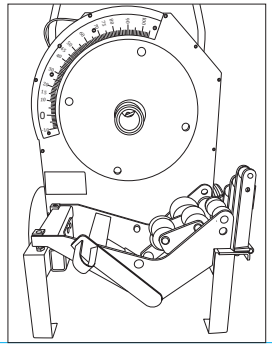
Key	Description	Material #
1	½" to 2" Rigid/IMC Bending Shoe	66154640
2	½" to 2" IMC Roller Support	66162940
	Metal Storage Box	

SETUP AND OPERATION:

1. Before assembling the MXB2000, ensure that the bender is disconnected from the power source.
2. Mount the handle using the four(4) hex bolts and washers. The bolts & washers can be found in the fabric pouch hanging on the MXB2000 frame.

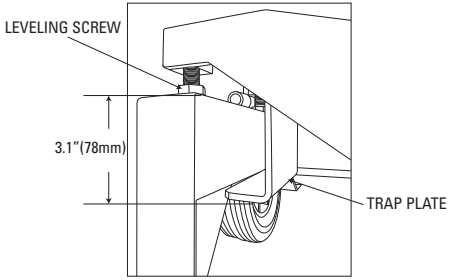


3. Mount the appropriate roller support onto the legs of the bender. The roller support mounts as shown below. The roller support is heavy and has spring-loaded moving parts so use caution to prevent pinching your hands and fingers.

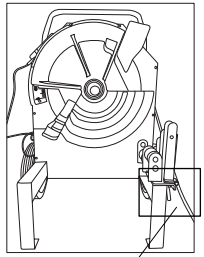


MXB2000 With Roller Support Installed

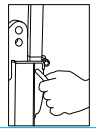
4. The IMC and EMT roller supports have a trap plate that may require adjustment to properly fit under the leg of the bender. Verify that the trap plate is 3.1" (78 mm) below the leveling screws. If necessary, loosen the two set screws, adjust the leveling bolts so the trap plate fits under the leg of the bender, then retighten the set screws.



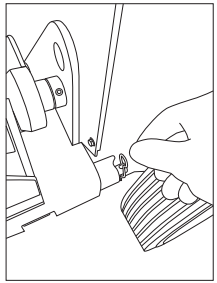
5. Install the roller support hinge pin in the location shown below.



Installing the Hinge Pin

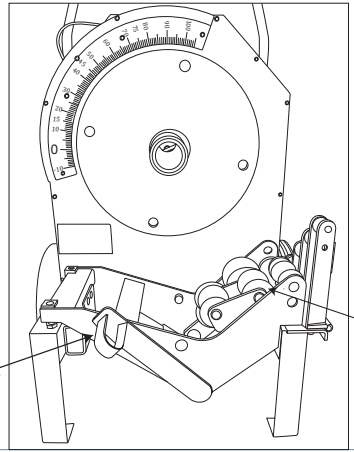


6. Install the cotter pin into the end of the roller support hinge pin to secure it.

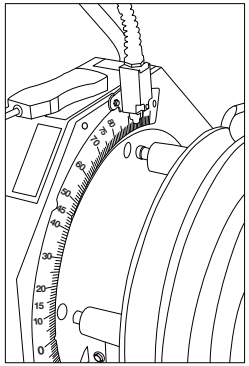


Installing the Cotter Pin

7. Fully retract the rollers by pulling up on the loading pedal with your foot before attempting to install the bending shoe.

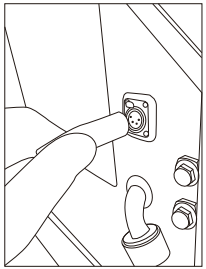


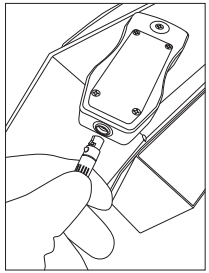
1. Slide the appropriate bending shoe onto the shaft of the main sprocket, as shown. Align the four studs on the back of the shoe with the four holes in the main sprocket. Push the shoe in until it stops.



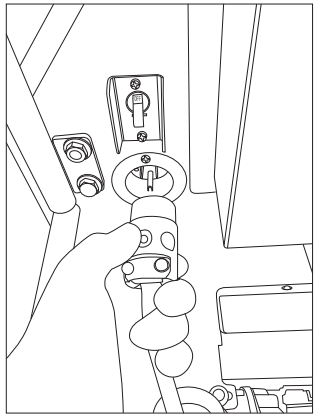
Installing a Bending Shoe

2 . Locate the pendant and the pendant power cord. Plug the pendant power cord into the back of the MXB2000 bender as shown below. Plug the other end of the pendant power cord into the bottom of the pendant as shown below.





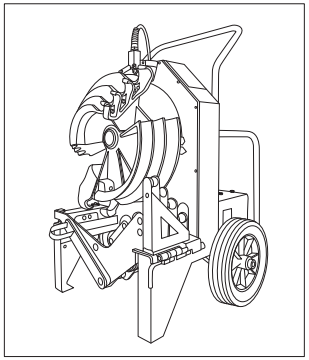
3 . Use a 10-3 electrical cord with the bender (not supplied)



BENDING CONDUIT

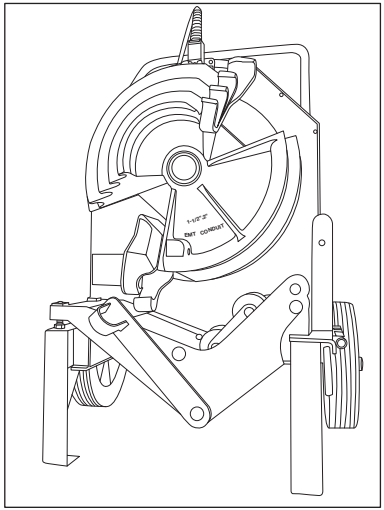
Bending ½", ¾", 1", and 1 ¼" EMT, Rigid, and IMC Conduit

1. Before preparing the MXB2000 for bending conduit, ensure that the bender is disconnected from the power source.
2. Install the correct roller assembly on the bender and attach the hinge pin to secure it to the bender. Insert the cotter pin into the end of the hinge pin.
3. Install the appropriate bending shoe for the conduit being bent
4. Place the black roller assembly in the folded-up or vertical position. These rollers are used when bending ½", ¾", 1", and 1 ¼" conduit.

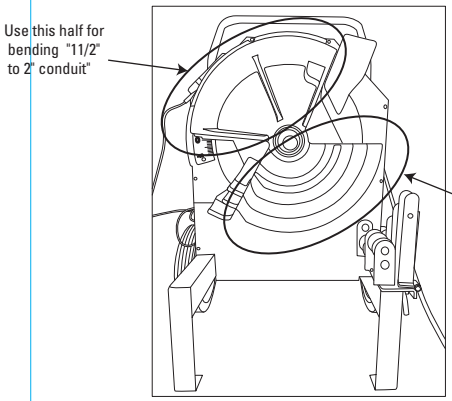


MXB2000 with Roller Supports in the UP-position for bending ½", ¾", 1", and 1 ¼" conduit

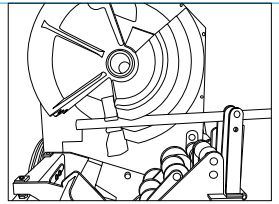
5. Using your foot, lift up on the pressure pedal to position the 1 ½" & 2" roller unit into the fully retracted position. The 1 ½" and 2" rollers should drop into the fully retracted position. If they do not fully retract, use a tool, such as a screwdriver, to adjust the roller so that both rollers rotate counterclockwise to the retracted position. Using a tool to adjust the roller will keep hands and fingers clear from any potential pinch points. These pressure rollers are not used when bending ½", ¾", 1", and 1 ¼" conduit.



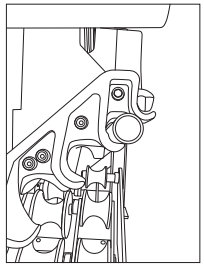
6. The bending shoe is separated into two halves. One half of the shoe is used for bending ½", ¾", 1", and 1 ¼" conduit. The other half of the shoe is used for bending 1 ½" and 2" conduit. See markings cast into the center of the shoe indicating the conduit size for each half.



7. Plug the power cord into an appropriate 120V AC receptacle.
8. Turn the power switch on the back of the bender to the ON position.
9. Using the pendant controller, press BEND to rotate the shoe clockwise. Rotate the shoe until the ½", ¾", 1", and 1 ¼" half of the shoe is facing down and the arrow pointer is at approximately 5° before the 0° starting point.
10. Facing the front of the bender, load the conduit into the right side of the bender. Place the conduit on the correct size roller and guide it into the bender until it aligns with the corresponding groove in the shoe. Continue guiding the conduit into the bender until the bending mark is aligned with the front edge of the hook.



11. Press BEND and rotate the shoe until the bottom of the hook fully contacts the bottom of the conduit. See illustration below. The conduit should be held firm but you should still be able to turn it with your hand. The arrow on the protractor scale should be at approximately the 0° position.



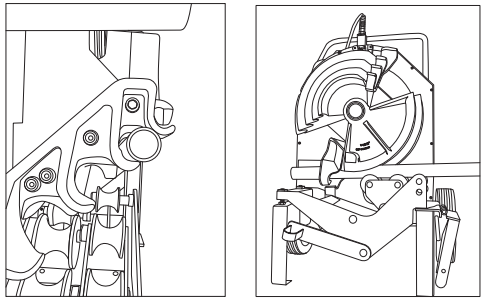
12. Press and hold the BEND button to begin bending the conduit.
13. Release the BEND button to stop bending.
14. When the bend is complete, press RETURN to rotate the shoe counterclockwise so that the conduit loosens from the hook and can be removed from the bender.
15. After the conduit has been removed, press and hold the RETURN button until the position arrow is pointing at approximately 5° before the 0° start position.

Bending 1 ½" and 2" EMT, IMC, and Rigid Conduit

Note: Pressure rollers are not used with Rigid conduit

1. Before preparing the MXB2000 for bending conduit, ensure that the bender is disconnected from the power source
2. Install the appropriate roller assembly on the bender and attach the hinge pin to secure it to the bender. Insert the cotter pin into the end of the hinge pin.
3. Install the appropriate bending shoe for the type of conduit being bent.
4. Place the black roller assembly in the folded-down position. This roller assembly is not used when bending 1 ½" and 2" conduit.
5. For EMT and IMC conduit, use your foot to lift up on the pressure pedal to position the 1 ½" & 2" roller unit into the fully retracted position. The 1 ½" and 2" rollers should drop into the fully retracted position. If they do not fully retract, use one hand to slightly press up on the loading pedal and at the same time, use a tool such as a screwdriver to adjust the roller so that both rollers rotate counter-clockwise to the retracted position. Using a tool to adjust the roller will keep hands and fingers clear from any potential pinch points.
6. The bending shoe is separated into two halves. One half of the shoe is used for bending ½", ¾", 1", and 1 ¼" conduit. The other half of the shoe is used for bending 1½" and 2" conduit. See markings on the shoe showing the conduit size for each half.
7. Plug the power cord into an appropriate 120V AC outlet.
8. Turn the power switch on the back of the bender to the ON position.
9. Using the pendant controller, press BEND to rotate the shoe clockwise. Rotate the shoe until the 1 ½" and 2" half of the shoe is facing down and the painted hooks on the shoe are at approximately the 6 o'clock position. On the protractor scale, the arrow should be approximately 5° before the 0° starting point.

10. Facing the front of the bender, load the conduit into the right side of the bender. Place the conduit on the correct size roller and guide it into the bender until it aligns with the corresponding groove in the shoe. Continue guiding the conduit into the bender until the bending mark is aligned with the front edge of the hook.
11. Press BEND and rotate the shoe until the bottom of the hook fully contacts the bottom of the conduit. The conduit should be held firm but you should still be able to turn it with your hand. The arrow on the protractor scale should be at approximately the 0° position.



For EMT and IMC Conduit

12. Place your foot on the pressure pedal to bring both rollers into contact with the conduit.

(The roller assembly has a stop which limits the travel of the pressure pedal. When the pressure pedal is touching the stop, the rollers are fully engaged).

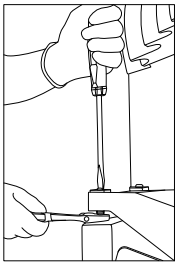
13. Before commencing with the bend, press down on the pressure pedal with moderate pressure (approximately 30-40 lbs of force). If the pressure pedal rotates and fully engages with the stop, the pressure rollers are too loose and the height of the rollers need to be raised. See section below titled “Adjusting the 1 ½” & 2” Pressure Rollers”. If you can apply moderate downward force on the pedal and it does not fully engage with the stop, then the rollers are adjusted properly.
14. Start the bend by pushing down on the pressure pedal with moderate pressure. Press and hold the BEND button on the pendant while maintaining pressure on pedal.
15. As the bend begins, the pressure rollers should “roll in” to the fully engaged position and the pressure pedal should come into contact with the stop. Once the pressure rollers are fully engaged, you can remove your foot from the pressure pedal and continue with the bend.
16. Release the BEND button to stop bending.
17. When the bend is complete, press RETURN to rotate the shoe counterclockwise so that the conduit loosens from the hook and can be removed from the bender.
18. After the conduit has been removed, press and hold the RETURN button until the position arrow is pointing at approximately 5° before the 0° start position.

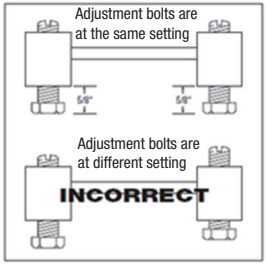
Adjusting the 1 ½” & 2” Pressure Rollers

Note: Pressure rollers are not used with Rigid conduit

When bending 1 1/2" and 2" EMT and IMC conduit, the pressure rollers must be fully engaged so that they apply the appropriate amount of pressure to the conduit. Because of variations in brands and construction of conduit, the factory setting for the pressure rollers may need to be adjusted to provide the right around of pressure on the conduit. If the conduit exhibits excessive side flattening when bent, the pressure may be set too high. If the conduit becomes kinked or wrinkled, the pressure may be set too low.

To adjust the roller pressure, do the following:
1. Use a screwdriver to loosen the set screws.





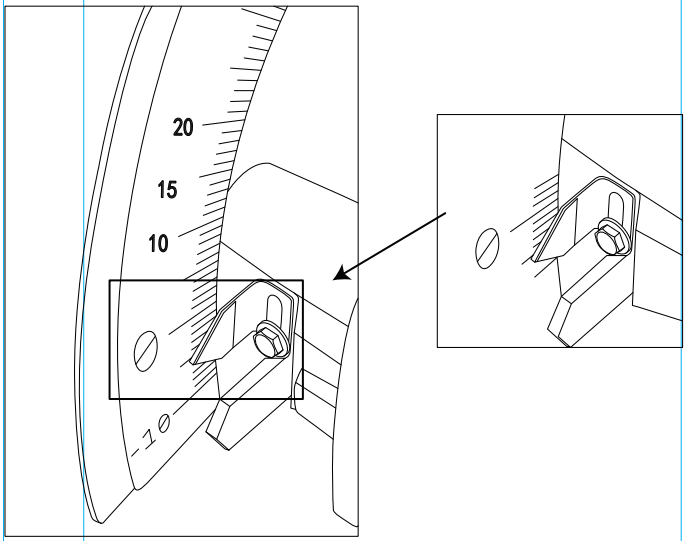
Standard Squeeze Setting

2. Use a wrench to rotate both adjusting bolts 1/2 turn clockwise to INCREASE pressure or 1/2 turn counterclockwise to DECREASE pressure.Be sure to adjust both bolts the same amount so that the roller pressure is applied evenly. Measure the length of the exposed bolt and ensure that the length is the same on both sides.
3. Tighten the set screws.

ARROW ADJUSTMENT

The arrow on the shoe can be adjusted to compensate for variations in conduit.

1. Load the conduit into the proper shoe groove.
2. Press BEND momentarily until the shoe rotates enough so that the bottom of the conduit is fully contacting the bottom of the hook.
3. Verify that the arrow position is aligned with 0° on the protractor scale. If necessary, loosen the hex head bolt and adjust the arrow to align with 0°. Retighten the hex head bolt, as shown.



Illustrated Bending Glossary

back-to-back bend— any U-shaped bend formed by two parallel 90° bends with a straight section of conduit or pipe between the bends.
center-to-center distance — the distance between the successive bends that make up an offset or a three-bend saddle.
developed length — the actual length of pipe that will be bent; refer to distance "d" in the illustration at left.
gain — the difference between the straight-line distance (a + a) and the shorter radial distance, (d) where:

q = angle of bend
r = the centerline bending radius of the bending shoe

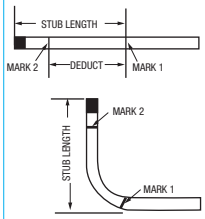
kick — single bend of less than 90°
leg length — the distance from the end of a straight section of conduit or pipe to the bend; measured from the end to the outside edge of the conduit or pipe.
offset bend — two opposite bends with the same degree of bend; used to avoid an obstruction.
offset height — the distance between the two legs of an offset bend, measured perpendicular to the two legs; also called amount of offset and depth of offset.
rise — the distance from the end of a straight section of conduit or pipe to the bend; measured from the end to the center line of the conduit or pipe. Also called stub or stub-up.
saddle — a three-bend or four-bend combination; used to avoid an obstruction.
shrink — the amount of conduit "lost" when laying out an offset bend working toward an obstruction.
spring back — the amount, measured in degrees, that a conduit or pipe tends to straighten after being bent.

Bending Instructions 90° STUBS

1. Measure the length of the required stub.
2. See the Minimum Stub Length formula on the Deduct Table. The required stub must be equal to or longer than the Minimum Stub Length.
3. Measure and mark the stub length on the conduit. This is Mark 1. Subtract the Deduct from this mark and make a new mark. This is Mark 2.
4. Align Mark 2 with the front edge of the hook and bend the conduit.

Notes:

When the operator presses RETURN, the conduit may spring back a few degrees. Compensate by overbending as shown in the Scale Reading Table.



Deduct Table

SIZE		1/2	3/4	1	1-1/4	1-1/2	2
DEDUCT	RIGID/PVC	7-1/2	9	11	14	14-1/4	16-1/8
	EMT	7	8-7/8	10-3/4	13-1/8	13-7/8	15-3/8
	IMC	7-1/2	9	11	14	13-3/4	15-1/4
MINIMUM STUB LENGTH-DEDUCT PLUS 2 INCHES							

Figures are approximate.

Scale Reading Table-Single-Shoe Groups



CONDUIT SIZE	RIGID					EMT					IMC				
	15°	30°	45°	60°	90°	15°	30°	45°	60°	90°	15°	30°	45°	60°	90°
1/2	17	33	49	64	96	16	32	48	63	96	20	36	51	67	98
3/4	17	33	48	64	95	17	33	48	64	96	19	35	50	66	97
1	17	32	48	63	94	17	32	48	63	94	19	35	50	66	97
1-1/4	17	32	48	63	94	17	32	48	63	94	19	35	50	66	97
1-1/2	17	32	48	63	94	19	35	50	66	97	17	33	49	64	96
2	17	32	48	63	94	19	34	50	65	96	19	34	50	65	96

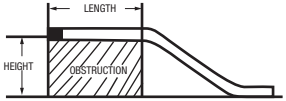
Figures are approximate.

Offset Bend

1. Measure the height and length of the obstruction. Select the angle to be used.
2. See the Offset Table. The height of the obstruction must be equal to or greater than the minimum offset.
3. Refer to the X Table to find the X dimension. Refer to the Offset Table to find the center-to-center distance.

Note: If the center-to-center distance is not shown, calculate it by using the multipliers shown in the Offset Table.

4. Mark the conduit as shown.
5. Insert the conduit into the bender. Align Mark 1 with the front edge of the hook and bend the conduit.
6. Return the bender to approximately 5° before 0°. Advance the conduit forward and align Mark 2 with the front edge of the hook.
7. Make the second bend.



Offset Table

OFFSET ►		2	4	6	8	10
15°	Max.Conduit Size	3/4	1-1/2	2		
	Center-to-Center	7-3/4	15-7/16	23-3/16	30-15/16	38-5/8
30°	Max.Conduit Size		3/4	1	1-1/2	2
	Center-to-Center		8	12	16	20
45°	Max.Conduit Size			1/2	1	1-1/4
	Center-to-Center			8-1/2	11-5/16	14-1/8

OFFSET ►		12	14	16	18	20	22
15°	Max.Conduit Size	2					
	Center-to-Center	46-3/8	54-1/16	61-13/16	69-9/16	77-1/4	85
30°	Max.Conduit Size	2					
	Center-to-Center	24	28	32	36	40	44
45°	Max.Conduit Size	1-1/2	2				
	Center-to-Center	16-15/16	19-13/16	22-5/8	25-7/16	28-1/4	31-1/8

CENTER TO CENTER DISTANCE-OFFSET HEIGHT X MULTIPLIER					
OFFSET ANGLE	10°	15°	22-1/2°	30°	45°
MULTIPLIER	5.8	3.9	2.6	2.0	1.4

Figures are approximate

X Table

CONDUIT SIZE	1/2	3/4	1	1-1/4	1-1/2	2
"X"	3-1/16	3-1/16	3-3/16	4	4-1/4	4-1/2

Figures are approndmate

Handle Removal and Replacement

The handle of the MXB2000 is designed to be removable. This feature is convenient when performing complex bending and makes it easy to replace a damaged handle.

Removal

1. Place the bender in the upright position.
2. Remove the two bolts from both sides of the handle
3. Lift the handle to remove.

Replacement

1. Insert the handle into the sleeves of the frame.
2. Align the holes in the handle with the holes in the sleeves.
3. Replace the bolts on left and right side of handle.
4. Tighten both bolts to the handle until snug.

The only proper way to lift this bender is by attaching a nylon or polyester sling around the storage spindle. The sling should extend between the handle and main frame of the bender so that the handle acts as a guide for the sling.

Make sure that all components used to lift this bender are properly rated for the 159 kg (265 lb.) weight. Use a ramp to load and unload from a truck or other vehicle that is not equipped with a lift gate.

⚠WARNING

Make sure the handle is properly installed and secured with the safety clips and tightened bolts before lifting or moving the bender. An improperly installed handle could allow the bender to fail, injuring nearby personnel.

Failure to observe this warning could result in severe injury or death.

Troubleshooting

Problem	Probable Cause	Possible Remedy
Bender will not operate.	No voltage.	Check supply voltage circuit operation.
		Check that switch is on.
	Loose pendant cable connection	Ensure that the pendant cable is securely connected to the bender and the pendant
Bends are overbent a few degrees.	Not properly adjusted for spring back	Determine how many degrees you are overbent and subtract an equivalent amount from your bend
Sides of conduit are smashed	Too much squeeze on 1-1/2" or 2" EMT or IMC conduit.	Reduce roller pressure. See Section titled "Adjusting the 1 ½" & 2" Pressure Rollers"
Bends are under-bent a few degrees.	Not properly adjusted for spring back	Determine how many degrees you are under bent and add an equivalent amount more to your bend
Rippling defects	Too little squeeze on 1-1/2" or 2" EMT or IMC conduit.	Increase roller pressure. See Section titled "Adjusting the 1 ½" & 2" Pressure Rollers"

SPECIFICATIONS

- Model#: MXB2000
- Stock #: 66115140
- Length: 26''
- Width: 25''
- Height: 44''
- Weight: 265 LBS.

WARRANTY ON
SOUTHWIRE CONTRACTOR EQUIPMENT

What Does This Warranty Cover?

Five-Year Limited Warranty on Contractor Equipment

Under Southwire's Contractor Equipment 5-Year Limited Warranty, Southwire Company, LLC warrants that all Southwire Contractor Equipment will be free from manufacturer defects for a period of five (5) years from the date of the original end user's purchase. However, electrical components and consumable parts such as "ropes, blades, dies, draw studs, grips, "are excluded from this 5-Year Limited Warranty and are subject to the One -Year warranty terms. Under this 5-Year Limited Warranty, the following are also excluded and Southwire Company, LLC will have no liability for any of the following: normal wear and tear resulting from product use and damage arising out of misuse, abuse, modification, and improper product maintenance. This warranty also does not cover Southwire Contractor Equipment products that have been modified by any party other than Southwire Company, LLC or its authorized third-party designee. This 5-Year Limited Warranty is not transferrable to or enforceable by any person other than the product's original end user.

One-Year Limited Warranty on Electrical Components and Consumable Parts (with 5-Year warranty)

Under Southwire's 1-Year Limited Warranty, Southwire Company, LLC warrants that all electrical components and consumable parts such as "ropes, blades, dies, draw studs, "grips will be free from manufacturer defects for a period of one-year from the date of the original end user's purchase.

Under this 1-Year Limited Warranty, Southwire Company, LLC will have no liability for any of the following: normal wear and tear resulting from product use and damage arising out of misuse, abuse, modification, and improper product maintenance. This warranty also does not cover Southwire electrical components and consumable parts that have been modified by any party other than Southwire Company, LLC or its authorized third-party designee. This 1-Year Limited Warranty is not transferrable to or enforceable by any person other than the product's original end user.

Exclusion of Incidental, Consequential, Indirect, Special and Punitive Damages

SOUTHWIRE MAKES NO WARRANTY THAT SOUTHWIRE CONTRACTOR EQUIPMENT PRODUCTS WILL BE MERCHANTABLE OR FIT FOR ANY PARTICULAR PURPOSE. SOUTHWIRE MAKES NO OTHER WARRANTY, EXPRESSED OR IMPLIED, OTHER THAN THE RELEVANT WARRANTY SPECIFICALLY SET FORTH IN THIS WARRANTY SECTION. SOUTHWIRE WILL NOT BE LIABLE FOR ANY INCIDENTAL, CONSEQUENTIAL, INDIRECT, SPECIAL, OR PUNITIVE DAMAGES FOR ANY BREACH OF THIS LIMITED LIFETIME WARRANTY.

Some states do not allow the exclusion or limitation of incidental or consequential damages, so the above limitation or exclusion may not apply to you.

Warranty Claim Information/How Do You Get Service?

For all warranty, customer service, and product return authorizations and inquiries, please contact Southwire's Tools & Assembled Products at:
Southwire Tools & Assembled Products
840 Old Bremen Road
Carrollton, GA, 30117
Phone Number: 1.855.SW.Tools

1. All warranty claims must be approved by Southwire's Tools & Assembled Products Warranty Department prior to return of product. If Southwire determines that a product is defective, Southwire will, at its option, repair or replace defective products or defective product components, free of charge.
2. Upon approval, Southwire will issue a Product Return Authorization Form which will include instructions on how and where to return the product. **The product serial number and the original date of delivery must be set forth on the Product Return Authorization Form.**
3. Southwire will cover standard freight charges (Ground Courier Rate) incurred in connection with products that Southwire ultimately determines to be defective.
4. All defective components and defective products that Southwire replaces under these Warranties will become Southwire's property and will be retained by Southwire.

Repair Your Product When it is Out of Warranty

Southwire is happy to provide information about where a purchaser can send a product for repair at the consumers expense.
Contact 1.855.SWtools or visit:
https://www.southwire.com/resources/repair-centers for information about a repair center that services conduit benders.