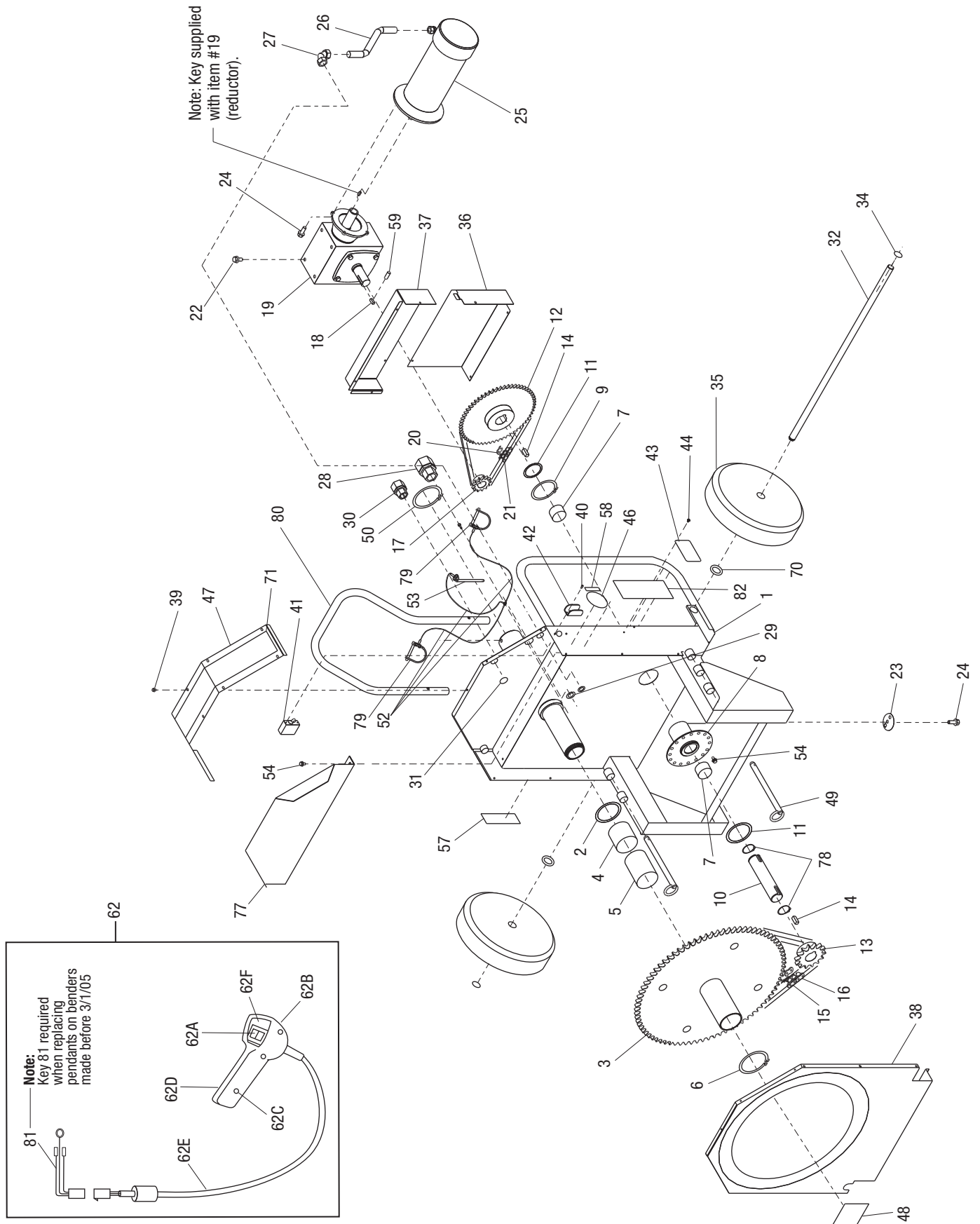
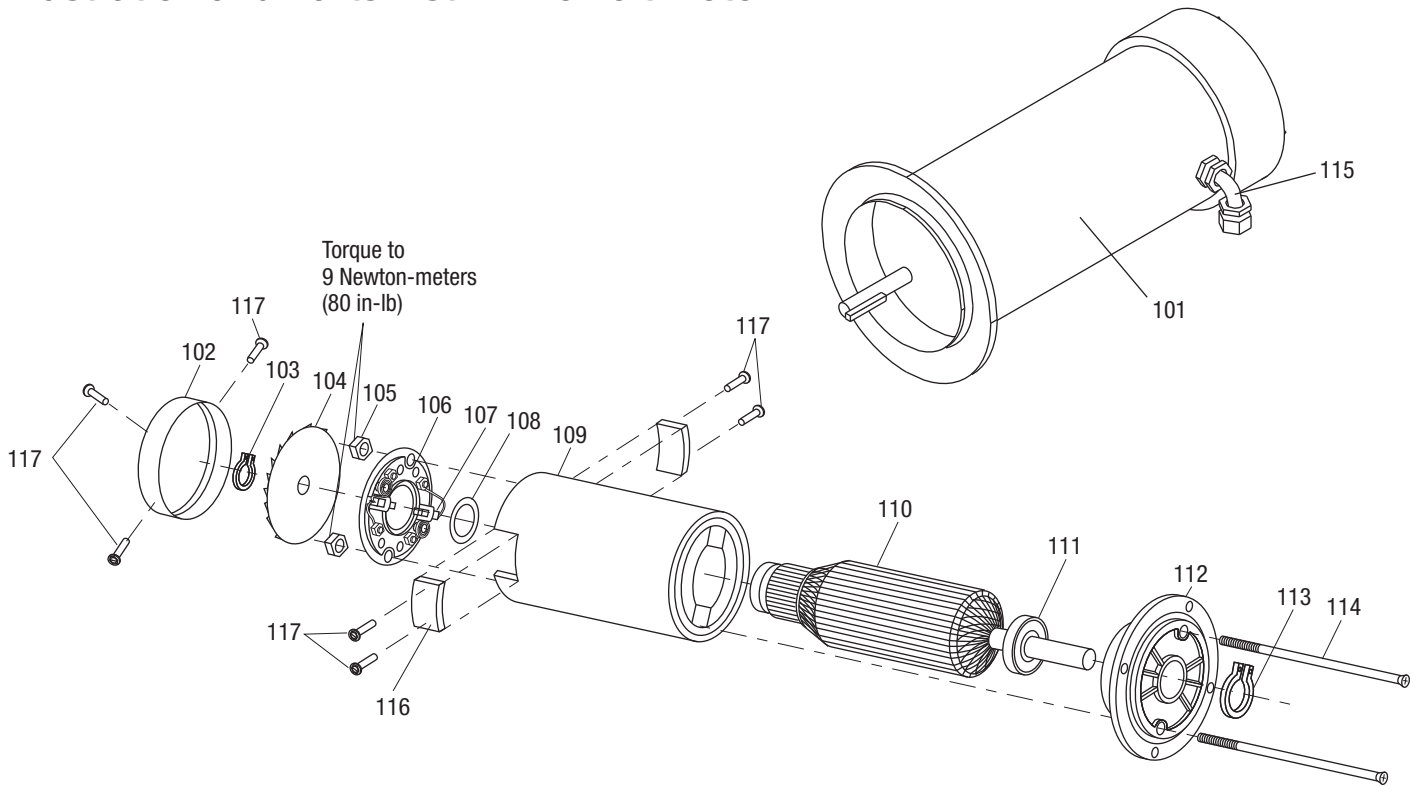


## Illustration – 555C Electric Bender Classic



**Parts List — 555C Electric Bender Classic**

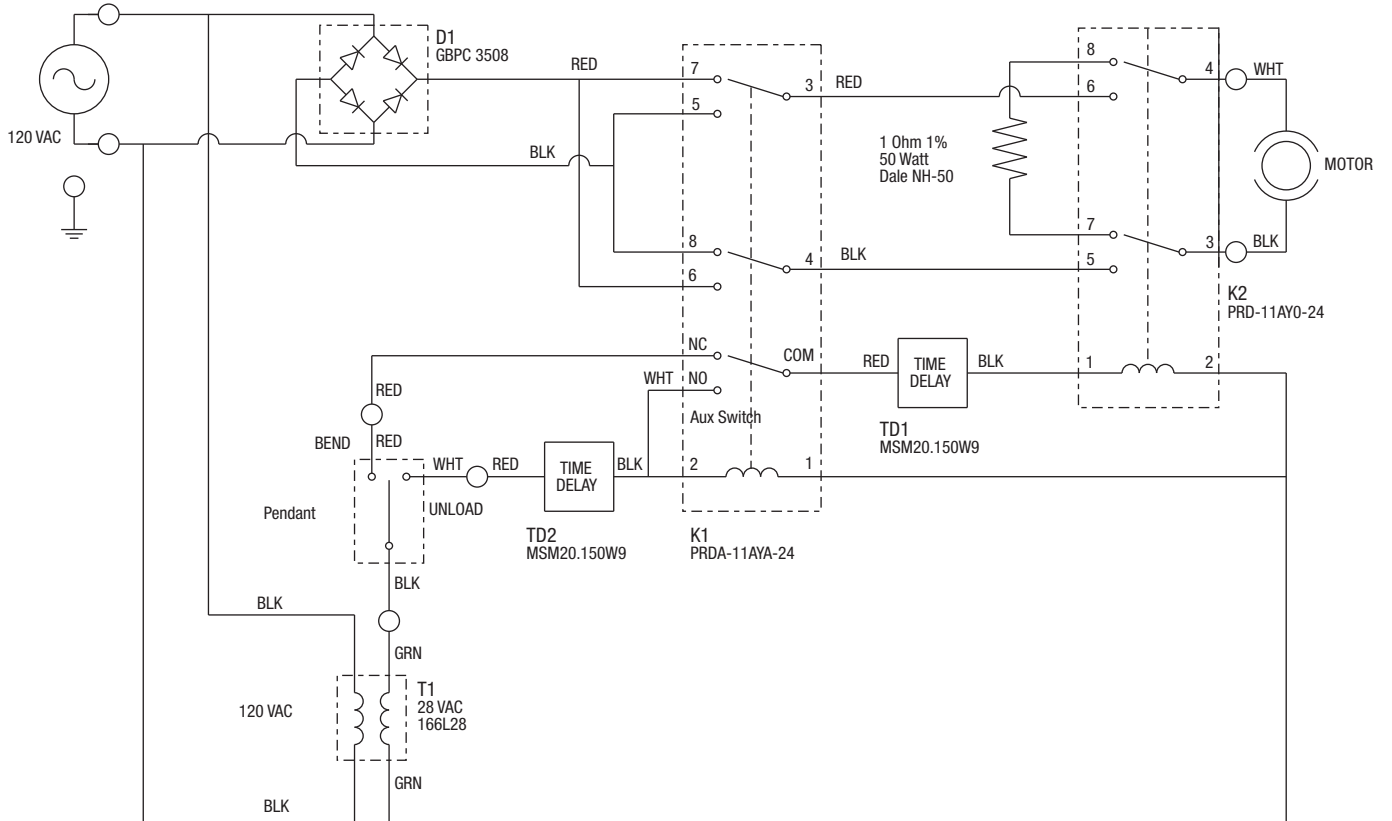
Key	Part No.	Description	Qty	Key	Part No.	Description	Qty
1	50397427	Weldment, main frame .....	1	40	90504305	Screw, #6–32 x .375 Phillips .....	2
2	50234528	Washer, fiber.....	1	41	91863856	Switch, air pax.....	1
3	50328964	Weldment, sprocket unit .....	1	42	50297082	Guard, switch .....	1
4	90524098	Bearing, Fiberglide® ø2.625 x 2.5 long....	1	43	50069055	Nameplate .....	1
5	90524101	Bearing, Fiberglide ø2.625 x 3.75 long ...	1	44	90530012	Rivet, pop 1/8 x 1/8 drive.....	4
6	90524144	Ring, retaining #5100-237 .....	1	46	50303929	Decal, damp warning .....	1
7	90524128	Bearing, Fiberglide ø1.625 x 1.00 long ...	2	47	50397591	Cover, top.....	1
8	50397630	Weldment, countershaft.....	1	49	90533895	Pin, hitch .....	2
9	90540239	Ring, retaining #5100-250 .....	1	50	90525019	Ring, retaining #5100-287 .....	1
10	50397648	Countershaft .....	1	52	90545524	Lanyard .....	3
11	90524136	Bearing, thrust Fiberglide .....	2	53	90545451	Pin, hitch .....	1
12	90545486	Sprocket, #40 60T.....	1	54	90543351	Screw, 1/4 x .37 thread-forming.....	6
13	90542533	Sprocket, #60 14T.....	1	57	50339370	Decal, squeeze adjust .....	1
14	50397656	Key, countershaft .....	2	58	50389742	Decal, circuit breaker .....	1
15	90545460	Chain, #60 87P.....	1	59	90553233	Pin, DRIV-LOK®, 1/8 x 1/2.....	1
16	90542517	Masterlink, #60.....	1	61	50079123	Power cord, Twist-Lock 20 Amp.....	1
17	90545478	Sprocket, #40 13T.....	1	62	50398393	Switch, pendant (complete assembly with Molex plug).....	1
18	50084313	Key, reductor sprocket .....	1	62A	91864496	Switch, center OFF.....	1
19	90523881	Reductor, worm gear.....	1	62B	50319027	Handle, right half .....	1
20	90527879	Masterlink, #40.....	1	62C	90534417	Screw, #6–20 x .625 pan head, self-tapping.....	3
21	90545516	Chain, #40 87P.....	1	62D	50319019	Handle, left half.....	1
22	90545680	Bolt, 3/8–16 UNC x .75 .....	7	62E	50398377	Cord.....	1
23	50397583	Eccentric .....	1	62F	50354876	Decal, faceplate .....	1
24	90542371	Bolt, 3/8–16 UNC x 1.00 .....	5	70	90517407	Washer, flat.....	2
25	91869730	Motor.....	1	71	52066299	Decal, instruction .....	1
26	90545494	Conduit, Sealtight.....	1	77	50068890	Electronic control assembly .....	1
27	91852145	Elbow, Sealtight.....	1	78	90510518	Ring, retaining #5100-150 .....	2
28	91866839	Strain relief .....	1	79	90552687	Pin, safety snap.....	2
29	90511700	Nut, 3/4 conduit lock.....	1	80	50397486	Handle, upper.....	1
30	91867673	Strain relief, pendant switch.....	1	81	50120620	Adapter, with Molex plug (required when replacing pendant switch on units made prior to 3/1/05) .....	1
31	91862639	Nut, 1/2 conduit lock.....	1	82	52025721	Decal, safety/warning.....	1
32	50397575	Axle .....	1				
34	90515285	Ring, retaining #5160-75.....	2				
35	90533909	Wheel .....	2				
36	50397680	Guard, rear lower.....	1				
37	50397699	Guard, rear upper.....	1				
38	50397605	Cover, front.....	1				
39	90516559	Screw, #10–16 x .50 hex head .....	31				

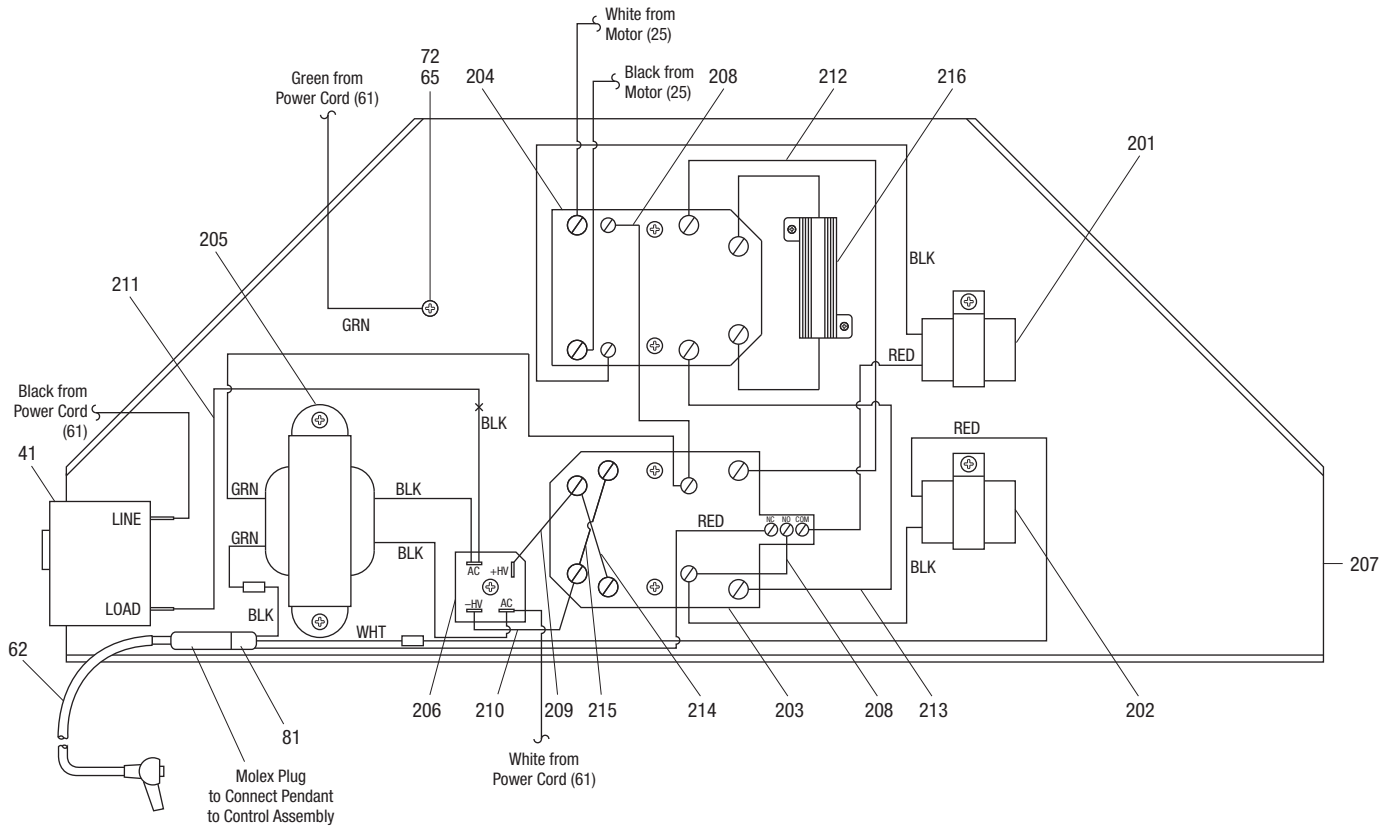
**Illustration and Parts List — 115 Volt Motor**

**Pacific Scientific**

Key	Part No.	Description	Qty
101	91869730	Motor (SRF-3648-5532-7-56C).....	1
*	91864178	Motor, 115 Volt (standard) (SRF-3745-4676-2-56C).....	1
102	91864712	Fan cover .....	1
103	90550714	Retaining ring .....	1
104	91864321	Fan .....	1
105	91864283	End bell nut .....	2
106	91864194	Bell, rear end .....	1
107	91864208	Brush.....	2
108	91864224	Thrust washer .....	1
109	91869757	Shell and magnet assembly.....	1
*	91864275	Shell and magnet assembly, 115V.....	1
110	91869749	Armature .....	1
*	91864259	Armature, 115V .....	1
111	91864216	Bearing kit .....	2
112	91864186	Bell, front end.....	1
113	91864240	Retaining ring .....	1
114	91864267	Tie bolt, 115V .....	2
115	91858763	90° Connector.....	1
116	91864305	Brush cover.....	2
117	91864313	Cover screw .....	7

*\*Note: Alternate motor  
Check motor part number before ordering magnet shell or armature.*

**Schematic Diagram**



**Control Assembly**

**Electronic Control Assembly – Part No. 50068890**

Key	Schematic Reference	Part No.	Description	Qty
201	TD1	50069152	Timer assembly, 150 ms ON Delay .....	1
202	TD2	50069071	Timer assembly, 150 ms ON Delay .....	1
203	K1	91869668	Relay, power, DPDT (with switch) .....	1
204	K2	91869676	Relay, power, DPDT .....	1
205	T1	50069080	Transformer assembly.....	1
206	D1	91859972	Bridge rectifier.....	1
207		50068954	Bracket, electrical mounting .....	1
208		50068962	Wire harness, 14 AWG .....	2
209		50060341	Wire harness, 12 AWG (RED) .....	1
210		50060350	Wire harness, 12 AWG (BLK) .....	1
211		50069160	Wire unit, BLK Rectifier.....	1
212		50068989	Wire harness, 12 AWG (RED).....	1
213		50068997	Wire harness, 12 AWG (BLK) .....	1
214		50060481	Wire harness, 12 AWG (RED).....	1
215		50060490	Wire harness, 12 AWG (BLK) .....	1
216		50060511	Resistor unit with leads.....	1
65		90543297	Screw, #8–32 x .37 ground .....	1
72		90537246	Washer, internal tooth lock.....	1
81		50120620	Adapter with Molex Plug.....	1

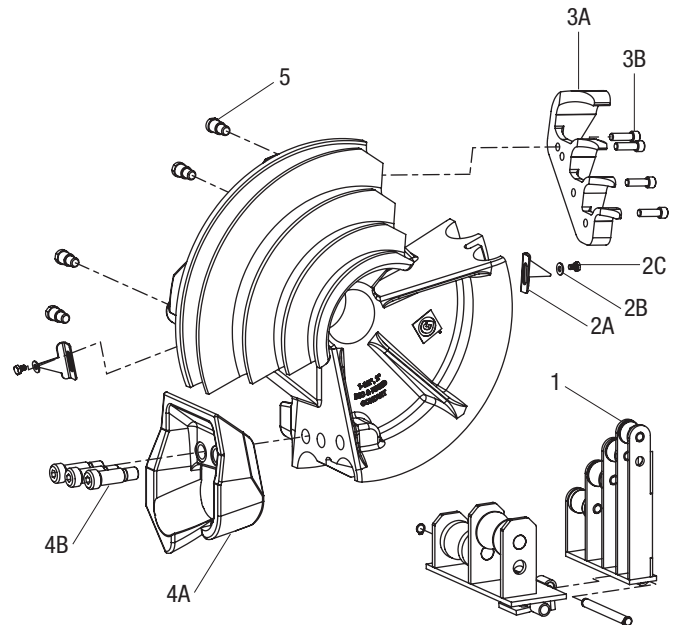
## Bending Shoes and Roller Supports

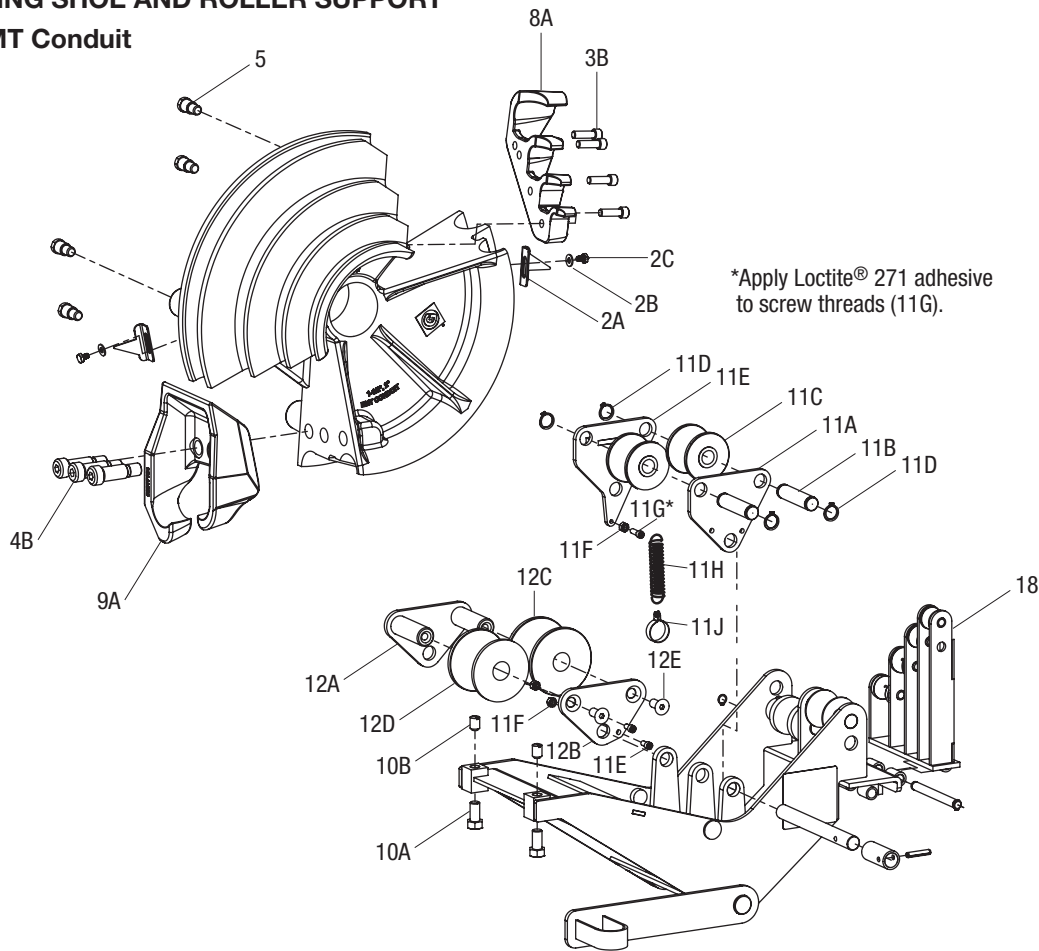
### 28008 BENDING SHOE AND ROLLER SUPPORT

1/2" to 2" Rigid Conduit

1/2" to 1-1/4" IMC Conduit

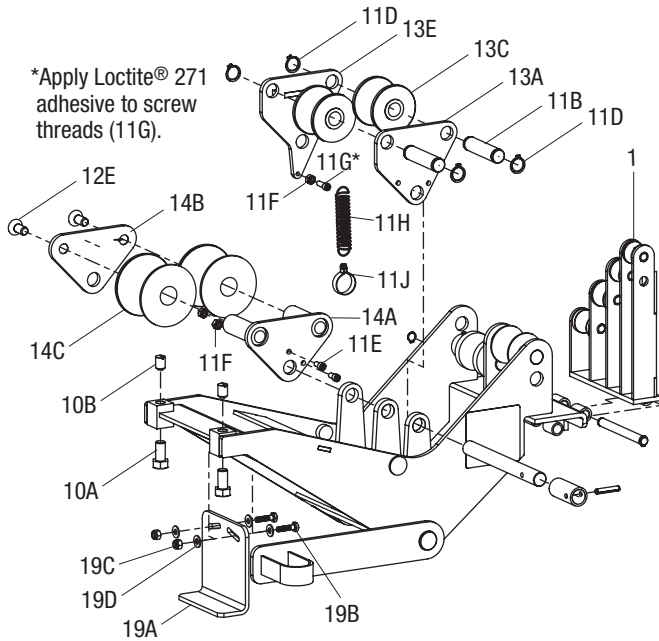
Key	Part No.	Description	Qty
	52066935	Shoe unit, 1/2"-2" rigid/IMC .....	1
	52066936	Roller support unit, 1/2"-2" rigid.....	1
1	52066937	Roller support, 1/2"-1-1/4" .....	1
2	52065278	Pointer kit (includes one each 2A-2C)	
2A		Point.....	2
2B		Washer, 1/4" standard.....	2
2C		Screw, 1/4-20 x 3/8 hex hd cap.....	2
3	52065279	Hook kit, 1/2"-1-1/4" rigid/IMC	
3A		Hook, 1/2"-1-1/4" rigid/IMC .....	1
3B		Screw, 3/8-16 x 1-1/4 skt hd cap.....	4
4	52065280	Hook kit, 1-1/2"-2" rigid/IMC	
4A		Hook, 1-1/2"-2" rigid/IMC .....	1
4B		Shoulder screw, $\phi$ .75 x 1.50 x 5/8-11 .....	3
5	52066933	Drive pin .....	4



**Bending Shoes and Roller Supports (cont'd)**
**23803 BENDING SHOE AND ROLLER SUPPORT**
**1/2" to 2" EMT Conduit**


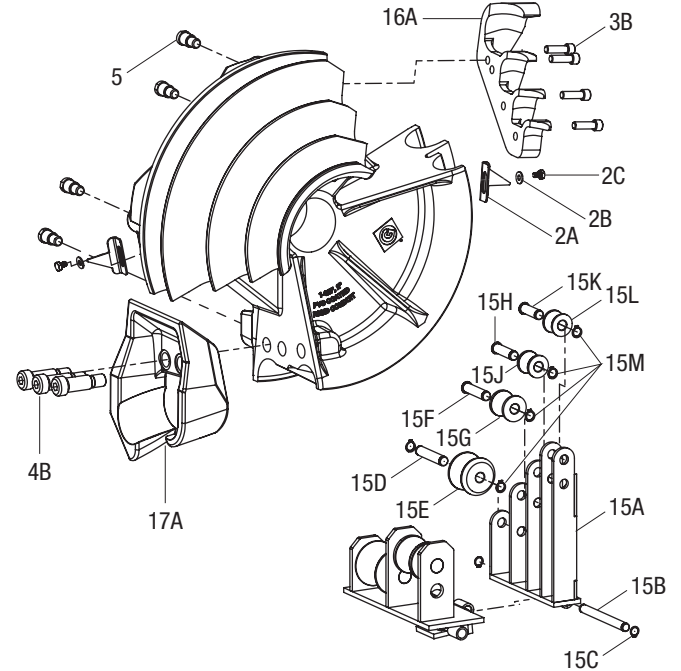
Key	Part No.	Description	Qty
	52066931	Shoe unit, 1/2"-2" EMT.....	1
	52066932	Bridge unit, 1/2"-2" EMT .....	1
2	52065278	Pointer kit (includes one each 2A-2C)	
2A		Point.....	2
2B		Washer, 1/4" standard.....	2
2C		Screw, 1/4-20 x 3/8 hex hd cap.....	2
8	52065321	Hook kit, 1/2"-1-1/4" EMT	
8A		Hook, 1/2"-1-1/4" EMT.....	1
3B		Screw, 3/8-16 x 1-1/4 skt hd cap.....	4
9	52065322	Hook kit, 1-1/2"-2" EMT	
9A		Hook, 1-1/2"-2" EMT.....	1
4B		Shoulder screw, ø.75 x 1.50 x 5/8-11 .....	3
5	52066933	Drive pin .....	4
10	52065273	Screw kit (includes one each 10A-10B)	
10A		Screw, 1/2-13 x 1 hex hd cap .....	2
10B		Screw, 1/2-13 x 3/4 slotted set.....	2

Key	Part No.	Description	Qty
11	52065274	Roller kit, 1-1/2" EMT	
11A		Pivot plate .....	1
11B		Pin, 1-1/2" EMT roller.....	2
11C		Roller, 1-1/2" EMT .....	2
11D		Retaining ring, Truarc #5160 EX.....	4
11E		Pivot plate, rear .....	1
11F		Hex nut, 1/4-20 .....	1
11G		Screw, 1/4-20 x 3/4 skt hd cap.....	1
11H		Spring, extension .....	1
11J		Clamp, loop type.....	1
12	52065275	Roller kit, 2" EMT	
12A		Support weldment, 2" EMT.....	1
12B		Plate, 2" EMT .....	1
12C		Roller, 2" EMT back (larger OD) .....	1
12D		Roller, 2" EMT front (smaller OD) .....	1
12E		Screw, 7/16-14 x 1 flat hd cap .....	2
11E		Screw, 1/4-20 x 1/2 skt hd cap.....	2
11F		Hex nut, 1/4-20 .....	2
18	52066934	Roller support, 1/2"-1-1/4" EMT.....	1

**Bending Shoes and Roller Supports (cont'd)**
**01323 BRIDGE UNIT**
**1/2" to 2" IMC and Rigid Conduit**


\*Apply Loctite® 271 adhesive to screw threads (11G).

Key	Part No.	Description	Qty
	52064757	Bridge unit, 1/2"-2" IMC/rigid.....	1
10	52065273	Screw kit (includes one each 10A-10B)	
10A		Screw, 1/2-13 x 1 hex hd cap.....	2
10B		Screw, 1/2-13 x 3/4 slotted set.....	2
13	52065276	Roller kit, 1-1/2" IMC	
13A		Pivot plate.....	1
11B		Pin, 1-1/2" EMT roller.....	2
13C		Roller, 1-1/2" IMC.....	2
11D		Retaining ring, Truarc #5160 EX.....	4
13E		Pivot plate, rear.....	1
11F		Hex nut, 1/4-20.....	1
11G		Screw, 1/4-20 x 3/4 skt hd cap.....	1
11H		Spring, extension.....	1
11J		Clamp, loop type.....	1
14	52065277	Roller kit, 2" IMC	
14A		Support weldment, 2" IMC.....	1
14B		Plate, 2" IMC.....	1
14C		Roller, 2" IMC.....	2
12E		Screw, 7/16-14 x 1 flat hd cap.....	2
11E		Screw, 1/4-20 x 1/2 skt hd cap.....	2
11F		Hex nut, 1/4-20.....	2
1	52066937	Roller support, 1/2"-1-1/4" IMC/rigid.....	1
19	52066949	Plate kit (includes 19A-19D)	
19A		Plate, bridge trap.....	1
19B		Screw, 1/4-20 x 1-1/4 hex hd cap.....	2
19C		Lock nut, 1/4-20.....	2
19D		Washer, 1/4" standard.....	4

**12586 PVC BENDING SHOE AND ROLLER SUPPORT**
**1/2" to 2" 40 MIL PVC-Coated Rigid Conduit**


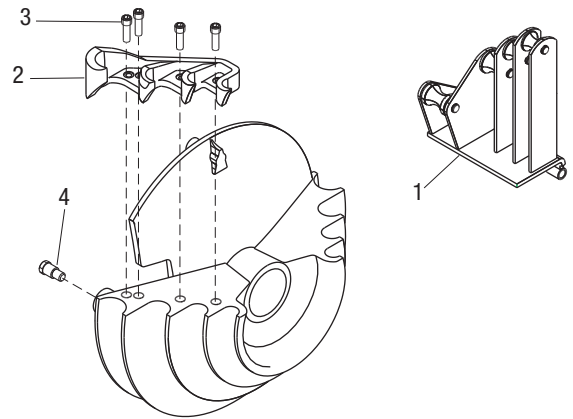
Key	Part No.	Description	Qty
	52066939	Shoe unit, 1/2"-2" PVC-coated rigid	
	52066940	Roller support unit, 1/2"-2"	
15	52065272	Roller support, 1/2"-1-1/4"	
15A		Support weldment.....	1
15B		Pivot pin.....	1
15C		Retaining ring, Truarc #5160-42 EX.....	2
15D		Axle, 1-1/4" roller.....	1
15E		Roller, 1-1/4".....	1
15F		Axle, 1" roller.....	1
15G		Roller, 1".....	1
15H		Axle, 3/4" roller.....	1
15J		Roller, 3/4".....	1
15K		Axle, 1/2" roller.....	1
15L		Roller, 1/2".....	1
15M		Retaining ring, Truarc #5160-50 EX.....	5
2	52065278	Pointer kit (includes one each 2A-2C)	
2A		Point.....	2
2B		Washer, 1/4" standard.....	2
2C		Screw, 1/4-20 x 3/8 hex hd cap.....	2
16	52065323	Hook kit, 1/2"-1-1/4" PVC	
16A		Hook, 1/2"-1-1/4" PVC.....	1
3B		Screw, 3/8-16 x 1-1/4 skt hd cap.....	4
17	52065324	Hook kit, 1-1/2"-2" PVC	
17A		Hook, 1-1/2"-2" PVC.....	1
4B		Shoulder screw, ø.75 x 1.50 x 5/8-11.....	3
5	52066933	Drive pin.....	4



**Bending Shoes and Roller Supports (cont'd)**
**BENDING SHOE AND ROLLER SUPPORT  
1/2" to 1-1/4" IMC and Rigid Conduit**

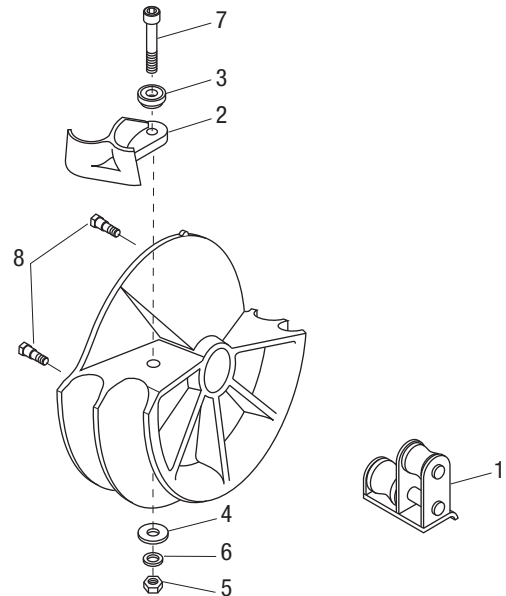
Key	Part No.	Description	Qty
1	50009362	Roller support, 1/2" to 1-1/4" IMC and rigid.....	1
	50005715	Bending shoe assembly (includes 2-4) .....	1
2	50005693	Hook.....	1
3		Screw, 3/8-16 UNC x 1-1/4" socket head cap.....	4
4	50234226	Stud, drive .....	3

Shoe not available separately.


**BENDING SHOE AND ROLLER SUPPORT  
1-1/2" to 2" Rigid Conduit**

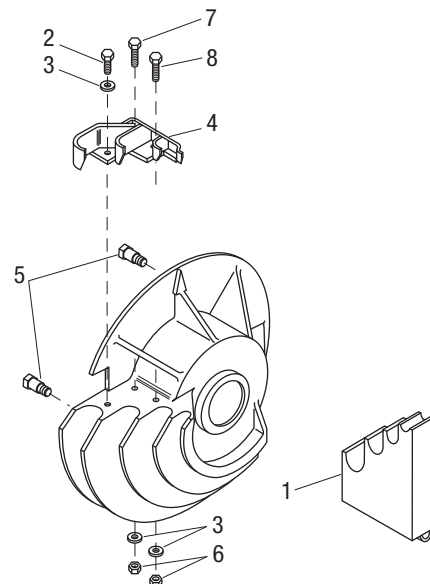
Key	Part No.	Description	Qty
1	50179845	Roller support, 1-1/2" to 2" rigid conduit .....	1
	50179373	Bending shoe assembly, 1-1/2" to 2" rigid conduit (includes 2-8).....	1
2	50179691	Pipe hook .....	1
3	50179748	Pivot .....	1
4	90526759	Washer, 5/8 flat.....	1
5	90515692	Nut, 5/8-11 UNC hex .....	1
6	90509056	Lock washer, 5/8 split .....	1
7	90524268	Screw, 5/8-11 UNC x 4" socket head cap.....	1
8	50234226	Stud, drive.....	4

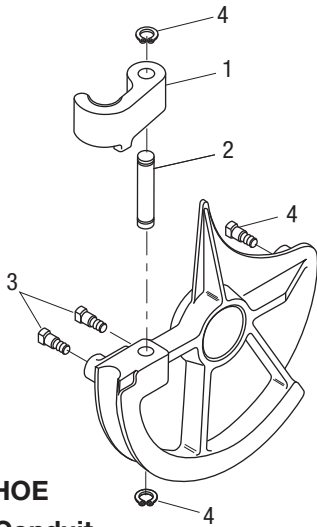
Shoe not available separately.


**BENDING SHOE AND PIPE REST  
1/2" to 1-1/4" EMT Conduit**

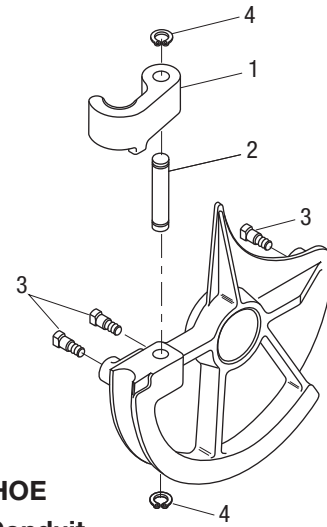
Key	Part No.	Description	Qty
1	50179861	Pipe rest assembly for 1/2" to 1-1/4" EMT conduit.....	1
	50179446	Bending shoe assembly for 1/2" to 2-1/4" EMT conduit (includes 2-8).....	1
2		Screw, 3/8-16 UNC x 1" socket head cap.....	1
3		Lock washer, 3/8 split .....	3
4	50245554	Pipe hook .....	1
5	50234226	Stud, drive.....	4
6		Nut, 3/8-16 UNC hex, cad.-plated.....	2
7		Screw, 3/8-16 UNC x 1-1/4 SAE grade 5 socket head cap.....	1
8		Screw, 3/8-16 UNC x 1-1/4 socket head .....	1

Shoe not available separately.

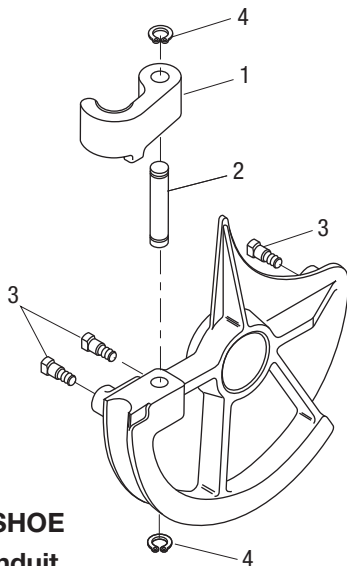


**Bending Shoes and Roller Supports (cont'd)**

**BENDING SHOE  
1-1/2" EMT Conduit**

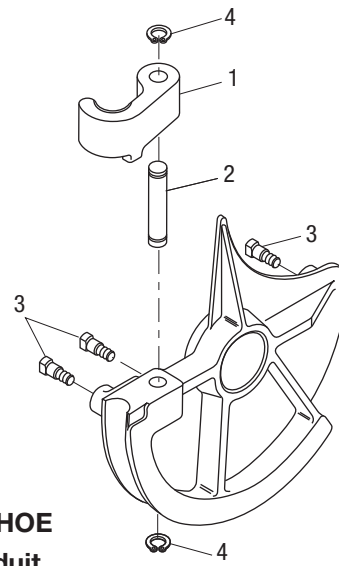
Key	Part No.	Description	Qty
	50234994	Shoe unit, 1-1/2" EMT (includes 1-4).....	1
1	50188208	Hook, 1-1/2" EMT .....	1
2	50188410	Pin, 1-1/2" EMT hook.....	1
3	50234226	Stud, drive.....	3
4	90515293	Ring, Tru-Arc #5160-87 retaining .....	2


**BENDING SHOE  
1-1/2" IMC Conduit**

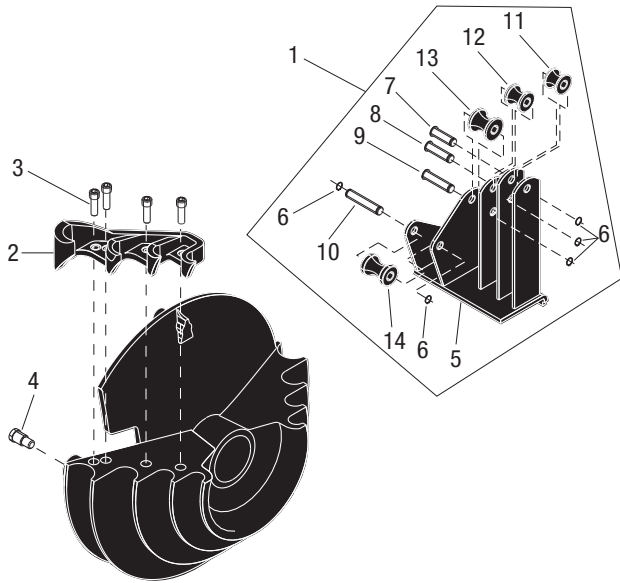
Key	Part No.	Description	Qty
	50253631	Shoe unit, 1-1/2" IMC (includes 1-4) .....	1
1	50188119	Hook, 1-1/2" IMC.....	1
2	50188372	Pin, 1-1/2" IMC .....	1
3	50234226	Stud, drive.....	3
4	90515285	Ring, Tru-Arc retaining.....	2


**BENDING SHOE  
2" EMT Conduit**

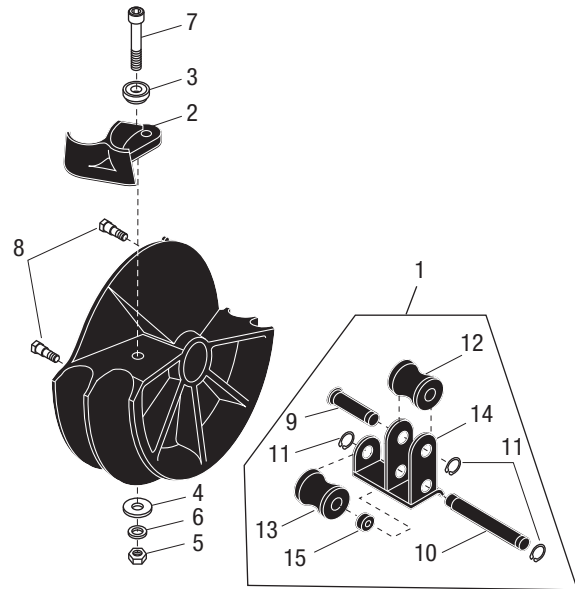
Key	Part No.	Description	Qty
	50235052	Shoe unit, 2" EMT conduit (includes 1-4) .....	1
1	50188186	Hook, 2" EMT.....	1
2	50188429	Pin, 2" EMT hook .....	1
3	50234226	Stud, drive.....	3
4	90515293	Ring, Tru-Arc #5160-87, retaining .....	2


**BENDING SHOE  
2" IMC Conduit**

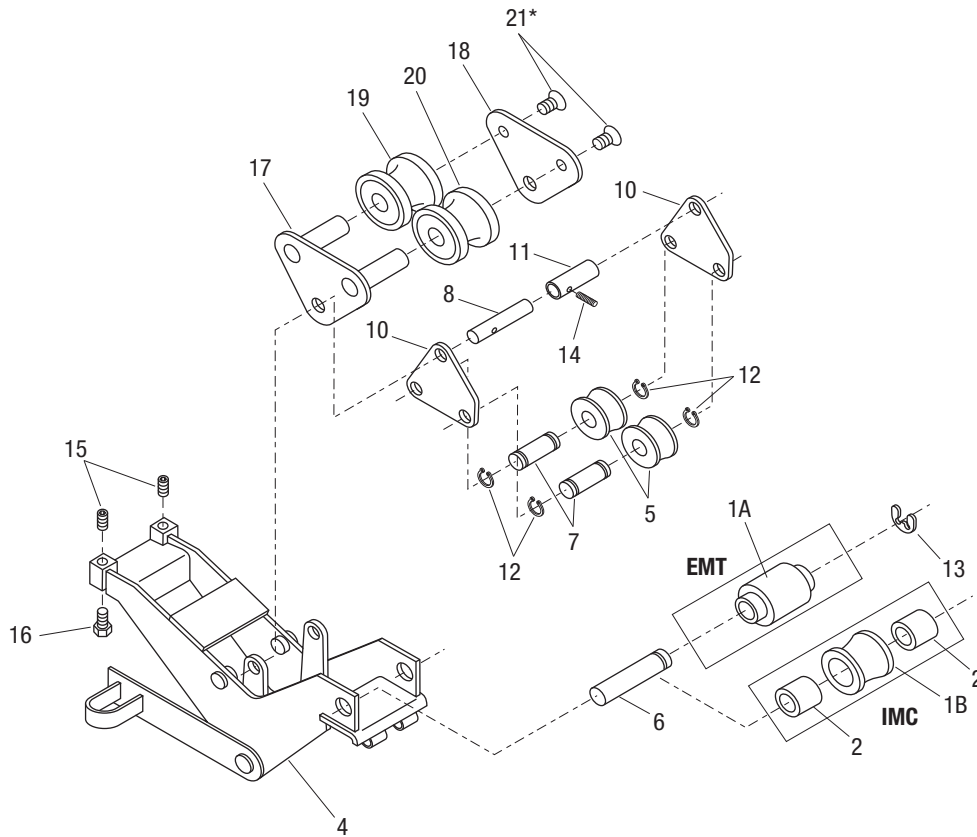
Key	Part No.	Description	Qty
	50252682	Shoe unit, 2" IMC (includes 1-4) .....	1
1	50001957	Hook, 2" IMC.....	1
2	50188429	Pin, 2" IMC .....	1
3	50234226	Stud, drive.....	3
4	90515293	Ring, Tru-Arc retaining.....	2

**Bending Shoes and Roller Supports (cont'd)**

**BENDING SHOE AND ROLLER SUPPORT  
1/2" to 1-1/4" 40 Mil PVC-Coated Rigid Conduit**

Key	Part No.	Description	Qty
1	50009460	Roller support, 1/2" to 1-1/4" PVC-coated rigid (includes 5-14).....	1
	50005731	Bending shoe assembly, 1/2" to 1-1/4" PVC-coated rigid (includes 2-4) .....	1
2	50005707	Hook.....	1
3	90510887	3/8-16 UNC x 1-1/4" Socket head cap screw.....	4
4	50234226	Stud, drive.....	3
5	50009451	Support weldment, roller.....	1
6	90513533	Retaining ring .....	5
7	50009230	1/2" Roller axle.....	1
8	50009249	3/4" Roller axle.....	1
9	50009257	1" Roller axle.....	1
10	50009265	1-1/4" Roller axle .....	1
11	50009273	1/2" Roller .....	1
12	50009281	3/4" Roller .....	1
13	50009290	1" Roller.....	1
14	50009303	1-1/4" Roller.....	1


**BENDING SHOE AND ROLLER SUPPORT  
1-1/2" to 2" 40 Mil PVC-Coated Rigid Conduit**

Key	Part No.	Description	Qty
1	50372823	Roller support, 1-1/2" to 2" PVC-coated rigid (includes 9-15).....	1
	50372815	Bending shoe assembly, 1-1/2" to 2" PVC (includes 2-8) .....	1
2	50024990	Hook.....	1
3	50179748	Pivot .....	1
4	90526759	5/8" Flat washer .....	1
5	90515692	5/8-11 UNC Hex nut.....	1
6	90509056	5/8" Lock washer .....	1
7	90524268	5/8-11 UNC x 4" socket head cap screw .....	1
8	50234226	Stud, drive.....	4
9	50376624	1-1/2" Shaft.....	1
10	50376616	2" Shaft .....	1
11	90515285	Retaining ring .....	3
12	50372840	1-1/2" Roller.....	1
13	50372831	2" Roller.....	1
14	50376640	Support weldment.....	1
15	50320254	Spacer.....	1

**Bending Shoes and Roller Supports (cont'd)**

**EMT ROLLER SUPPORT UNIT**

Key	Part No.	Description	Qty
	50235419	Support unit, 1-1/2" and 2" EMT roller (includes all of the following).....	1
1A	50279831	Roller unit, cushioned.....	1
4	50235397	Frame unit .....	1
5	50235109	Roller, 1-1/2" EMT .....	2
6	50235117	Pin, roller support.....	1
7	50239325	Pin, 1-1/2" EMT roller.....	2
8	50235176	Pin, roller pivot .....	1
10	50235249	Plate, 1-1/2" EMT pivot.....	2
11	50237934	Spacer .....	1
12	90515285	Ring, retaining .....	4
13	90524640	Ring, Tru-Arc #X5133-98 external series "E" retaining .....	1
14	90514912	Rollpin, #59, -040-187-1250 .....	1
15	90528484	Screw, 1/2-13 UNC x 3/4 cup point socket set.....	2
16	90505425	Screw, 1/2-13 UNC x 1, hex head cap ...	2
17	50349643	Support weldment, 2" roller .....	1
18	50349651	Plate, 2" inner roller support .....	1
19	50235192	Roller, 2" EMT front .....	1
20	50237926	Roller, 2" EMT back.....	1
21*	90533941	Screw, 7/16-14 UNC x 1, flat head.....	2

**IMC ROLLER SUPPORT UNIT**

Key	Part No.	Description	Qty
	50252739	Support unit, 1-1/2" and 2" IMC roller (includes 1 and 2).....	1
1B	50283340	Roller .....	1
2	50283359	Spacer .....	2
4	50263250	Frame unit .....	1
5	50252747	Roller, 1-1/2" IMC.....	2
6	50235117	Pin, roller support.....	1
7	50239325	Pin, 1-1/2" IMC roller.....	2
8	50235176	Pin, roller pivot .....	1
10	50235249	Plate, 1-1/2" IMC pivot.....	2
11	50237934	Spacer .....	1
12	90515285	Ring, retaining .....	4
13	90524640	Ring, Tru-Arc #X5133-98 external series "E" retaining .....	1
14	90514912	Rollpin, #59, -040-187-1250 .....	1
15	90528484	Screw, 1/2-13 UNC x 3/4 cup point socket set.....	2
16	90505425	Screw, 1/2-13 UNC x 1, hex head cap ...	2
17	50349643	Support weldment, 2" roller .....	1
18	50349651	Plate, 2" inner roller support .....	1
19	50252798	Roller, 2" IMC .....	2
21*	90533941	Screw, 7/16-14 UNC x 1, flat head.....	2

\*Key No. 21 must be torqued to 54 to 61 Newton-meters (40 to 45 ft-lb).



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