



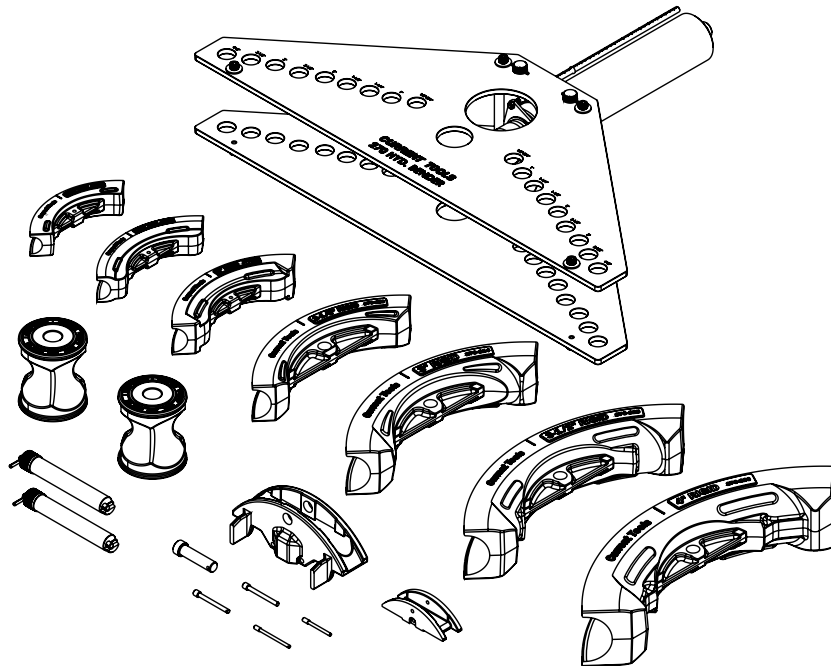
Current Tools

FOR THE PROFESSIONAL ELECTRICIAN

MODEL 270 and 271

Hydraulic Conduit Bender

**for bending 1 ¼" thru 5"
RIGID Conduit**



Assembly, Operating, Maintenance, Safety and Parts Manual

09/2024



Read and understand this material before assembling, operating or servicing this Hydraulic Bender. Failure to understand how to safely assemble, operate and service this unit may result in serious injury or death.

This manual is free of charge. All personnel who assemble, operate or service this Hydraulic Bender should have a copy of this manual and read and understand its contents. To request a copy, call or write to the address below. All information, specifications and product designs may change due to design improvements or updates and are subject to change without notice. Current Tools does not assume any liability for damages resulting from misuse or incorrect application of its products.

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Safety Alert Symbol

THIS SAFETY SYMBOL is used to call your attention to instructions that concern your personal safety. It means: ATTENTION! BE AWARE! THIS IS AN IMPORTANT SAFETY INSTRUCTION!

Read, understand, and follow these safety instructions. Failure to follow these safety instructions may result in injury or death.

DANGER

Immediate hazards which, if not avoided, **WILL** result in serious personal injury or death.

WARNING

Hazards or unsafe practices which, if not avoided, **COULD** result in serious personal injury or death.

CAUTION

Hazards or unsafe practices which, if not avoided, **COULD** result in minor personal injury or property damage.

RETAIN SAFETY INFORMATION



This manual should be read and understood by all personnel who assemble, operate or service this hydraulic bender. Failure to understand how to safely assemble, operate and service this unit could result in injury or death. This unit should only be assembled, operated and serviced by qualified personnel.



IMPORTANT SAFETY INFORMATION

- ⚠ DANGER** NEVER operate the bender in an explosive atmosphere.
- ⚠ WARNING** NEVER operate the bender in wet or damp locations. DO NOT expose the bender to rain.
- ⚠ WARNING** ALWAYS disconnect the bender from the hydraulic pump before servicing and when not in use.
- ⚠ WARNING** ALWAYS inspect the bender before operating. Replace any damaged, missing or worn parts. Check for alignment of moving parts, binding of moving parts, breakage of parts and any other conditions that may effect its operation.
- ⚠ WARNING** NEVER alter this equipment. Doing so will void the warranty.
- ⚠ WARNING** ALWAYS keep hands and feet away from pinch points such as bending shoes, conduit supports, conduit and other moving parts.
- ⚠ WARNING** ALWAYS use appropriate bending shoe, conduit supports and shoe adapter for the size conduit to be bent.
- ⚠ WARNING** ALWAYS keep conduit under control when unloading.
- ⚠ WARNING** ALWAYS keep the path of the bending conduit clear of obstructions. Make sure all obstacles are clear of the bending path BEFORE you bend the conduit.
- ⚠ WARNING** ALWAYS wear approved safety glasses when the bender is in operation.
- ⚠ WARNING** ALWAYS wear proper apparel. Do not wear loose clothing, gloves, neckties, rings, bracelets, or other jewelry which may get caught in moving parts. Non-slip footwear is recommended. Wear protective hair covering to contain long hair.
- ⚠ WARNING** NEVER stand in direct line with the hydraulic cylinder while operating or servicing the bender. Some parts of the cylinder are under high pressure and can be propelled with considerable force.



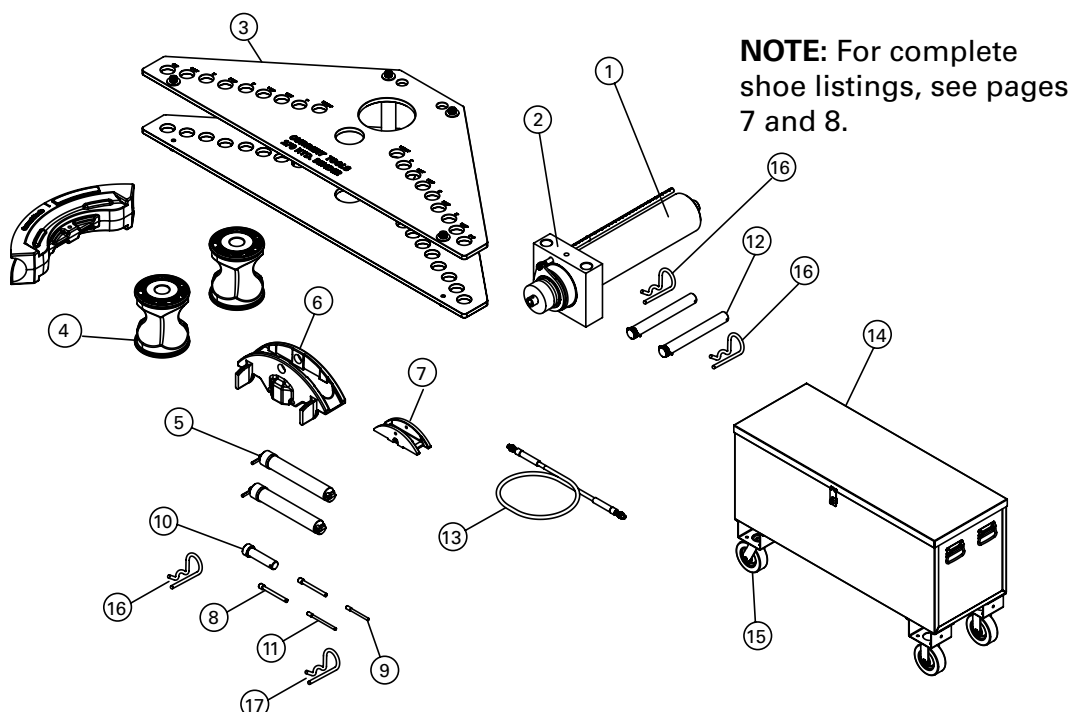
IMPORTANT SAFETY INFORMATION – continued

- ⚠ WARNING** ALWAYS read and understand the safety and operating instructions supplied with your hydraulic pump
- ⚠ WARNING** ALWAYS keep children away. All visitors should remain a safe distance from work area.
- ⚠ CAUTION** The bender and some accessories exceed 50 lbs. and will require more than one person to lift, transport and assemble.
- ⚠ CAUTION** Only use the bender for its intended purpose as specified in this manual.
- ⚠ CAUTION** ALWAYS maintain bender with care. Keep bender clean for best and safest performance.
- ⚠ CAUTION** CHECK all hose connections prior to use and ensure they are properly connected. Improper connections may not allow the hydraulic cylinder to retract after the bend is complete.

SPECIFICATIONS – 270 AND 271 CONDUIT BENDERS

Model Number	270	271
Storage Box Size	50"W x 17"D x 20"H	50"W x 17"D x 20"H
Weight (w/Storage Box)	423	456
Bending Capacity	1¼" thru 4" Rigid conduit and schedule 40 pipe 1¼" thru 4" PVC coated Rigid conduit with optional shoe group	1¼" thru 5" Rigid conduit and schedule 40 pipe 1¼" thru 4" PVC coated Rigid conduit with optional shoe group

MAJOR COMPONENTS – BENDER

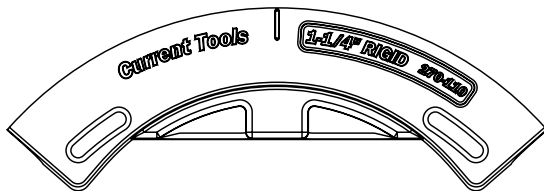


MAJOR COMPONENTS – PARTS LIST

ITEM	CATALOG	DESCRIPTION	QTY.
1	270-124	CYLINDER — HYDRAULIC (INCLUDES ITEM #2)	1
2	270-109	CYLINDER MOUNTING BLOCK	1
3	270-125	FRAME ASSEMBLY	1
4	270-117	SUPPORT — RIGID CONDUIT	2
5	270-123	PIN — CONDUIT SUPPORT	2
6	270-118	ADAPTER — SHOE (LARGE)	1
7	270-119	ADAPTER — SHOE (SMALL)	1
8	270-105	PIN — SHOE ADAPTER (LARGE)	2
9	270-104	PIN — SHOE ADAPTER (SMALL)	1
10	270-103	PIN — SHOE (LARGE)	1
11	270-106	PIN — SHOE (SMALL)	1
12	270-121	PIN — CYLINDER BLOCK	2
13	291	HOSE — HYDRAULIC	1
14	106	BOX, METAL STORAGE	1
15	506	CASTER SET — 2 RIGID, 2 SWIVEL	1
16	254-006	CLIP — SPRING	3
17	270-007	CLIP — SPRING	1

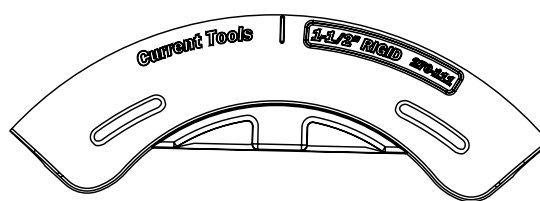
MAJOR COMPONENTS – RIGID SHOES

1 1/4" SHOE – RIGID



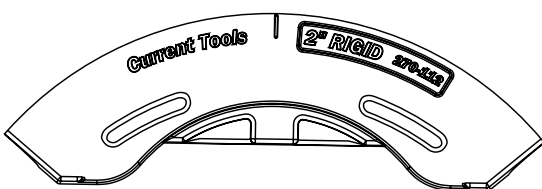
PART #270-110

1 1/2" SHOE – RIGID



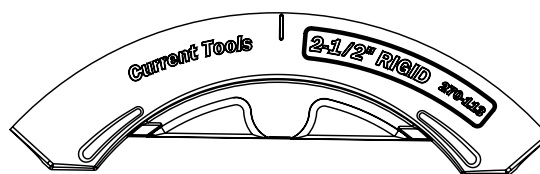
PART #270-111

2" SHOE – RIGID



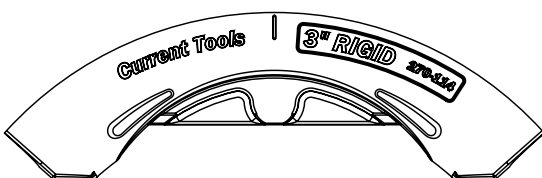
PART #270-112

2 1/2" SHOE – RIGID



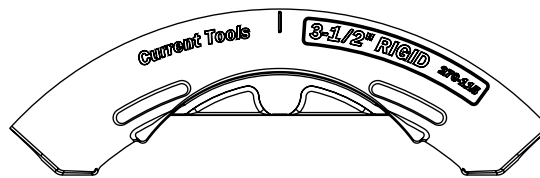
PART #270-113

3" SHOE – RIGID



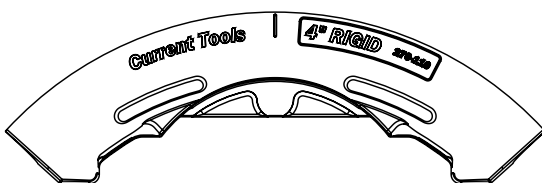
PART #270-114

3 1/2" SHOE – RIGID



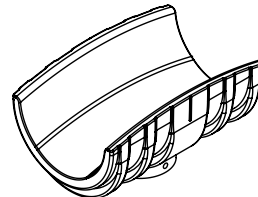
PART #270-115

4" SHOE – RIGID



PART #270-116

5" SEGMENT SHOE – RIGID



PART #270-120

SHOE GROUPS – RIGID CONDUIT

PART NUMBER	DESCRIPTION
270-150	COMPLETE SHOE GROUP FOR 1-1/4" THRU 4" RIGID CONDUIT — INCLUDES CONDUIT SUPPORTS
270-151	COMPLETE SHOE GROUP FOR 1-1/4" THRU 5" RIGID CONDUIT — INCLUDES CONDUIT SUPPORTS AND 5" SEGMENT BENDING SHOE

CONDUIT CENTERLINE BENDING RADII – RIGID

SHOE SIZE	1 1/4"	1 1/2"	2"	2 1/2"	3"	3 1/2"	4"	5"
BENDING RADIUS (INCHES)	7 1/4"	8 1/4"	9 1/2"	12 1/2"	15"	17 1/2"	20"	25"



OPTIONAL SHOES FOR PVC COATED RIGID

1 1/4" SHOE – PVC COATED RIGID



PART #270-210

1 1/2" SHOE – PVC COATED RIGID



PART #270-211

2" SHOE – PVC COATED RIGID



PART #270-212

2 1/2" SHOE – PVC COATED RIGID



PART #270-213

3" SHOE – PVC COATED RIGID



PART #270-214

3 1/2" SHOE – PVC COATED RIGID



PART #270-215

4" SHOE – PVC COATED RIGID



PART #270-216

CONDUIT SUPPORT – PVC COATED RIGID



PART #270-217



SHOE GROUPS – PVC COATED RIGID CONDUIT

PART NUMBER	DESCRIPTION
270-250	SEVEN PIECE SHOE GROUP FOR 1-1/4", 1-1/2", 2", 3" AND 4" PVC COATED RIGID CONDUIT (INCLUDES CONDUIT SUPPORTS)
270-251	COMPLETE SHOE GROUP FOR 1-1/4", 1-1/2", 2", 2-1/2", 3", 3-1/2" AND 4" PVC COATED RIGID CONDUIT (INCLUDES CONDUIT SUPPORTS)



CONDUIT CENTERLINE BENDING RADII – PVC COATED RIGID

SHOE SIZE	1 1/4"	1 1/2"	2"	2 1/2"	3"	3 1/2"	4"
BENDING RADIUS (INCHES)	7 1/4"	8 1/4"	9 1/2"	12 1/2"	15"	17 1/2"	20"

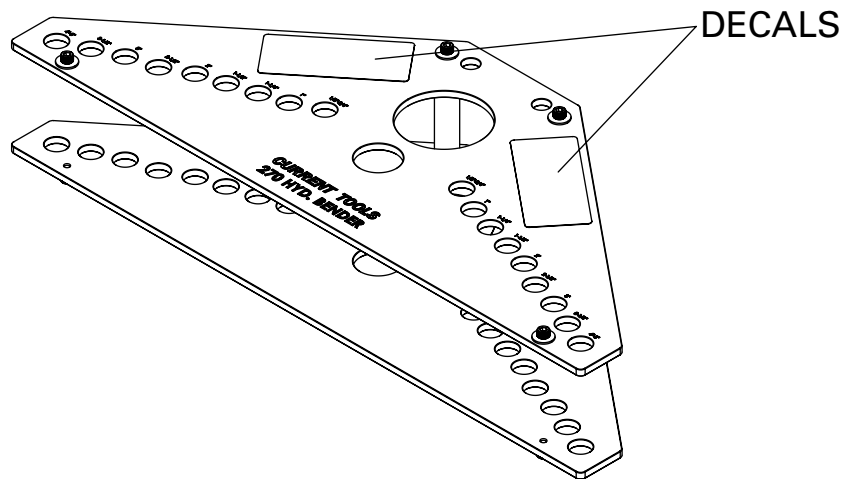


ASSEMBLY & OPERATING INSTRUCTIONS – 270/271 CONDUIT BENDER

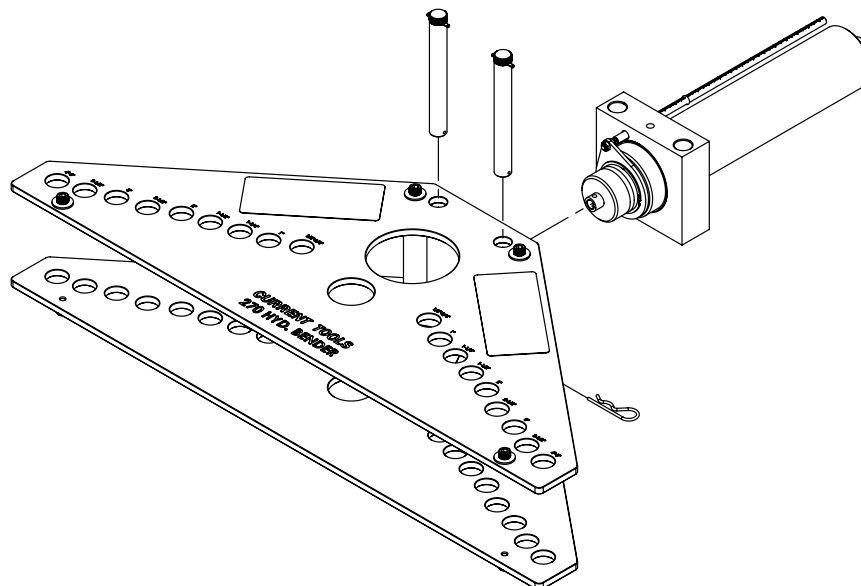
FOR OPERATING ON THE FLOOR

BENDER ASSEMBLY

1. Locate the frame assembly and place it on the floor with the decals facing up.



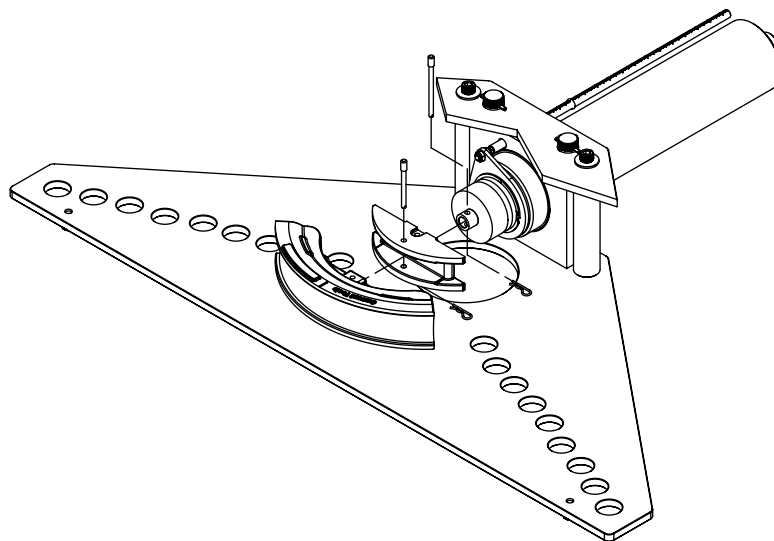
2. Place the hydraulic cylinder with the cylinder mounting block between the frame sides. Insert the two cylinder block pins through the frame sides and cylinder block and secure with spring clips. (Part #254-006).



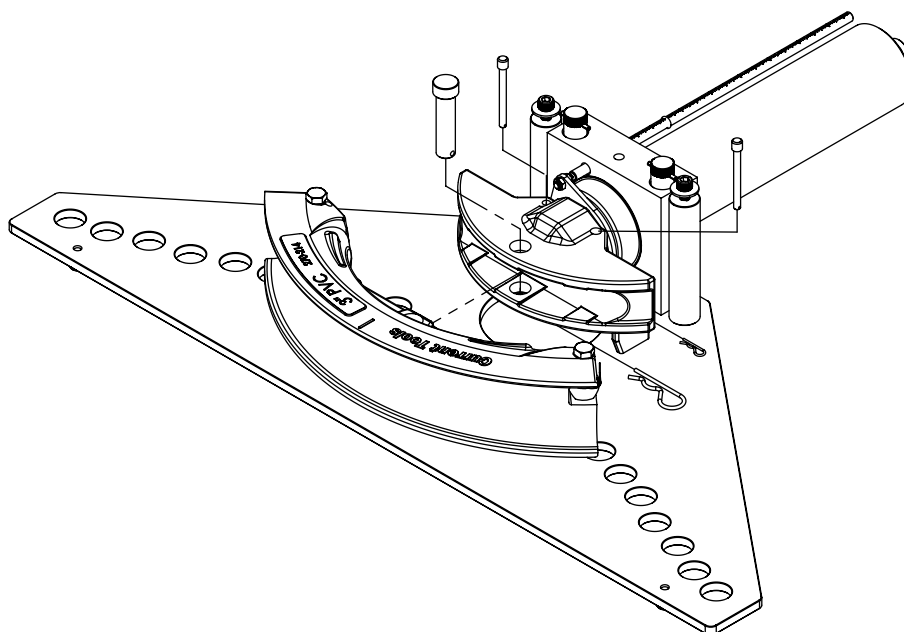


3. Pin the correct shoe adapter (large or small) onto the hydraulic cylinder as noted below:

- For bending 2" and smaller conduit, pin the small shoe adapter (Part #270-119) to the hydraulic cylinder using the small shoe adapter pin (Part #270-104) and secure the pin with spring clip (Part #270-007). Attach the shoe to the shoe adapter with the small shoe pin (Part #270-106).



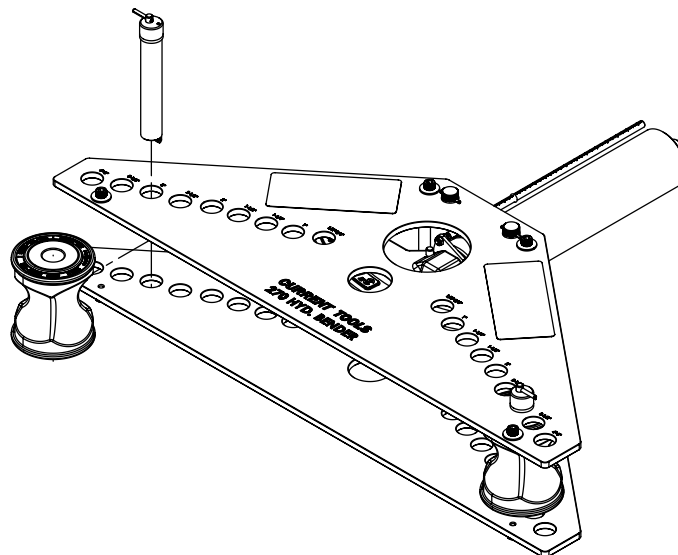
- For bending 2 1/2" and larger conduit, pin the large shoe adapter (Part #270-118) to the hydraulic cylinder using the two large shoe adapter pins (Part #270-105) and secure the pins with spring clips (Part #254-006). Attach the shoe to the shoe adapter with the large shoe pin (Part #270-103) and secure with spring clip (Part #254-006).



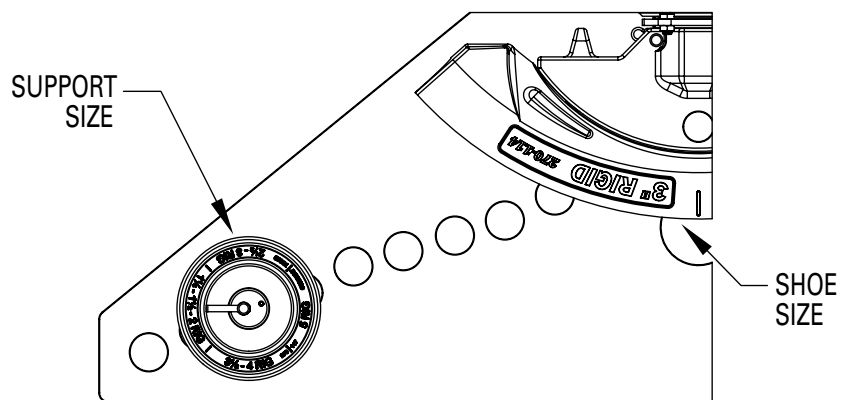


ASSEMBLY & OPERATING INSTRUCTIONS – 270/271 CONDUIT BENDER — *CONTINUED*

4. Place the conduit supports (Part #270-117) in between the frame pieces and line up the mounting holes with the correct hole position on the frame for the size conduit you will be bending. Insert the conduit support pins (Part #270-123) through the frame sides and conduit supports. Secure the pins by turning the locking pin over the ball on the end of the pin.

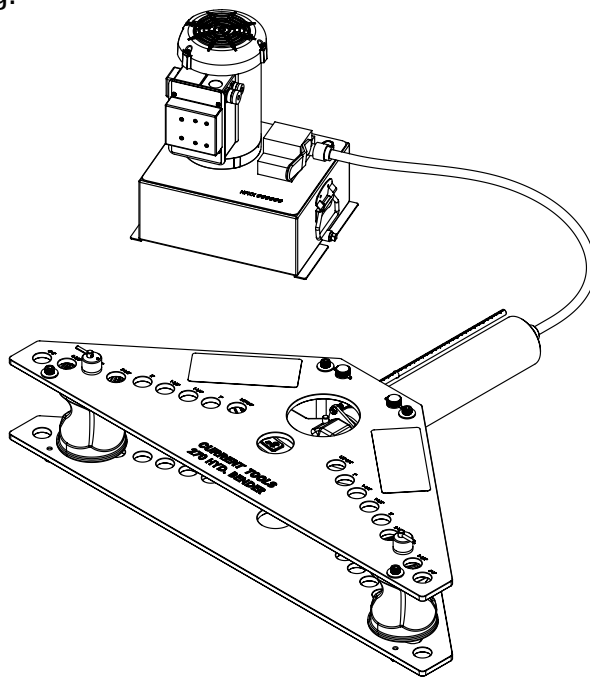


5. Turn the conduit support so that the correct side for the size conduit you are bending is facing the hydraulic cylinder.

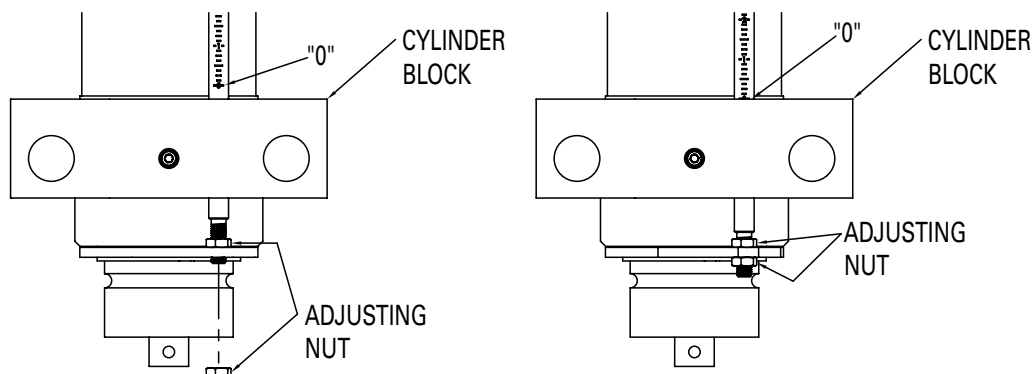




6. Connect the hydraulic hose (Part #291) to the pump and hydraulic cylinder. Rotate the pump valve lever to the open position to ensure the cylinder is fully retracted. NOTE: Make sure all fittings are clean, free of debris and completely tightened prior to bending.



7. Adjust the gauge rod on the cylinder such that gauge reads zero when the cylinder is fully retracted. NOTE: To adjust gauge rod, loosen gauge rod adjusting nuts and adjust rod such that zero (Ø) is flush with the top of the cylinder block.



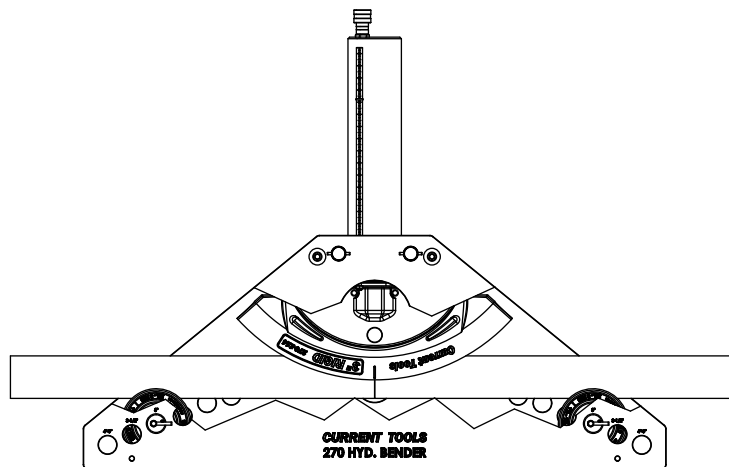


BENDING CONDUIT

1. Refer to the “BENDING INFORMATION AND CHARTS” section of this manual to determine bending mark locations for the bend you will be making. Mark the conduit accordingly.

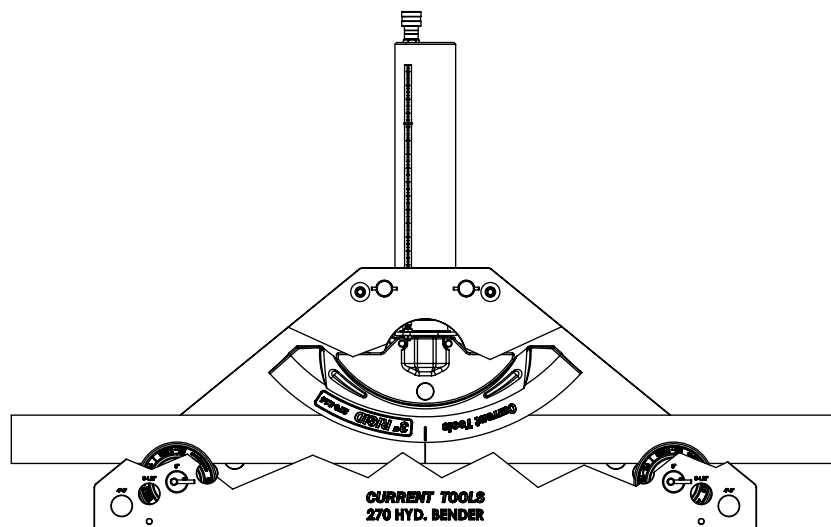


2. Insert the conduit into the bender frame between the conduit supports and bending shoe. Align the bending mark you made in step 1 with the center mark on the bending shoe.



ALIGN

3. Rotate the pump valve lever to the closed position and activate the hydraulic pump until the shoe contacts the conduit and the conduit is snug against the conduit supports. DO NOT BEGIN BEND.



SNUG

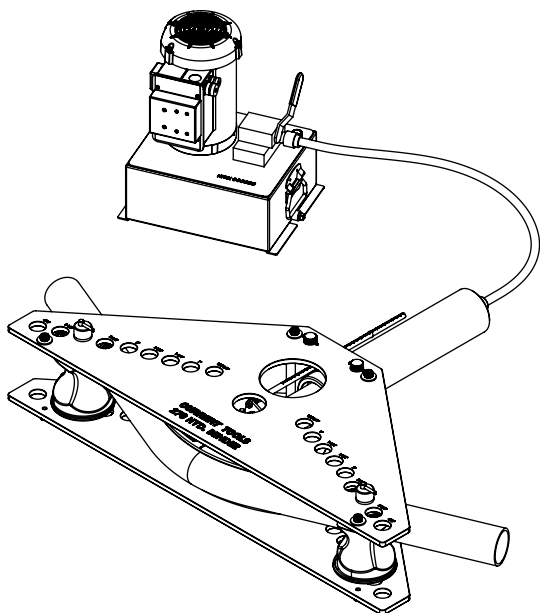


ASSEMBLY & OPERATING INSTRUCTIONS – 270/271 CONDUIT BENDER — *CONTINUED*

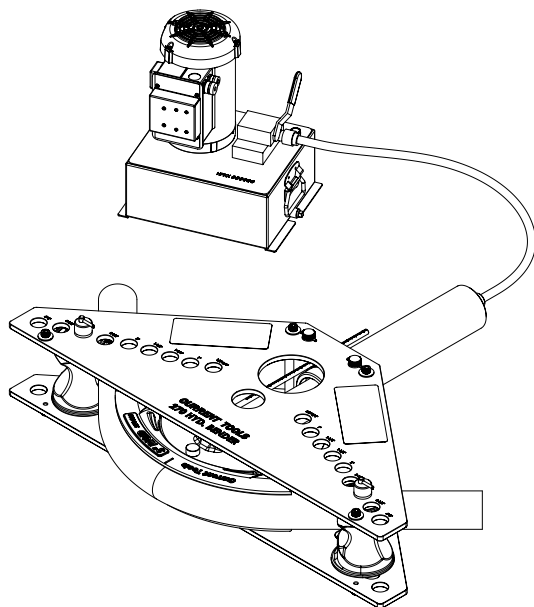
4. Determine the amount of cylinder travel for the size, type and degree of bend by referring to the CYLINDER TRAVEL AND BENDER CALIBRATION information on page 16.

5. Activate the hydraulic pump to begin the bend.

NOTE: DO NOT overextend the hydraulic cylinder during operation. This will allow hydraulic fluid to escape the cylinder and may cause a hazardous condition.



6. When the desired degree of bend is complete, rotate the pump valve lever to the open position to release the hydraulic pressure and the hydraulic cylinder will retract.



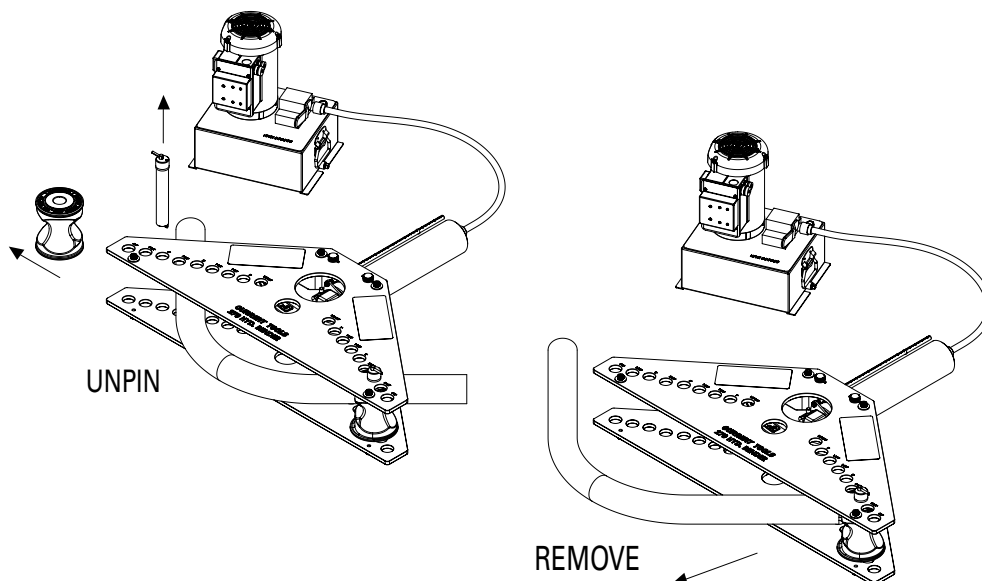


BENDING CONDUIT

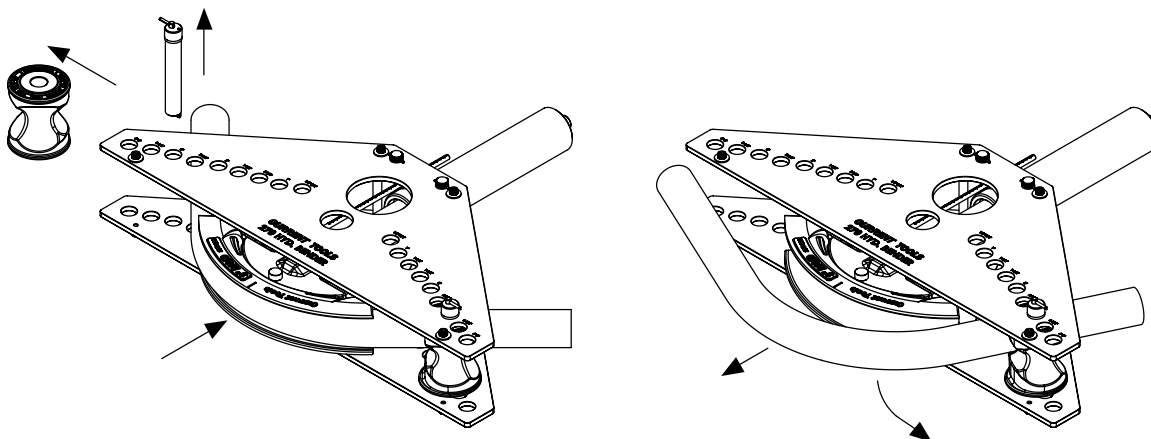
7. If necessary, move the conduit to the next bending position. Repeat steps 5 and 6 until the bend is complete.

NOTE: For an offset bend, rotate the conduit 180° and make the second bend. For a three bend saddle, rotate the conduit 180° before making the second and third bends. For a four bend saddle, rotate the conduit 180° before making the second and fourth bends.

8. Rotate the pump valve lever to the open position to retract the cylinder. Remove the conduit from the bender.



NOTE: To facilitate easy removal of bent conduit, slightly retract the cylinder and remove one conduit support from the bending frame. Then operate the pump to advance the cylinder until the conduit releases from the shoe.

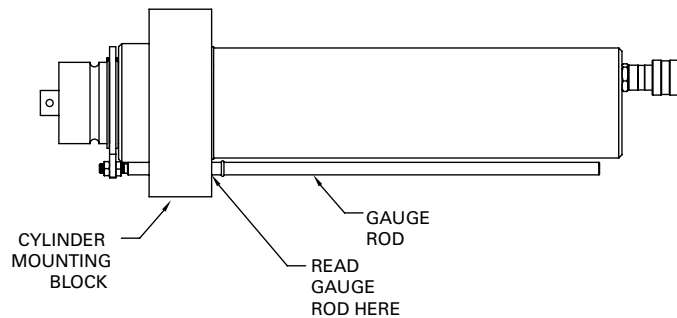




CYLINDER TRAVEL AND BENDER CALIBRATION

NOTE: Read the gauge rod at the edge of the cylinder mounting block. Gauge rod should read zero (Ø) when cylinder is fully retracted.

TO ADJUST GAUGE ROD, loosen the gauge rod adjusting nuts and adjust rod so that zero (Ø) is flush with the top of the cylinder block.



CYLINDER TRAVEL (APPROXIMATE)

DEGREE OF BEND	CONDUIT SIZE						
	1-1/4"	1-1/2"	2"	2-1/2"	3"	3-1/2"	4"
10°	1-3/4"	2-1/16"	2-1/8"	2-5/16"	2-5/8"	2-1/4"	2-3/4"
15°	2-1/8"	2-1/2"	2-5/8"	3"	3-5/16"	3-5/8"	3-5/8"
30°	3-1/4"	3-13/16"	4-1/4"	4-3/4"	5-5/16"	5-7/8"	6-1/16"
45°	4-1/4"	5-3/16"	5-11/16"	6-3/8"	7-3/16"	7-7/8"	8-1/4"
60°	5-3/16"	6-7/16"	7-1/8"	7-7/8"	8-13/16"	9-3/4"	10-1/4"
90°	6-15/16"	8-13/16"	10"	10-11/16"	11-7/8"	12-15/16"	13-11/16"

NOTE: To use the cylinder travel table, locate the conduit size in the second row and the desired degree of bend in the first column. Where that row and column intersects gives you the approximate cylinder travel to achieve your desired degree of bend.

90° BENDING INFORMATION AND TABLES

NOTE: CurrentTools Model #270 bender is designed to make up to 90° bends with one extension of the hydraulic cylinder. The Greenlee®* Model #884/885 hydraulic bender major components will fit the CurrentTools Model #270 hydraulic bender.

To locate bending marks for a 90° bend with a desired stub length.

1. Determine the desired stub length
NOTE: Check corresponding table on page 18 for the size conduit being bent and ensure the desired stub length is greater than the "minimum stub length" shown in the table.

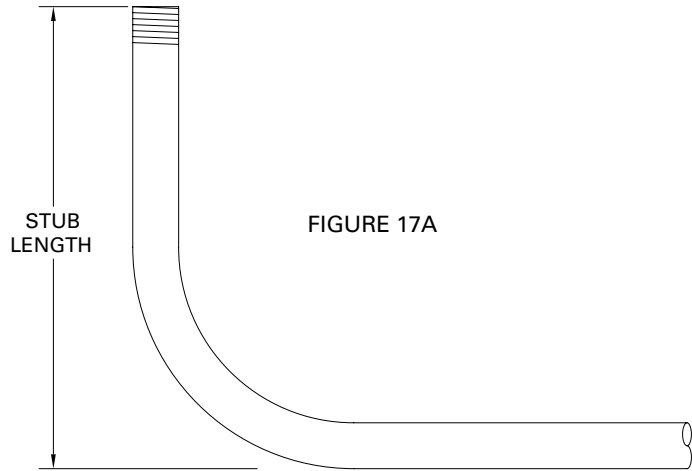


FIGURE 17A

2. From the end of the conduit, measure and mark the desired stub length on the conduit (stub length mark). See Figure 17B.
3. Subtract "deduct length" from the stub length mark and make a second mark (bending mark). See Figure 17B.

NOTE: Check corresponding table on page 18 for the deduct length of the size conduit you are bending.

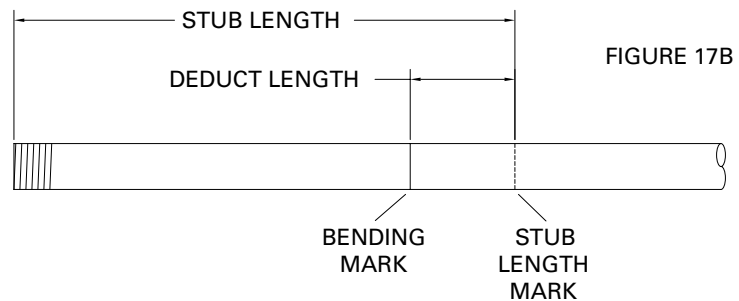


FIGURE 17B

4. Insert the conduit into the bender frame between the conduit supports and bending shoe. Align the bending mark made in Step 3 with the center mark on the bending shoe. Proceed with the bend as shown in the assembly and operating section of this manual.

NOTE: Refer to the cylinder travel table on page 16 to determine approximate cylinder travel to achieve the desired bend degree.

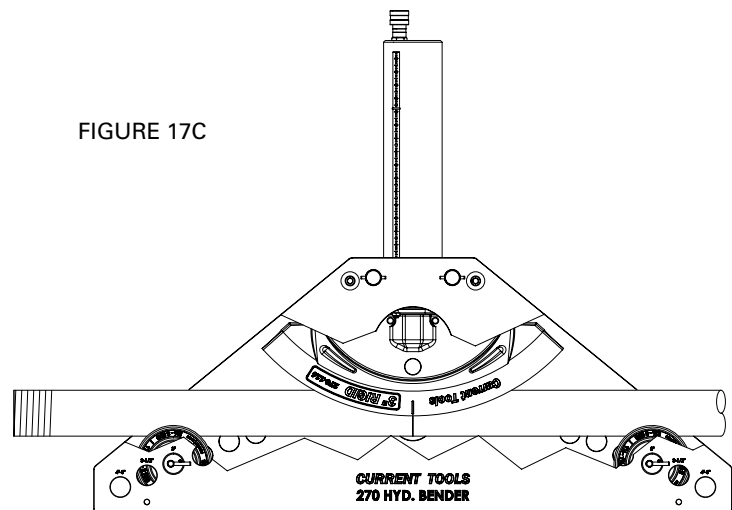


FIGURE 17C

ALIGN

* Greenlee® is a registered trademark of Emerson Electric.

MINIMUM STUB LENGTH TABLE

Conduit Size	Deduct Length	Minimum Stub Length
1 - 1/4"	2 - 3/8"	15 - 13/16"
1 - 1/2"	2 - 3/4"	18 - 3/4"
2"	3 - 1/4"	21-5/8"
2 - 1/2"	4 - 1/8"	25"
3"	5"	28 - 3/16"
3 - 1/2"	5 - 3/4"	31"
4"	6 - 9/16"	33 - 7/8"

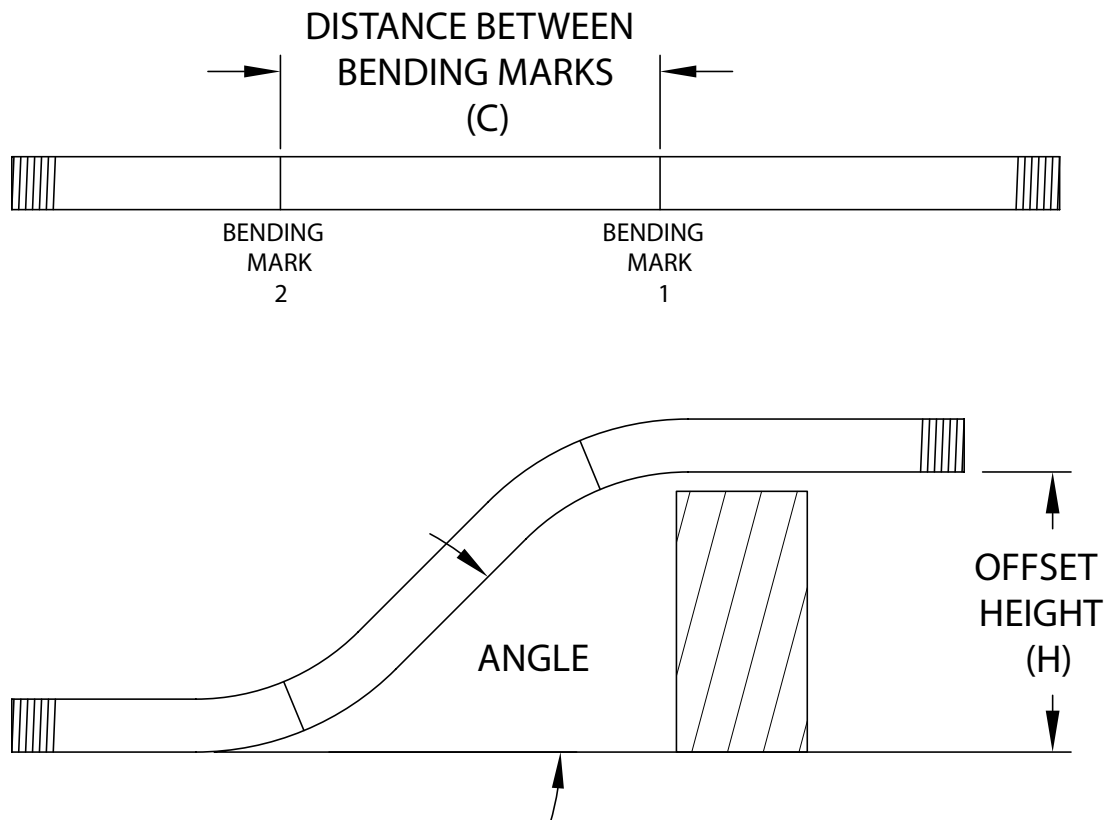
To locate bending marks for an offset bend.

NOTE: Offset bends are used to route conduit around an obstacle. Two bends are necessary to make an offset. The height and angle of the offset must be determined prior to making the bend, and the distance between the two bends is the center-to-center distance.

1. Measure the height of the obstacle you are working away from.
2. Determine the offset angles for the bends. Common offset angles are noted in the "common calculated offsets" table on pg. 20.
3. Calculate the center-to-center distance for both bends (see the "center-to-center calculations" table on pg. 20).

NOTE: See table "center-to-center calculations with shrinkage" to calculate shrink if you are working towards an obstacle.

4. Mark the conduit at the two center-to-center locations determined in step 3.
5. Bend the conduit as described in the Assembly and Operating Instructions section of this manual.



Common Calculated Offsets

OFFSET ANGLE	OFFSET IN INCHES	MAX. CONDUIT SIZE	CENTER-TO-CENTER DISTANCE
15 DEG.	4	1-1/2"	15 - 7/16"
	6	3"	23 - 3/16"
	8	4"	30 - 7/8"
	10	4"	38 - 5/8"
	12	4"	46 - 5/16"
	14	4"	54 - 1/16"
	16	4"	61 - 3/4"
	18	4"	69 - 1/2"
	20	4"	77 - 3/16"
	22	4"	84 - 15/16"
30 DEG.	8	1 - 1/2"	16"
	10	2"	20"
	12	3"	24"
	14	3 - 1/2"	28"
	16	4"	32"
	18	4"	36"
	20	4"	40"
	22	4"	44"
	24	4"	48"
	26	4"	52"
45 DEG.	10	1 - 1/4"	14 - 1/8"
	12	1 - 1/2"	16 - 15/16"
	14	2"	19 - 3/4"
	16	2 - 1/2"	22 - 9/16"
	18	2 - 1/2"	25 - 3/8"
	20	3"	28 - 3/16"
	22	3 - 1/2"	31"
	24	4"	33 - 13/16"
	26	4"	36 - 11/16"
	28	4"	39 - 1/2"

CENTER-TO-CENTER CALCULATIONS

Multiply the measured height of the obstacle by the correct multiplier in the table below to find your center-to-center distance for your bend.

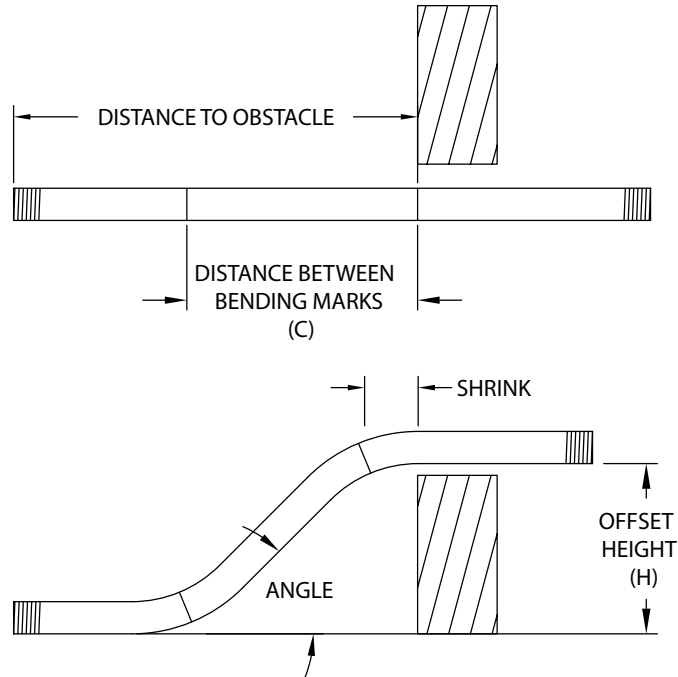
OFFSET ANGLE	MULTIPLIER
15 DEG.	3.86
30 DEG.	2
45 DEG.	1.41
60 DEG.	1.15

Example: — 8" offset (obstacle is 8" high)
 with a 30° offset angle
 — Multiplier for 30° angle is 2
 — $8 \times 2 = 16$ " center-to-center

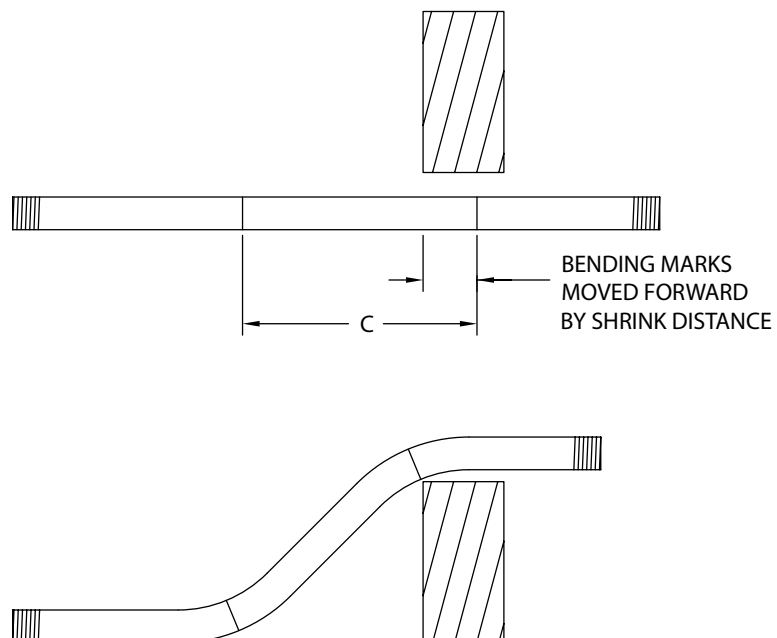
CONDUIT “SHRINK”

When making offsets as close as possible to the obstacle, it is necessary to figure in “shrinkage” when approaching the obstacle. Page 21 & 22 illustrates how to figure shrinkage in those circumstances.

To compensate for shrinkage when approaching an obstacle, both bends need to be adjusted forward. The example below (Figure 21A) illustrates an offset bend without shrinkage figured in.



The example below (Figure 21B) illustrates the example above with the shrinkage factor figured in. Instructions on how to figure the shrinkage can be found page 22.



CENTER-TO-CENTER CALCULATIONS WITH SHRINKAGE

Use the table below to determine the center-to-center distance and shrinkage per inch of offset for a particular offset bend.

OFFSET ANGLE	MULTIPLIER	SHRINK PER INCH OF OFFSET HEIGHT
10 DEG.	5.76	1/16"
15 DEG.	3.86	1/8"
30 DEG.	2	1/4"
45 DEG.	1.41	3/8"
60 DEG.	1.15	1/2"

Example on how to use the above table:

1. Measure the height of the obstacle you are working towards. We will use 8" in this example.
2. Determine the offset angle you will use. In this example we will use 45 degrees.
3. Find the multiplier in the chart above for the offset angle you will be using. The multiplier for 45 degrees is 1.41.

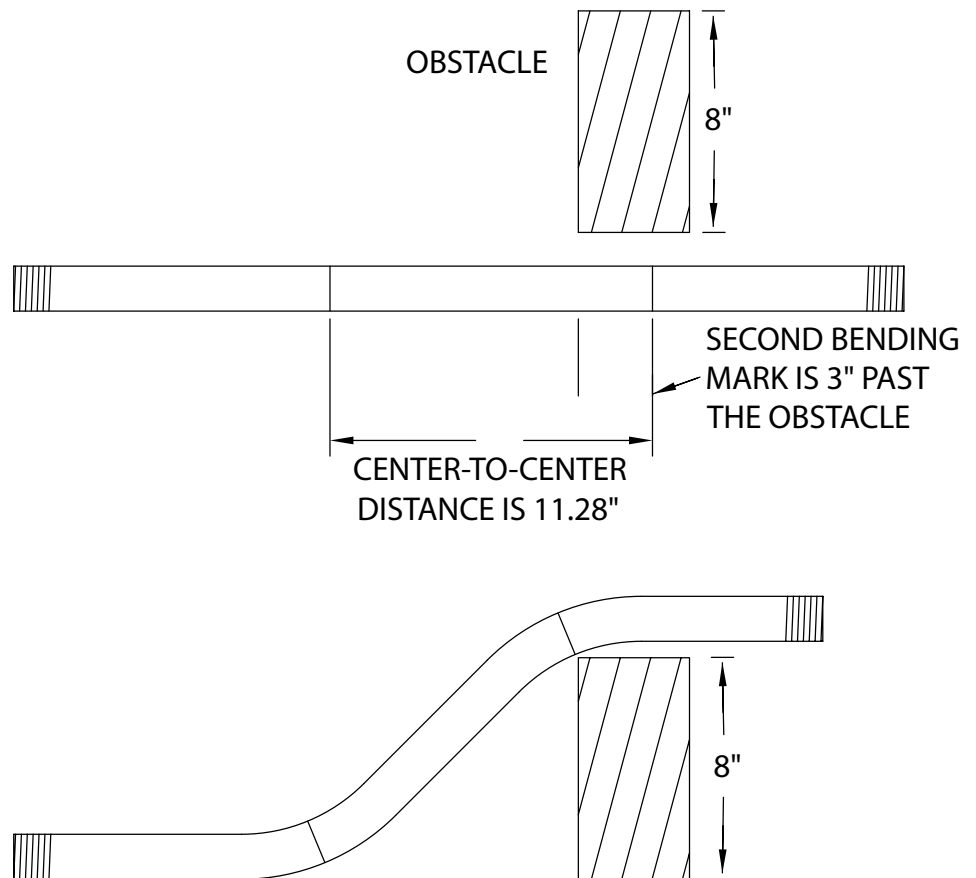
4. Multiply the offset height (8") by the multiplier (1.41) to get your center-to-center distance ($8 \times 1.41 = 11.28$).

5. Find the "SHRINK PER INCH OF OFFSET HEIGHT" number for your chosen offset angle in the chart above. This is 3/8" for our example.

6. Multiply the shrink per inch number (3/8) by the measured height of your offset (8").
 $8 \times 3/8 = 3"$.

7. Now mark the conduit by placing the second bending mark 3" past the obstacle. Measure back towards the starting point and put the first bending mark 11.28 inches before the second bending mark.

8. Bend the conduit as described in the assembly and operating instructions section of this manual.



SEGMENT BENDS LAYOUT INFORMATION

For large radius bends, a series of smaller bends (called segment bends) spaced closely together are required. The following pages offer instructions on how to layout and bend segment bends. Mounting the bender on the Current Tools Model #280 Bending Table can help in this process.

The information needed for any given segment bend includes:

- 1) Size of the conduit being bent
- 2) Length of the stub required
- 3) Degree of bend
- 4) Bend radius needed

Example: 3" conduit, 48" stub, 90° bend, 50" radius

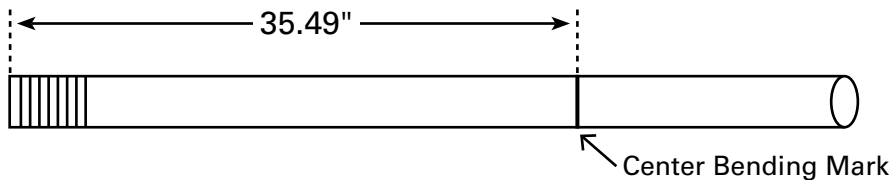
1. Determine the length of conduit needed for the bend by multiplying the formula .01744 with the degree of bend number and the radius number.

$$90 \text{ (degree of bend)} \times 50 \text{ (radius)} \times .01744 = 78.48$$

In our example, total conduit length needed = 78.48"

2. Next, determine the center of the bend and mark the conduit in that spot. To determine the center of the bend, measure and mark the length of the stub (48"). Subtract the radius of the bend (50) and 1/2 of the actual O.D. of the conduit (1.75). Add 1/2 of the bend length ($78.48/2 = 39.24$).

$$\text{CENTER Mark: } 48 - 50 - 1.75 + 39.24 = 35.49"$$



3. Determine the number of bends needed to achieve the desired radius by referring to the table below.

NOTE: Table numbers are suggestions only, and using more bends will produce a smoother bend.

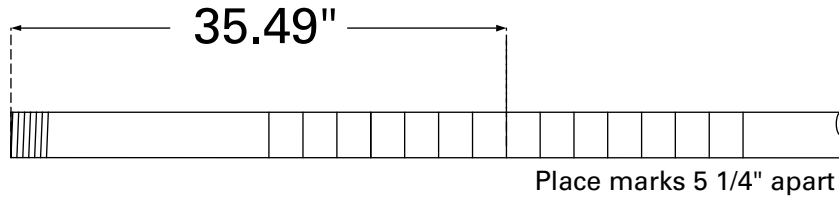
	DESIRED RADIUS					
	4" TO 10"	10" TO 20"	20" TO 30"	30" TO 40"	40" TO 50"	50" TO 60"
Minimum Bends	2	3	5	9	13	19
Maximum Bends	3	5	9	13	19	25

Example: 50" Radius = 15 Bends

4. Divide the length of the bend (78.48") by the number of bends to calculate the distance between each bend and round to the nearest fraction or whole number.

Example: $78.48 \div 15 = 5.23$ (nearest common fraction is $5 \frac{1}{4}$ ")

5. Starting at the center bending mark determined in Step 2 (35.49"), mark the conduit on both sides of the center mark using the figure determined in Step 4 ($5 \frac{1}{4}$ ").

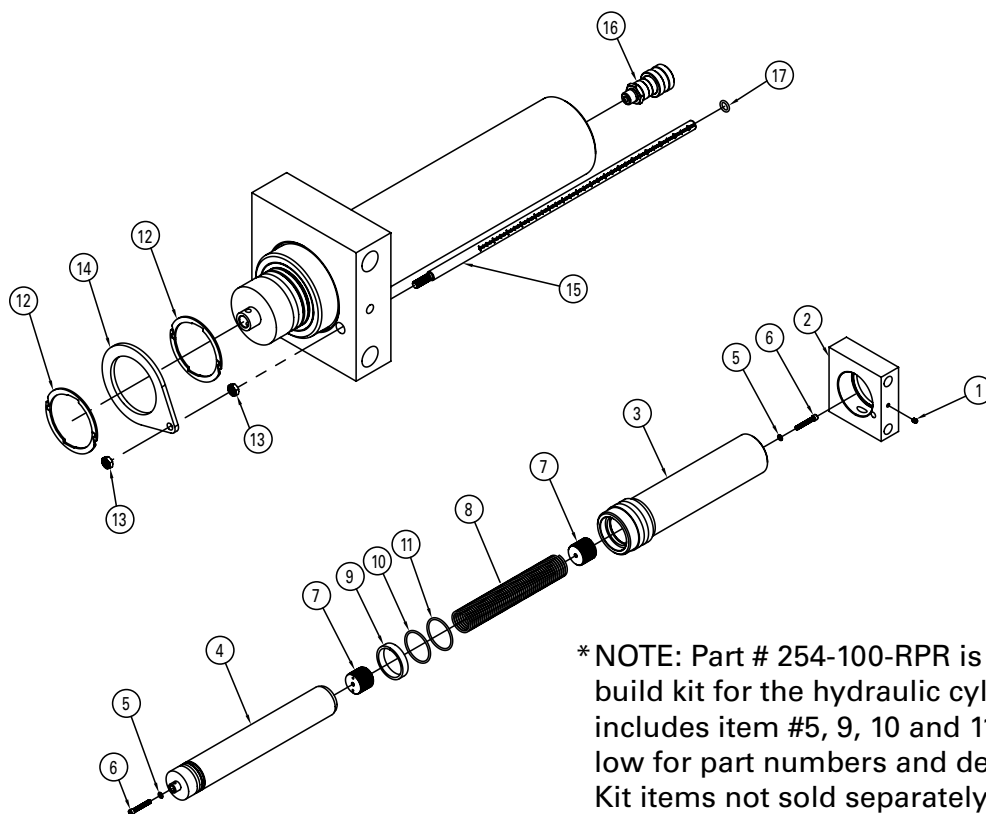


6. Divide the total angle of the desired bend by the total number of bends determined in step 3. This will determine the angle to which each segment should be bent.

Example: $90^\circ \text{ bend} \div 15 \text{ bends} = 6^\circ \text{ per segment}$.

7. Bend the conduit at each segment to the degree determined in step 6, ensuring to account for springback.

EXPLODED VIEW – HYDRAULIC CYLINDER



* NOTE: Part # 254-100-RPR is the re-build kit for the hydraulic cylinder and includes item #5, 9, 10 and 11. See below for part numbers and descriptions. Kit items not sold separately.

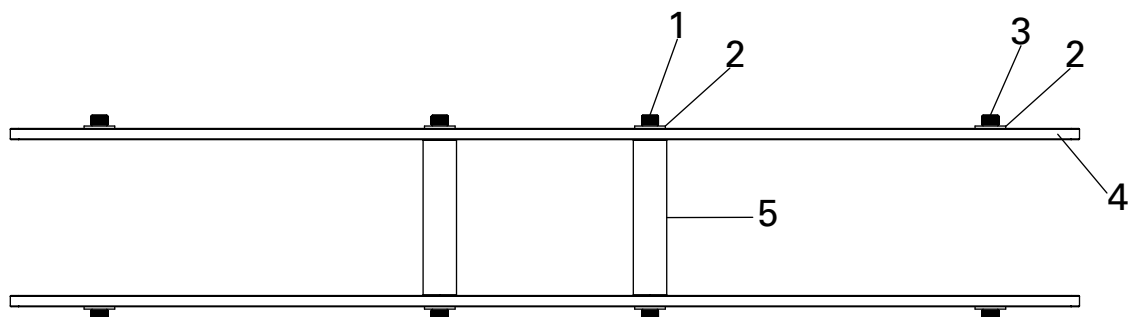
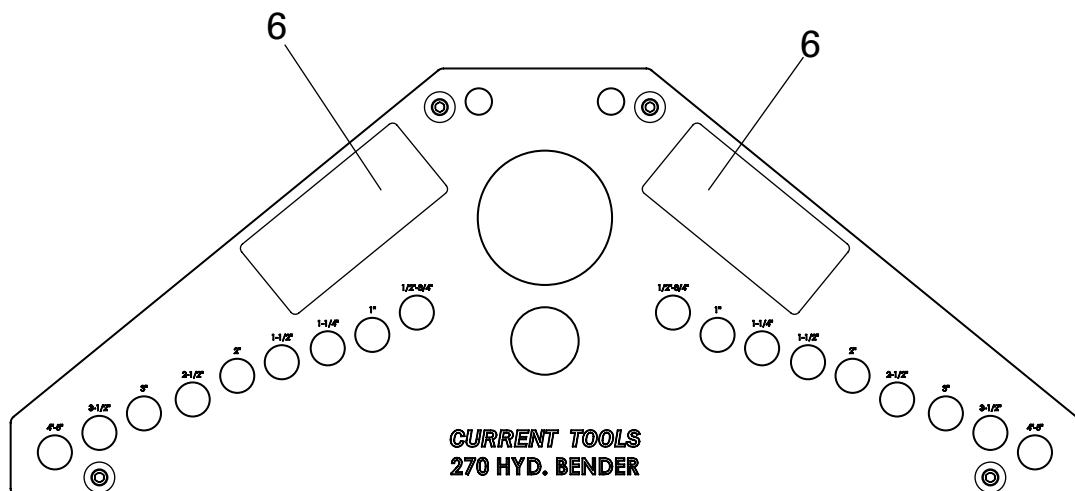
PARTS LIST – HYDRAULIC CYLINDER

ITEM #	PART #	QTY.	DESCRIPTION
1	254-011	1	SCREW-SET, 7/16-14 x 1/2"
2	270-109	1	CYLINDER BLOCK
3	254-401	1	BARREL
4	254-402	1	ROD
5*	254-404	2	GASKET (COPPER)
6	254-405	2	SCREW-SKT. HD. CAP, 3/8-16 X 2 3/4"
7	254-406	2	SPRING RETAINER
8	254-407	1	EXTENSION SPRING
9*	254-408	1	BUSHING
10*	254-409	1	BACK-UP RING
11*	254-410	1	O-RING
12	254-010	2	RING-RETAINING, EXTERNAL INTERLOCKING
13	254-009	2	NUT-HEX, THIN 3/8-24
14	254-188	1	PLATE-GAUGE ROD
15	254-189	1	ROD-GAUGE
16	291-2A	1	FITTING-HYDRAULIC, FEMALE
17	254-007	1	O-RING, RUBBER

REBUILD KIT – HYDRAULIC CYLINDER

ITEM #	PART #	QTY.	DESCRIPTION
5	254-404	2	GASKET (COPPER)
9	254-408	1	BUSHING
10	254-409	1	BACK-UP RING
11	254-410	1	O-RING

ILLUSTRATION AND PARTS LIST — FRAME ASSEMBLY



PARTS LIST — FRAME ASSEMBLY

ITEM #	PART #	QTY.	DESCRIPTION
1	270-005	4	SCREW — SOCKET HD CAP, 1/2-20 × 1"
2	451-25	8	WASHER — FLAT, 1/2 USS
3	270-004	4	SCREW — SOCKET HD CAP, 1/2-13 × 1/2"
4	270-108	2	FRAME
5	270-107	2	PIN — FRAME
6	270-DECAL-FRAME	1	DECAL SET — FRAME