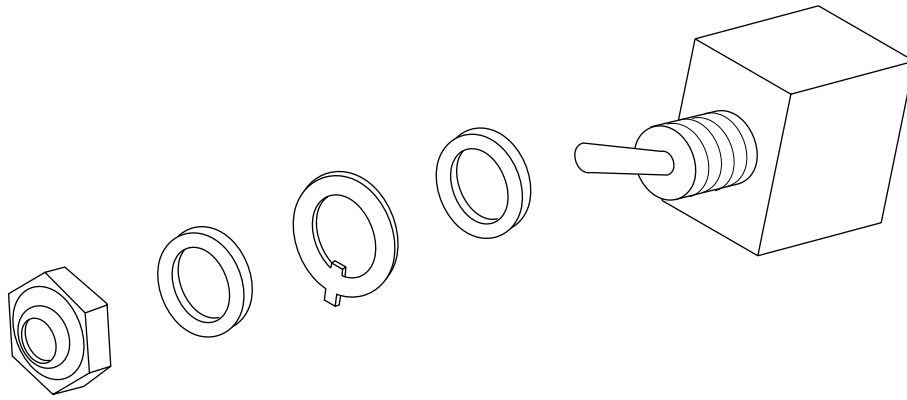


SERVICE BULLETIN



500 7974.3

Direction Switch Upgrade Kit

for the 854 Bender

with Serial Code ABT



Read and understand all of the instructions and safety information in this manual before operating or servicing this tool.

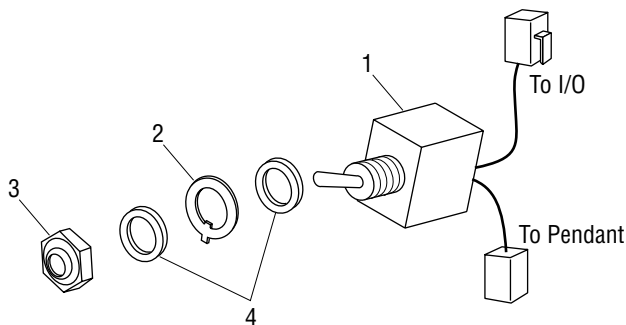
Description

The Direction Switch Upgrade Kit for the 854 bender with serial code ABT allows a user to change from the plastic rotary type direction selector switch (500 3052.3) to a new metal toggle direction selector switch.

If your 854 bender has a serial code of ADT, please return this component and exchange it for a Switch with Harness (500 7904.2), which is the proper repair part for the ADT series bender.

All the parts needed to upgrade the toggle switch are included in this kit:

Key	Part No.	Description	Qty.
1	500 7973.5	Direction Switch	1
2	918 6890.4	Locking Ring	1
3	918 6983.8	Toggle Boot, 1/2, Black	1
4	905 5051.0	Lock Washer	2



Installation Instructions

	⚠ WARNING
	<p>Wear eye protection when performing this procedure.</p> <p>Failure to wear eye protection can result in serious eye injury from flying debris.</p>

Required Tools

- 5/16" socket wrench
- Slot screwdriver with narrow tip (3/32")
- 9/16" open-ended wrench
- 5/8" open wrench
- 15/32" metal drill bit
- 1/8" metal drill bit
- Hand drill

Procedure

1. Turn off and unplug the tool.
2. Remove the top rounded shroud by removing four 5/16" hex head sheet metal screws.
3. Unplug selector switch from I/O board. Unplug pendant switch from selector switch board.
4. Use screwdriver to remove setscrew in selector switch knob. Remove and discard knob.
5. Use 9/16" wrench to remove nut on shaft of selector switch. Remove and discard switch assembly.
6. Drill out switch mounting hole to 15/32".
7. Using the template provided, mark location and drill 1/8" hole. Be sure that this small hole is to the right of the 15/32" mounting hole so that the switch will give the proper bend and unload directions.

Note: Although the switch would be more prone to rotating, the assembly can be made without the 1/8" hole and locking ring. Be sure to align the notch in the switch to the right to get proper bend and unload directions from the switch.
8. Connect direction switch to I/O board. Connect direction switch to pendant.
9. Place a lock washer over the switch's mounting shaft.
10. Inside bender, insert direction switch through hole.
11. On the outside, stack the locking ring (tab facing bender), lock washer, and toggle boot onto the switch's mounting shaft.
12. Rotate the switch so that the tab of the lock ring is aligned with the 1/8" hole.
13. Tighten the toggle boot with 5/8" wrench.
14. Replace top rounded shroud and hand tighten four 5/16" hex head sheet metal screws.

Template for Drilling

