



BENDER

90° STUB LENGTHS

USE ARROW AS YOUR BENCHMARK.

TOOL TAKE-UP TO ARROW **6"**

NOTE: on floor bends: a vertical handle indicates a 30° bend.

GUIDE FOR OFFSETS

OFFSET DEPTH	DISTANCE BETWEEN BENDS	ANGLE OF BENDS	WIREMOLD CONDUIT SHORTENS
Inches [mm]	Inches [mm]		
3/8" [9.5mm]	2 1/4" [57mm]	10°	—
3/4" [19.1mm]	4 1/2" [114mm]	10°	—
1" [25mm]	6" [152mm]	10°	1/16"
2" [51mm]	5 1/4" [133mm]	22.5°	3/8"
3" [76mm]	6" [152mm]	30°	3/4"
4" [102mm]	8" [203mm]	30°	1"
5" [127mm]	7" [178mm]	45°	1 7/8"
6" [152mm]	8 1/2" [216mm]	45°	2 1/4"

START BENDS AT ARROW ON TOOL

CAT. NO. **600B**

BENDS V500 AND V700 RACEWAY IN ONE SWEEP. USE 601B ADAPTER FOR NO. V200 RACEWAY.

BACK-TO-BACK BENDS

LOCATE "STAR-POINT"



opposite the finish line desired – the "star-point" indicates where back of the bend will lie.



600B RACEWAY BENDER OPERATING INSTRUCTIONS

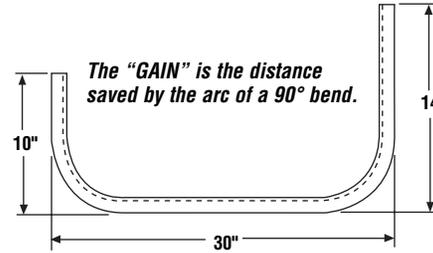
Installation Instruction No.: 28373R1 – Updated April 2004

The 600B consists of: Iron bender, two sections of 3/4" [19.1mm] galvanized steel pipe handle and extra-strong coupling.

BENDING WITH THE WIREMOLD 600B BENDER

BENDING TIPS

Knowing the "GAIN" saves time and cuts waste. Precut raceway to the required length.

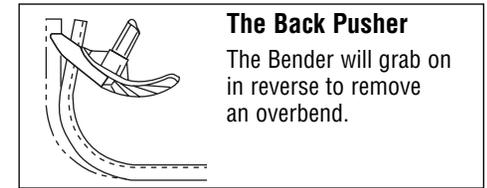


The "GAIN" on the 600B tool is 2 1/4" [57mm] for a 90° sweep or 1 1/8" [29mm] for a 45° bend.

The Raceway at left could be precut to a 49-1/2" [1257mm] length.

$$10" + 30" + 14" = 54" \\ [254mm] + [762mm] + [356mm] = [1372mm]$$

$$54" \text{ less two "GAINS" } (4 \frac{1}{2}") = 49 \frac{1}{2}" \\ [1372mm] \text{ less } [114mm] = [1257mm]$$



- **Bending with tool in air.** Apply hand pressure as close to the tool as possible. Keep pressure close to the groove for smoother bends and greater accuracy.
- **Bending on floor.** Work on hard surfaces. Avoid soft sand or deep pile carpets.
- **Degree scale.** One side of the tool (closed hook side) is scaled for V500 raceway. The opposite, open hook side, is scaled for V700.
- **Zero (0°) degree line.** The zero degree line in bottom of groove adjacent to the hook is the beginning point of the bend.
- **Rim notches.** The rim notches closest to the hook indicate exact center of a 45° bend. Numerals "500" and "700" tell which notch to use for which size raceway.

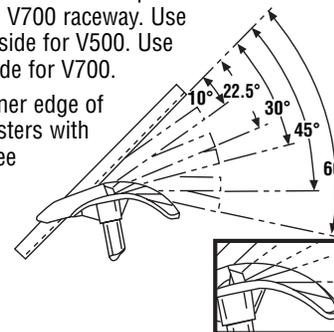
OTHER LABOR SAVING TOOLS FROM WIREMOLD

- 605 Raceway Cutter for 500 Raceway –
- 607 Raceway Cutter for 700 Raceway – Portable single action cutters. Case hard steel blades for clean, fast and easy square cuts every time.
- 605K Replacement blade for 605 Cutter –
- 607K Replacement blade for 607 Cutter – Case hard steel blades ensure clean, burr-free cuts.

ANGLE BENDS

Separate degree scales are provided for V500 and V700 raceway. Use closed hook side for V500. Use open hook side for V700.

Bend until inner edge of raceway registers with desired degree mark.

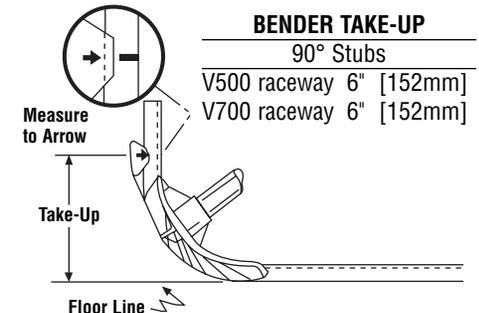


STUB LENGTHS

BENDER TAKE-UP

90° Stubs

V500 raceway 6" [152mm]
V700 raceway 6" [152mm]



The Wiremold Company
U.S. and International:
60 Woodlawn Street • West Hartford, CT 06110
1-800-621-0049 • FAX 860-232-2062 • Outside U.S. 860-233-6251
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850 Gartshore Street • Fergus, Ontario N1M 2W8
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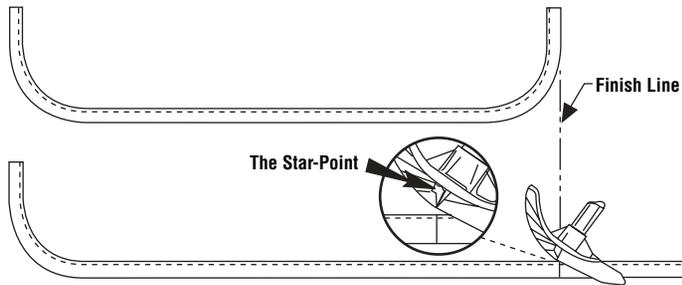
28373R1 – Updated April 2004 – For latest specs visit www.wiremold.com



BENDING WITH THE WIREMOLD 600B BENDER

BACK-TO-BACK BENDS

Position the tool on raceway so the "STAR-POINT" symbol is opposite the finish line desired. The STAR-POINT indicates where the back of any angle bend will lie (1° to 90° inclusive).

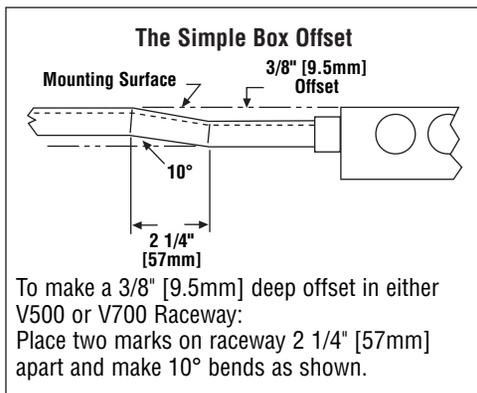


OFFSET TABLE

WITH 22.5° BENDS					
Offset Depth		Place Two Marks on Raceway		Shrink Table*	
Inches	[mm]			Inches	[mm]
1	[25mm]	2 5/8" [67mm] apart		3/16	[4.8mm]
2	[51mm]	5 1/4" [133mm] apart		3/8	[9.5mm]
3	[76mm]	7 3/4" [197mm] apart		9/16	[14.3mm]
4	[102mm]	10 1/2" [267mm] apart		3/4	[19.1mm]
5	[127mm]	13" [330mm] apart		15/16	[23.8mm]
6	[152mm]	15 1/2" [394mm] apart		1 1/8	[29mm]
7	[178mm]	18 1/4" [464mm] apart		1 5/16	[33mm]
8	[203mm]	20 3/4" [527mm] apart		1 1/2	[38mm]

WITH 30° BENDS					
Offset Depth		Place Two Marks on Raceway		Shrink Table*	
Inches	[mm]			Inches	[mm]
3	[76mm]	6" [152mm] apart		3/4	[19.1mm]
4	[102mm]	8" [203mm] apart		1	[25mm]
5	[127mm]	10" [254mm] apart		1 1/4	[32mm]
6	[152mm]	12" [305mm] apart		1 1/2	[38mm]
7	[178mm]	14" [356mm] apart		1 3/4	[44mm]
8	[203mm]	16" [406mm] apart		2	[51mm]
9	[229mm]	18" [457mm] apart		2 1/4	[57mm]
10	[254mm]	20" [508mm] apart		2 1/2	[64mm]

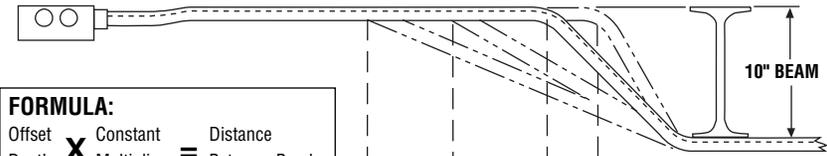
WITH 45° BENDS					
Offset Depth		Place Two Marks on Raceway		Shrink Table*	
Inches	[mm]			Inches	[mm]
5	[127mm]	7" [178mm] apart		1 7/8	[48mm]
6	[152mm]	8 1/2" [216mm] apart		2 1/4	[57mm]
7	[178mm]	9 3/4" [248mm] apart		2 5/8	[67mm]
8	[203mm]	11 1/4" [286mm] apart		3	[76mm]
9	[229mm]	12 1/2" [318mm] apart		3 3/8	[86mm]
10	[254mm]	14" [356mm] apart		3 3/4	[95mm]
11	[279mm]	15 1/2" [394mm] apart		4 1/8	[105mm]
12	[305mm]	16 3/4" [425mm] apart		4 1/2	[114mm]
13	[330mm]	18 1/4" [464mm] apart		4 7/8	[124mm]
14	[356mm]	19 3/4" [502mm] apart		5 1/4	[133mm]
15	[381mm]	21" [553mm] apart		5 5/8	[143mm]



BEND WITH MARK ON RACEWAY OPPOSITE ARROW ON TOOL

* The "shrink table" column tells where to place the first mark. If stringing raceway towards an obstruction, place the first mark on raceway beyond edge of obstruction distance shown in shrink table. If offsetting away from obstruction ignore shrink.

OFFSET BY TRIANGULATION



FORMULA:
 Offset Depth X Constant Multiplier = Distance Between Bends

EXAMPLE:
 To offset under 10" [254mm] beam:

- Select angle of bends.
- Multiply offset depth by proper Constant Multiplier.
- Depending on the angle of bends, the distance between bends for a 10" [254mm] offset is...

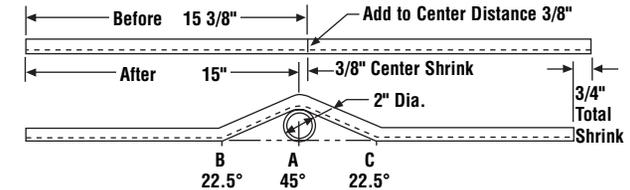
22.5°	30°	45°	60°
2.6	2.0	1.4	1.2
26"	20"	14"	12"

OFFSET TABLE				
Angle of Bends	Constant Multiplier	Shrinkage of Offset Depth	Inches	[mm]
10° x 10°	6.0	1/16"	[1.6mm]	
22.5° x 22.5°	2.6	3/16"	[4.8mm]	
30° x 30°	2.0	1/4"	[6.4mm]	
45° x 45°	1.4	3/8"	[9.5mm]	
60° x 60°	1.2	1/2"	[12.7mm]	

Shrink Column above indicates where to place the first mark. The 10" offset illustrated (with 45° bends) would shorten the raceway 10 x 3/8" or 3 3/4" [254mm x 9.5mm x 95mm]. Therefore place 1st mark 3 3/4" [95mm] beyond the edge of beam to allow for this shrink.

"3 BEND" PIPE SADDLES

Example:
 Making a saddle in 500 or 700 raceway over a 2" [51mm] diameter pipe.



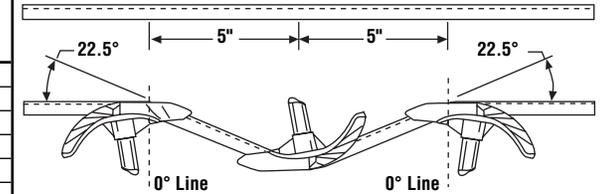
STEP ONE Use this table to locate center mark "A"

Note: The center on a "3 Bend" Saddle shifts (shortens) 3/16" [4.8mm] for every inch of saddle depth.

SADDLE CENTER LOCATOR					
Saddle Depth		Add to Center Distance		Raceway Shortens Overall	
Inches	[mm]	Inches	[mm]	Inches	[mm]
1	[25mm]	3/16	[4.8mm]	3/8	[9.5mm]
2	[51mm]	3/8	[9.5mm]	3/4	[19.1mm]
3	[76mm]	9/16	[14.3mm]	1 1/8	[29mm]
4	[102mm]	3/4	[19.1mm]	1 1/2	[38mm]
5	[127mm]	15/16	[23.8mm]	1 3/4	[44mm]
6	[152mm]	1 1/8	[29mm]	2 1/4	[57mm]

STEP TWO Use the table below to locate marks "B" and "C".

Saddle Depth		Place Marks "B" and "C" each way from Center "A"	
Inches	[mm]	Inches	[mm]
1	[25mm]	2 1/2"	[64mm]
2	[51mm]	5"	[127mm]
3	[76mm]	7 1/2"	[191mm]
4	[102mm]	10"	[254mm]
5	[127mm]	12 1/2"	[318mm]
6	[152mm]	15"	[381mm]



STEP THREE

Make a 45° bend with "A" opposite deepest rim notch on tool.

STEP FOUR

Make a 22.5° bend at "B" (mark "B" at zero degree line on tool)

STEP FIVE

Make a 22.5° bend at "C" (mark "C" at zero degree line on tool)