





a = Place mark on conduit before installing conduit in bender

b = Place mark on conduit before installing conduit in bender

z = Place mark on conduit at a stationary point at the back of the bender before bending 90 degree bend and enter value in the Travel z cell in chart

t = Place mark on conduit at a stationary point at the back of the bender after bending 90 degree bend and enter value in the Travel t cell in chart

Deduct = af

Length = L

Stub fc = cf

Length de = de

Travel = bz - bt

gain = (cf + de) - L

B to B = af - ((cf + de) - L)

OD = Outside diameter of conduit

DCOB = (Deduct - Radius) Distance from the front of the bending shoe to the center of bend.

Travel z = bz

Travel t = bt