| CONDUIT | Deduct | Length | Stub "FC" | Length "ED" | Travel | Gain | B to B | DCOB | OD | Travel Z | Travel T |
| :---: | :---: | :---: | :---: | :---: | :---: | :---: | :---: | :---: | :---: | :---: | :---: |
| Chicago 16 |  |  |  |  |  |  |  |  |  |  |  |
| Chicago 21 |  |  |  |  |  |  |  |  |  |  |  |
| Chicago 27 |  |  |  |  |  |  |  |  |  |  |  |
| EMT 16 |  |  |  |  |  |  |  |  |  |  |  |
| EMT 21 |  |  |  |  |  |  |  |  |  |  |  |
| EMT 27 |  |  |  |  |  |  |  |  |  |  |  |
| EMT 35 |  |  |  |  |  |  |  |  |  |  |  |
| EMT 41 |  |  |  |  |  |  |  |  |  |  |  |
| EMT 53 |  |  |  |  |  |  |  |  |  |  |  |
| EMT 63 |  |  |  |  |  |  |  |  |  |  |  |
| EMT 78 |  |  |  |  |  |  |  |  |  |  |  |
| EMT 91 |  |  |  |  |  |  |  |  |  |  |  |
| EMT 103 |  |  |  |  |  |  |  |  |  |  |  |
| IMC 16 |  |  |  |  |  |  |  |  |  |  |  |
| IMC 21 |  |  |  |  |  |  |  |  |  |  |  |
| IMC 27 |  |  |  |  |  |  |  |  |  |  |  |
| IMC 35 |  |  |  |  |  |  |  |  |  |  |  |
| IMC 41 |  |  |  |  |  |  |  |  |  |  |  |
| IMC 53 |  |  |  |  |  |  |  |  |  |  |  |
| Rigid 16 |  |  |  |  |  |  |  |  |  |  |  |
| Rigid 21 |  |  |  |  |  |  |  |  |  |  |  |
| Rigid 27 |  |  |  |  |  |  |  |  |  |  |  |
| Rigid 35 |  |  |  |  |  |  |  |  |  |  |  |
| Rigid 41 |  |  |  |  |  |  |  |  |  |  |  |
| Rigid 53 |  |  |  |  |  |  |  |  |  |  |  |
| Rigid 63 |  |  |  |  |  |  |  |  |  |  |  |
| Rigid 78 |  |  |  |  |  |  |  |  |  |  |  |
| Rigid 91 |  |  |  |  |  |  |  |  |  |  |  |
| Rigid 103 |  |  |  |  |  |  |  |  |  |  |  |
| Robroy 16 |  |  |  |  |  |  |  |  |  |  |  |
| Robroy 21 |  |  |  |  |  |  |  |  |  |  |  |
| Robroy 27 |  |  |  |  |  |  |  |  |  |  |  |
| Robroy 35 |  |  |  |  |  |  |  |  |  |  |  |
| Robroy 41 |  |  |  |  |  |  |  |  |  |  |  |
| Robroy 53 |  |  |  |  |  |  |  |  |  |  |  |
| Robroy 78 |  |  |  |  |  |  |  |  |  |  |  |

Side "E"


K

1 Length "L" $\longrightarrow \mathbf{1}$
$a=$ 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 $=\mathrm{L}$
Stub fc = cf
Length de = de
Travel = bz-bt
gain $=(c f+d e)-L$
$B$ to $B=$ af $-((c f+d e)-L)$
$O D=$ Outside diameter of conduit
$D C O B=($ Deduct - Radius) Distance from the front of the bending shoe to the center of bend.
Travel $\mathrm{z}=\mathrm{bz}$
Travel $\mathrm{t}=\mathrm{bt}$

