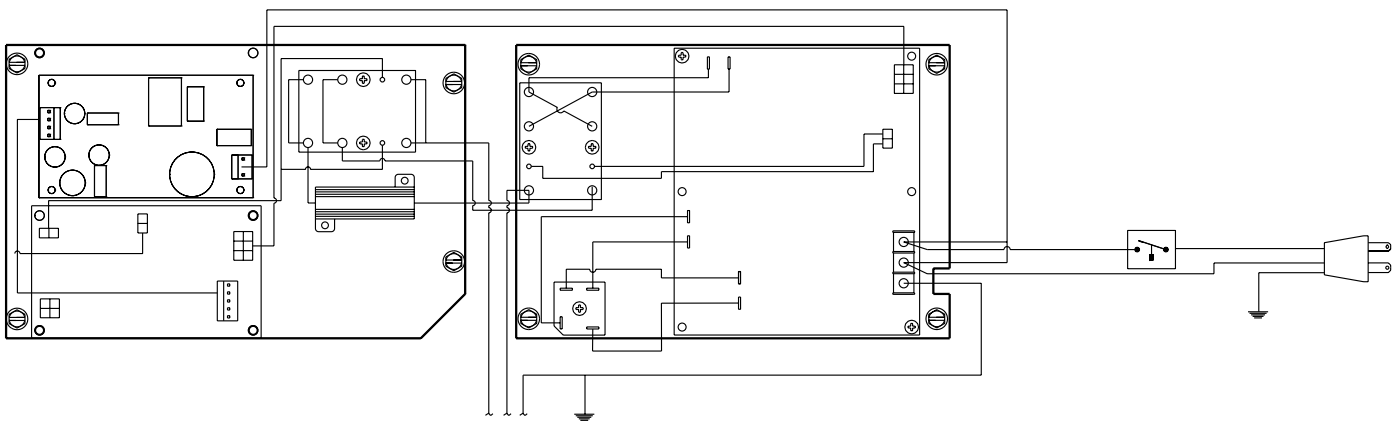


SERVICE BULLETIN

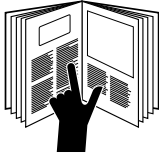



500 6018.0 I/O Control Retrofit to 854 Bender with 500 3050.7 I/O Control



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

Important Safety Information

	⚠ WARNING
	Read and understand all of the instructions and safety information in IM 1301 before operating or servicing this tool.

	⚠ WARNING
	Electric shock hazard: Always turn off and unplug bender before performing any repair. Failure to observe this warning can result in severe injury or death.

IMPORTANT
The I/O control is a static-sensitive device. Handle only at a static-safe work station.

Wiring

Refer to the Wiring Diagram.

1. Completely remove and discard I/O to PGU Wire Unit (124) and I/O to Power Wire Unit (125).
2. Unplug Brake and Pendant.
3. Disconnect red jumper wire, white motor-drive wire, and white resistor wire.
4. Remove four 5/16" hex drive screws (23) that retain assembly in bender, and remove old assembly.
5. Insert new assembly in bender and secure with four 5/16" hex drive screws (23).
6. Connect the green wire provided (strapped to base plate of I/O) between the center ground screw (shared with ground wire of the drive unit) and the ground terminal on the PGU assembly.
7. Find the power wires on the new control assembly. They are connected to the small brown power supply circuit board.
 - Connect the ring terminal of the black wire to the line connection of the PGU.
 - Connect the ring terminal of the white wire to the neutral connection of the PGU.

Note: The rest of the connections are similar to the 500 3050.7 board.

8. Plug in the Direction Selector Switch Unit (127) to JP4 "Selector" on circuit board.
9. Plug in the Brake (51) to JP2 "Brake" on circuit board.
10. Plug in the (supplied) six-wire harness from the I/O from JP5 "TO PGU" to the PGU board "TO I/O" connector.
11. Connect the white motor-drive wire to relay Common (terminal #4) shared by short black jumper across relay common.
12. Connect the red jumper wire to relay Normally Open (terminal #6) shared by short red jumper across relay NO.
13. Connect the white resistor wire to the relay Normally Closed on the PGU (terminal #7) with black motor-drive wire.

Connection Check

Leave the crescent-shaped shroud off the top of the 854 to perform some checks. **Be careful not to contact the circuit boards or moving parts when the cover is off. Do not bend conduit with shroud off.** Only observe the shoe movement and LEDs as described below.

1. Plug in and turn on the 854.

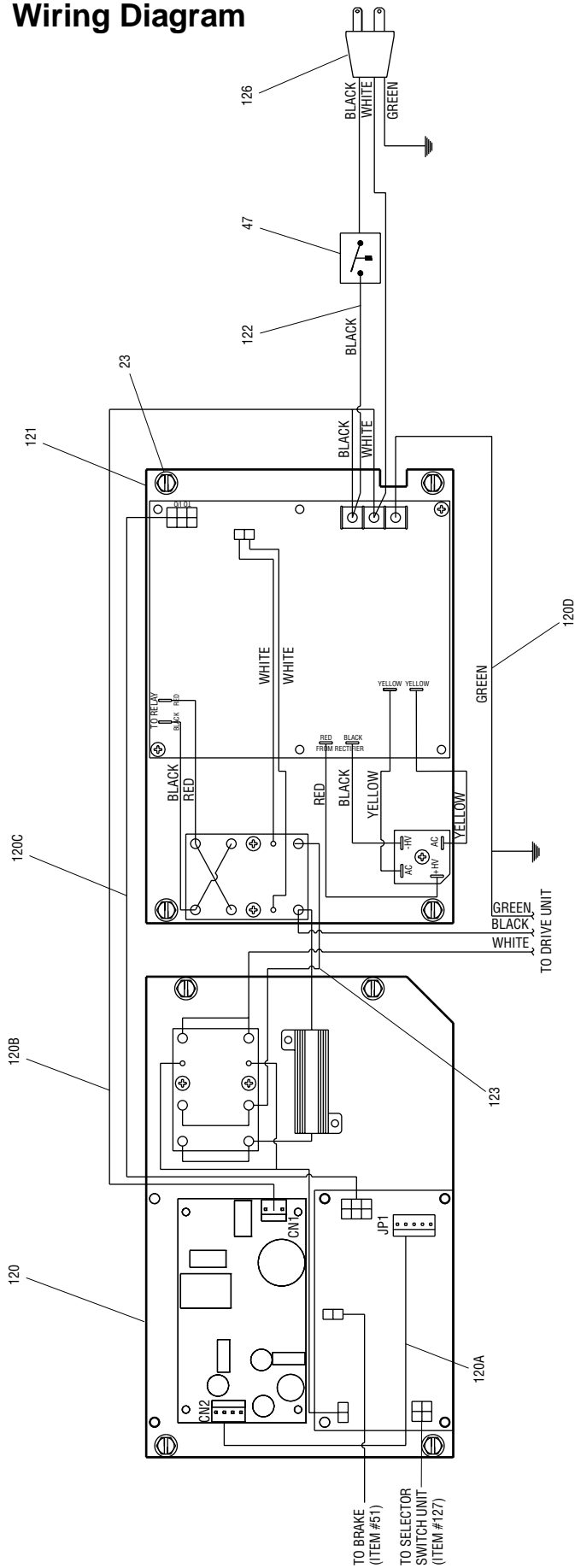
The green LED on the PGU should come on, and the green LED on the Control Board should come on.
2. Switch the selector to 1-1/2" – 2".
3. Press BEND. Observe the direction of rotation.

If the bender goes in the wrong direction, turn off and unplug the bender. Swap the black and white wires of the drive unit and repeat Connection Check.
4. Press and hold BEND. 854 shoes should turn 180 degrees in 10 to 15 seconds.
5. Press UNLOAD. Observe the direction of rotation.
6. Switch the selector to 1/2" – 1-1/4". Press BEND. Release. Press UNLOAD. Observe the direction of rotation.
7. Turn off and unplug the 854 bender.
8. Check that the circuit board assembly is firmly mounted with four 5/16" hex drive screws (23).
9. Replace the crescent-shaped shroud and firmly mount with four 5/16" hex drive screws (23).
10. The bender is now ready for normal usage.

Troubleshooting

If you encounter any difficulty connecting or using this circuit board assembly, please contact Greenlee Textron.

Wiring Diagram



Parts List

Key	Part No.	Description	Qty.
120	500 6018.0	854 I/O Control Assembly	1
120A	500 6037.6	Wire Unit, Power — DC	1
120B	500 6036.8	Wire Unit, Power — AC	1
120C	503 8648.4	Wire Unit, I/O — PGU	1
120D	500 6040.6	Wire Unit, Ground	1
121	500 5467.8	PGU2 Assembly	1
122	503 8941.6	Wire Unit, PGU to Breaker	1
123	918 6839.4	Wire Unit, I/O to PGU	1
126	503 8603.4	Cord Unit, Power	1
127	500 3052.3	Switch, PCB Direction	1
128	905 4279.7	Tie, Cable (not shown)	3