

7. Keeping the conduit flat, apply ample foot pressure to the bender's heel minimizing the use of the handle as a lever, smoothly rolling up the free end until the **45°** mark is reached.

*Note: Some over bending may be required to allow for spring back of the conduit. The resting condition of the conduit is to be at the final angle desired.*



8. Keeping the bender and conduit together, flip the two parts upside down and put the bender's handle hilt on the floor, balancing the conduit in the air, allow the conduit to rotate 180° in the cradle. Slide the conduit down so the first bend is moving away from the bender head, aligning the 1<sup>st</sup> return bend mark with the **Arrow Symbol** (See Stub-Up section, note 5).

*Note: Some over bending may be required to allow for spring back of the conduit. The resting condition of the conduit is to be at the final angle desired.*

9. The second bend of the saddle bend is accomplished by performing an air-bend. Make sure handle hilt is secure on ground and is reinforced by your foot so it does not slide out. Make sure you are balanced and apply force close to the tool and your body controlling the tubing as you bend it around the bender's cradle. Bend the free end until the **22.5°** mark is reached.



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