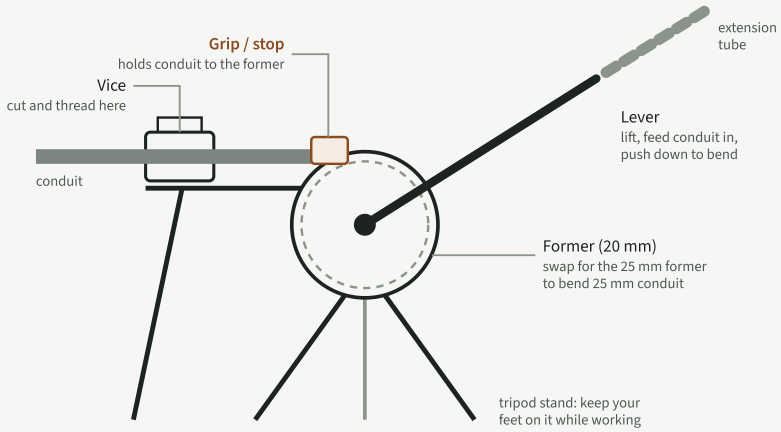
THE CONDUIT BENDER: CUTTING AND BENDING STEEL CONDUIT

WHAT MUST YOU DO AFTER CUTTING STEEL CONDUIT?

THE CONDUIT BENDER AND CUTTING

For steel conduit you use a **conduit bender**, a stand-mounted tool that does three jobs: it **grips** the conduit in a **vice** for cutting and threading, and it **bends** it. (A new one is clean. Most you'll see on site are covered in grease and marks.)
The main parts:

- **Vice**: grips the conduit securely so you can cut it or thread it.
- **Grip / stop**: holds the conduit against the former while you bend.
- **Former**: the curved wheel the conduit bends around. Each former suits one size. Ours was fitted with the **20 mm** former, with a **25 mm** former stored below. Swap the former to bend 25 mm.
- **Lever**: you lift it, feed the conduit in, then push down to bend.
- **Extension tube**: slides over the end of the lever for extra grip and **purchase** on hefty conduit.



A stand-mounted conduit bender (simplified). The same tool is your **vice** for cutting and threading and your **bender**. Formers are size-specific: 20 mm and 25 mm.

Cutting steel conduit

- Clamp it firmly in the **vice**. Check the vice and the whole bender are **tight and secure** first. Anything coming loose affects the job.
- Cut with a **hacksaw**, using the **whole length of the blade** for a smooth, easy cut.
- Cutting leaves a sharp **burr** inside, so **file the inside** smooth (see the threading section).

BENDING STEEL CONDUIT (A 90° BEND)

1. **Mark** the conduit where the bend should start. You'll have to work out your own marks on your bender's former through practice.
2. Set the **grip vertical**, **lift the lever**, and **slide the conduit in** against the former.
3. Make sure everything's prepared, then **push the lever down** steadily to form the bend.
4. **Check as you go** so you don't go too far. It's easy to add a little more ("a little tweak").
5. Take it out and **check the angle** against something you **know is a true right angle** (for example a square wall corner).
6. If you've **over-bent** it, put it back in the bender and **pull the bend back out** a bit.

> **Sparky's tip**
> Bend a little at a time and check. Taking a bend back out is possible, but it's much easier to creep up on 90° than to correct an over-bend.

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