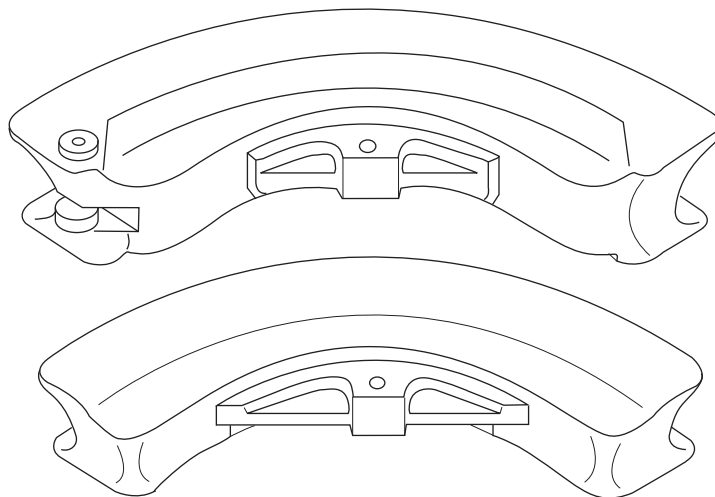


# INSTRUCTION MANUAL



## PVC Shoes for Use with 880/884 Benders



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

Register this product at [www.greenlee.com](http://www.greenlee.com)

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## Description

PVC-type bending shoes are intended to be used with Greenlee 880 and 884 Conduit Benders. They are designed to bend PVC-coated rigid conduit. The 1-1/2" and 2" shoes have a single hex cam to eject the conduit after it is bent; the 3" to 4" shoes have two hex cams.

## Safety

Safety is essential in the use and maintenance of Greenlee tools and equipment. This instruction manual and any markings on the tool provide information for avoiding hazards and unsafe practices related to the use of this tool. Observe all of the safety information provided.

## Purpose of this Manual

This manual is intended to familiarize all personnel with the safe operation and maintenance procedures for the Greenlee PVC-type bending shoes.

Keep this manual available to all personnel.

Replacement manuals are available upon request at no charge at [www.greenlee.com](http://www.greenlee.com).

All specifications are nominal and may change as design improvements occur. Greenlee Tools, Inc. shall not be liable for damages resulting from misapplication or misuse of its products.

## ***KEEP THIS MANUAL***

## IMPORTANT SAFETY INFORMATION



### SAFETY ALERT SYMBOL

This symbol is used to call your attention to hazards or unsafe practices which could result in an injury or property damage. The signal word, defined below, indicates the severity of the hazard. The message after the signal word provides information for preventing or avoiding the hazard.

#### ⚠️ DANGER

Immediate hazards which, if not avoided, **WILL** result in severe injury or death.

#### ⚠️ WARNING

Hazards which, if not avoided, **COULD** result in severe injury or death.

#### ⚠️ CAUTION

Hazards or unsafe practices which, if not avoided, **MAY** result in injury or property damage.

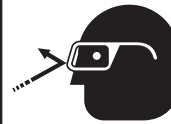


#### ⚠️ WARNING

Pinch points:

Keep hands away from bending shoe, pipe supports, and conduit when bender is in use.

Failure to observe this warning could result in severe injury or death.



#### ⚠️ WARNING

Wear eye protection when bending conduit.

Failure to observe this warning could result in severe injury.

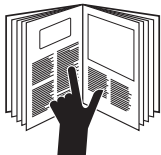
#### ⚠️ WARNING

Inspect the shoes and conduit supports before each use. Replace damaged, worn or missing parts with Greenlee replacement parts. A damaged or incorrectly assembled component can fail and strike nearby personnel.

#### ⚠️ CAUTION

Some of the bending shoes are heavy (42 lb) and may require more than one person to lift.

Improper lifting may result in injury.



#### ⚠️ WARNING

Read and understand all of the instructions and safety information in this manual before operating or servicing this tool. Also follow the instructions and safety information supplied with your bender and pump. Failure to observe this warning could result in severe injury or death.

*Note: Keep all decals clean and legible, and replace when necessary.*

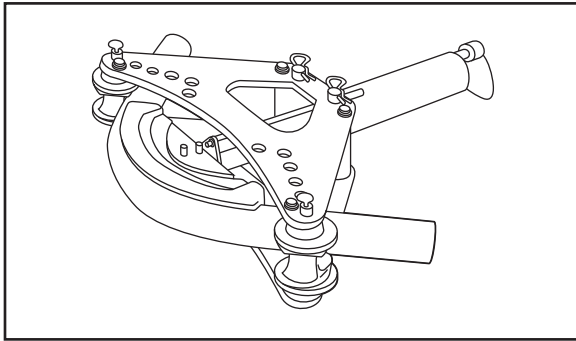
## Shoes and Supports to Bend 40 Mil PVC-Coated Rigid Conduit

Use these accessories with your 880 or 884 bender.

40 Mil Coated Size	UPC No. 78-3310-	Description	Centerline Radius	Included in 880 PVC	Included in 884 PVC	33612
1/2"	33456	Shoe Unit	4"			
3/4"	33457G	Shoe Unit	4-1/2"			
1"	33458	Shoe Unit	5-3/4"	1		1
1-1/4"	33459	Shoe Unit	7-1/4"	1	1	1
1-1/2"	33463	Shoe Unit	8-1/4"	1	1	1
2"	33462G	Shoe Unit	9-1/2"	1	1	1
2-1/2"	34321	Shoe Unit	11-7/16"			
3"	34340	Shoe Unit	13-3/4"		1	
3-1/2"	34342G	Shoe Unit	16"			
4"	34344	Shoe Unit	18-1/4"		1	
1/2"-2"	33455G	Conduit Support for 880 Bender		2		2
1/2"-4"	33454	Conduit Support for 884 and 885 Benders			2	
	34329	7/8" Wrench		1	1	1

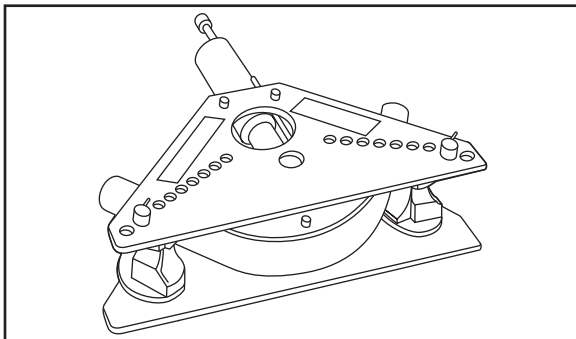
### 880 PVC Bender

for bending 1"-2" PVC-coated rigid conduit



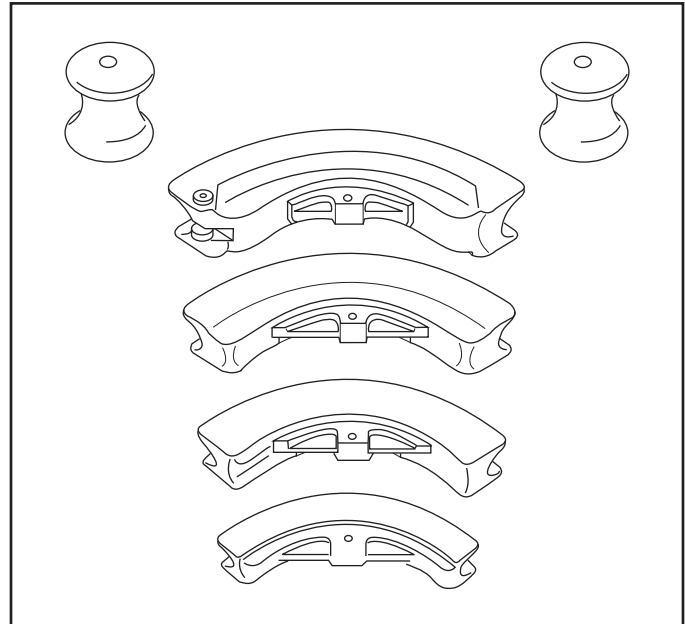
### 884 PVC Bender

for bending 1-1/4"-4" PVC-coated rigid conduit



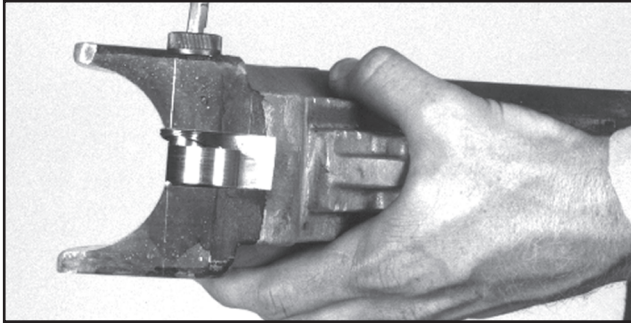
### 33612 Shoe Group

for 1"-2" 40 Mil PVC-coated rigid conduit

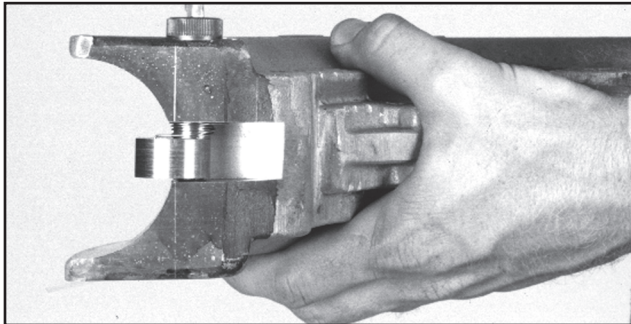


Use with 880 Greenlee Bender

## How to Bend



**Cam retracted (for bending conduit)**



**Cam extended (for ejecting conduit)**

### Step 1

Select the size of shoe that corresponds to the size of conduit. Check the cam location. If the cam is extended, retract the cam by turning the 7/8" headcam with a wrench.

*Note: Shoes smaller than 1-1/2" do not have a cam; 3" and larger shoes have two cams.*



### Step 2

Attach the shoe support to the ram with the ram pin.

*Note: When using the 2" or smaller shoe, use the small shoe support. When using 2-1/2" or larger shoe, use the large shoe support.*

Attach the shoe to the shoe support with the shoe pin.



### Step 3

Rotate the conduit support so that the appropriate groove is toward the conduit.

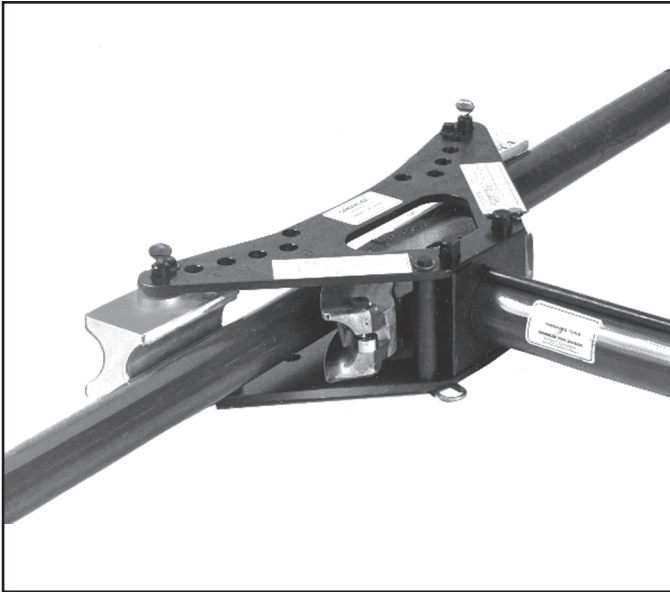
*Note: For bending more than 75° in 1" PVC-coated conduit, rotate the conduit support so that the large groove faces the conduit.*



### Step 4

Position both conduit supports in line with the corresponding holes in the bender frame. Insert the pipe support pin through the upper frame plate, through the conduit support, and through the lower frame plate. Lock the pipe support pins in place with pin locks.

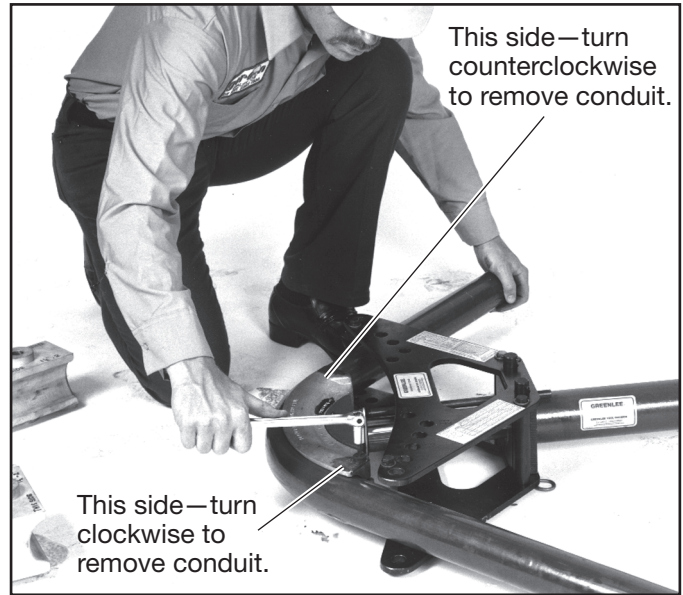


**How to Bend (cont'd)****Step 5**

Advance the shoe by operating the hydraulic pump.

*Note: Refer to the instructions supplied with the hydraulic pump.*

While the shoe is advancing, make sure that the conduit is properly seated in the conduit supports and the shoe groove.

**Step 7**

Release the pressure at hydraulic pump.

*Note: Refer to the instructions supplied with the hydraulic pump.*

After the ram has retracted completely, remove the pipe support pins and pipe supports.

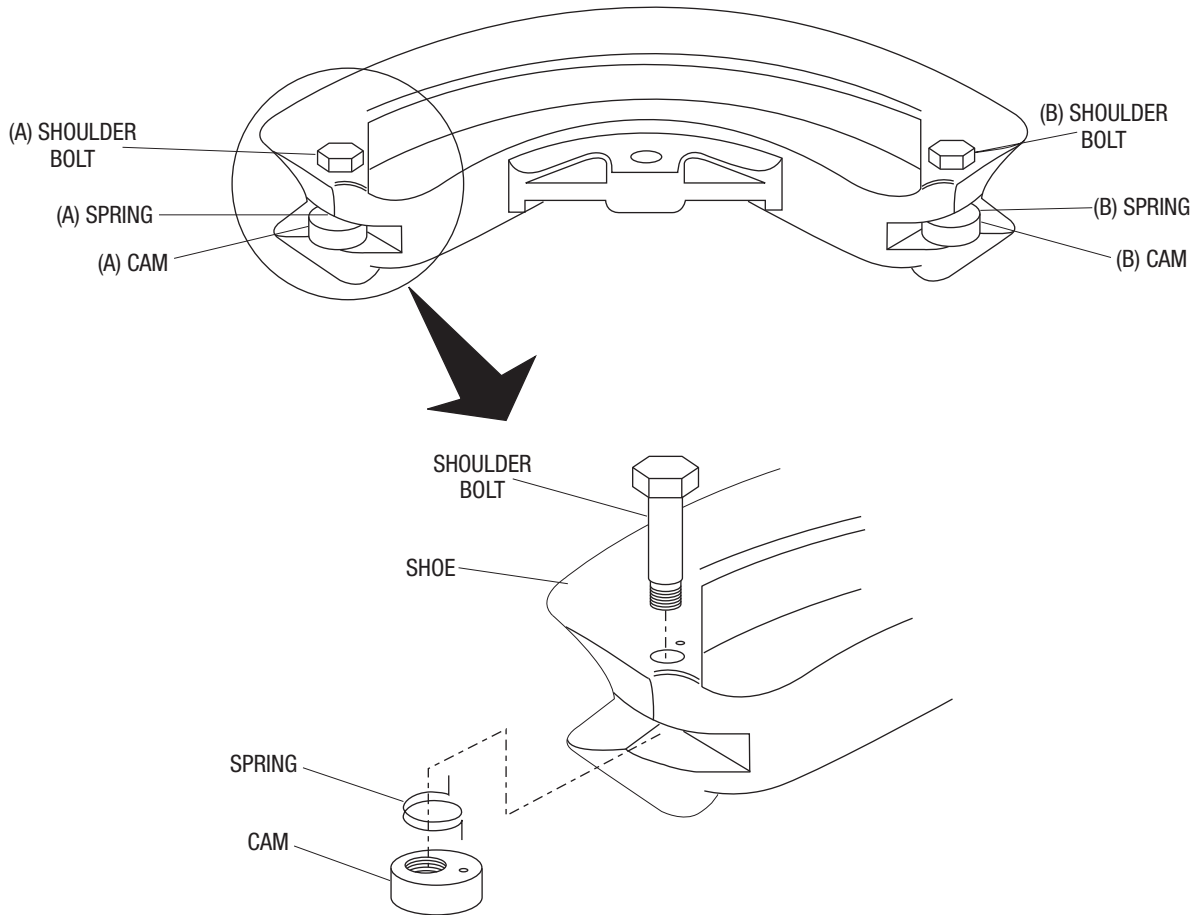
**Step 6**

Using the bender instructions, bend the PVC-coated conduit to the desired angle.

**Step 8**

Remove the conduit from the bender. Inspect the PVC coating. Touch up if necessary.

## Shoe Unit Illustration and Parts List



Items marked with (•) are included in the associated service kit.

Size	Cat. No. Shoe Unit	Service Kit Part No.	(A) Shoulder Bolt	(A) Cam	(A) Spring	(B) Shoulder Bolt	(B) Cam	(B) Spring
1/2"	33456							
3/4"	33457G							
1"	33458							
1-1/4"	33459							
1-1/2"	33463	52059254	•	•	•			
2"	33462G	52059255	•	•	•			
2-1/2"	34321	52059261	•	•	•			
3"	34340	52059256	•	•	•	•	•	•
3-1/2"	34342G	52059250	•	•	•	•	•	•
4"	34344	52059257	•	•	•	•	•	•



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