

# Hotbox™ PVC Bender

For 1/2" Thru 4" Conduit  
115 Volt A.C. - 20 Amps  
50-60 Hz - 2400 Watts

**Model No.  
BHB-540A**

Made in the USA



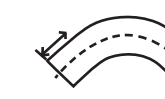
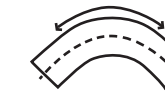
Milwaukee, WI  
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## Instructions

1. Place unit on secure dry surface away from flammable materials.
2. Open cover and plug in unit.
3. Place conduit on rollers when heating element glows red. Close cover and slowly rotate conduit.
4. Allow approximately 30 seconds per 1/2" of conduit diameter for correct bending temperature to be reached. Sizes and ambient temperature will vary these times.
5. Conduit is ready to form when it's surface takes on a glossy appearance and it deflects readily when lifted at one end.
6. Remove conduit and form as desired. Hold conduit in place. As conduit cools it will remain permanently in this shape. To quickly cool and set, sponge with cold water.
7. **Important:** Use bending plugs for short radius bends and offsets of 2" through 4" conduit to eliminate deformation.

## Bending Chart

Minimum Stocks Lengths for 90° Elbows



Conduit Nominal Inside Dia.	Inside Radius*	Length of Curved Section***	Straight Ends**	Total Stock Length
1/2"	4"	7"	2"	11"
3/4"	5"	9"	2-5/8"	14-1/4"
1"	6"	10-1/2"	2-3/4"	16"
1-1/4"	8"	14"	2-3/4"	19-1/2"
1-1/2"	10"	17-1/2"	3-1/16"	23-5/8"
2"	12"	21"	4"	29"
2-1/2"	15"	26"	4-3/4"	35-1/2"
3"	18"	31"	7-1/2"	46"
3-1/2"	21"	36"	8-3/16"	52-3/8"
4"	24"	41"	9"	59-1/2"

\* Ref. NEC 352-24

For Conductors without lead sheath - Minimum radius of conduit bends.

\*\* Recommended minimum straight section each end.

\*\*\* Minimum Heated Length