

MAX-I-MUM XL Commercial Bender System Operations Manual

The **MAX-I-MUM XL COMMERCIAL BENDER SYSTEM** includes:
MAX-I-MUM II™ Port-O-Bender®
MAX Snap Stand® and Wheel Kit
Adjustable MAX Cut-Off™

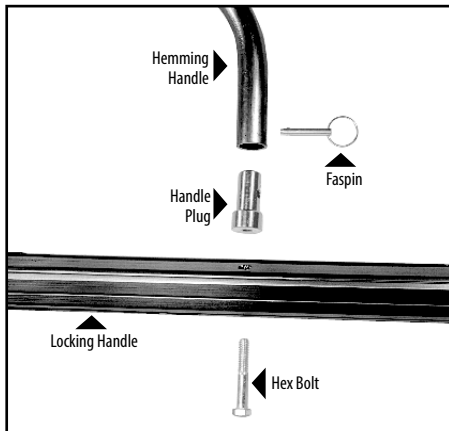


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Setting up your MAX-I-MUM II

Hemming Handle Installation



The MAX-I-MUM II Hemming Handle Assembly (10' 6" & 12' 6" Brake) includes: (2) Hemming Handles, (4) Handle Plugs, (4) Faspins, (4) Hex Bolts. **The 8' 6" Brake includes:** (1) Hemming Handle, (2) Handle Plugs, (2) Faspins, (2) Hex Bolts. **The 14' 6" Brake includes:** (3) Hemming Handles, (6) Handle Plugs, (6) Faspins, (6) Hex Bolts.

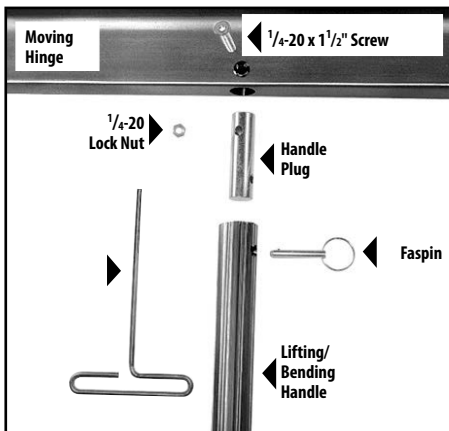


Insert Hex Bolt through Locking Handle of your Port-O-Bender and into base of Hemming Handle as indicated using the 3/8" Hex Bolts provided. **HAND TIGHTEN ONLY.** Repeat for other side.



Attach the Hemming Handle over the Handle Plugs and secure them with Faspins. Now tighten the 3/8" Hex Bolts with a 9/16" wrench. Handle can be detached from now on by simply removing the Faspins.

Lifting/Bending Handle Installation



Exploded view of Handle Assembly — First insert one end of Handle Plug into Lifting/Bending Handle and install Faspin through holes.



Next, insert Handle Assembly into hole in bottom of Moving Hinge. Align hole in hinge with Handle Plug and insert screw using Allen wrench as shown. Secure with 1/4-20 Lock Nut.



Repeat for other handles. To remove handles now, simply release Faspins. Always use more than one handle when bending.

Hinge Clip Installation

The Hinge Clip keeps the Moving Hinge in position for ease of aligning material. It can also prevent rippling of the material during cut off operations.

To install Hinge Clip, locate predrilled hole on bottom center of Moving Hinge. Align holes in Clip and Hinge as shown and insert Phillips head screw provided.

Note: You must engage Hinge Clip for proper operation of the Adjustable MAX Cut-Off.



Adjusting your MAX-I-MUM II

Power Link Adjustment Instructions

IMPORTANT: The Power Links on your Tapco Brake have been pre-set at the factory for average holding capacity and ease of operation. However, the Power Link Stud allows you to adjust the brake to your specific bending needs. It is important that you follow these steps when you adjust your Brake to ensure proper gripping tension and maximum performance.

CAUTION: overtightening the Link Stud can result in damage to brake components.

First check the uniformity of the clamping pressure along the entire length of your Tapco Brake by using the following method.

TO TEST

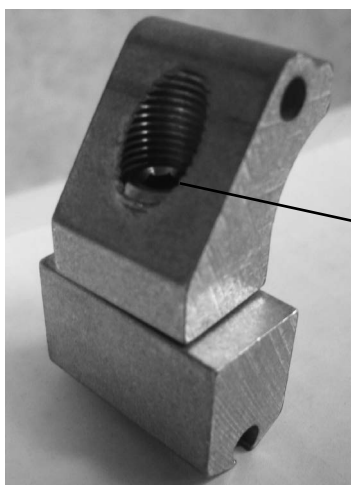
Cut some narrow strips, approximately 2" x 4", of aluminum or use strips from stock you will be using and lock one under each shoe casting as indicated in **Figure 1**. Lightly pull the material in a side to side and outward motion to determine the tightness and uniformity of each Power Link. Refer again to **Figure 1**. If the material can be moved when the handle is locked or if it requires excessive pressure to lock the handle down on the material then the Power Link may need adjustment.

NOTE: All adjustments are made with the Tapco Brake in the "open" position. All adjustments are tested with strips of material placed in the Brake in the "locked" position.

TO ADJUST

1. Insert the $\frac{3}{16}$ " hex wrench into the Power Link Stud (See **Figure 2**.)
2. Turn a $\frac{1}{4}$ to $\frac{1}{2}$ turn either **CLOCKWISE** to **INCREASE** locking tension or **COUNTER-CLOCKWISE** to **DECREASE** locking tension.
3. Adjust each shoe casting until all are uniform.

Repeat test step above to check tension.



Power Link Stud

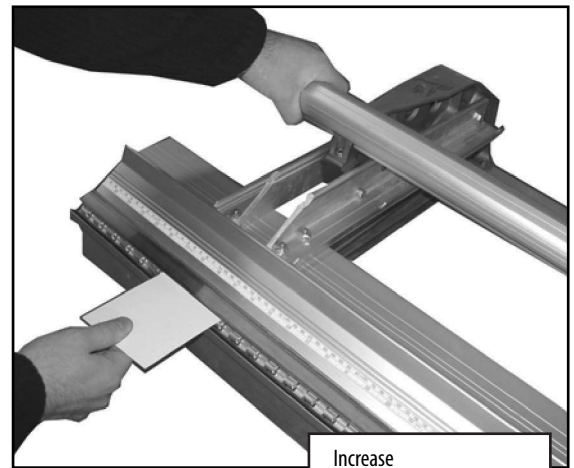


Figure 1

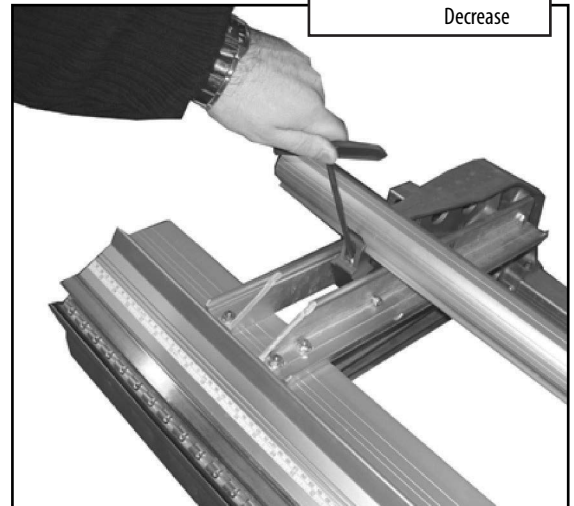
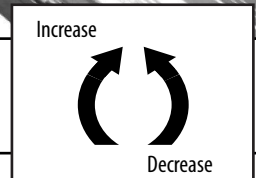
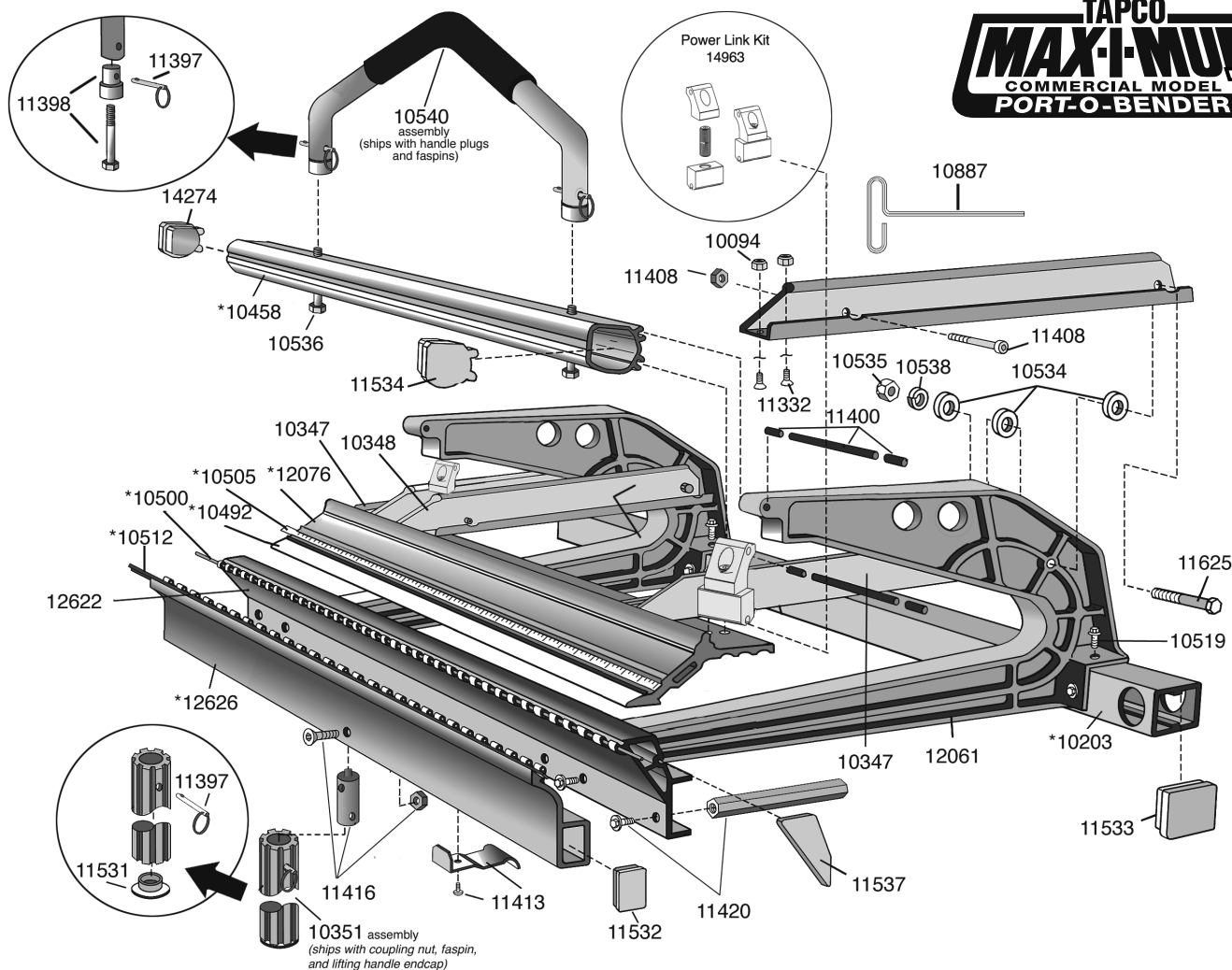


Figure 2

MAX-I-Mum II Parts List



*Note: For length-specific parts, 10'6" parts numbers are shown in diagram.

Item #	Description
10094	1/4 -20 Hex Flange Nut
12625	8'6" Max Moving Hinge
12626	10'6" Max Moving Hinge
12627	12'6" Max Moving Hinge
12628	14'6" Max Moving Hinge
12621	8'6" Max Fixed Hinge
12622	10'6" Max Fixed Hinge
12623	12'6" Max Fixed Hinge
12624	14'6" Max Fixed Hinge
10201	8'6" Max Back Rail
10203	10'6" Max Back Rail
10205	12'6" Max Back Rail
10207	14'6" Max Back Rail
10347	Max/Pro 19 Left Pivot Arm
10348	Max/Pro 19 Right Pivot Arm
10351	Lifting Handle Assembly
10454	HD Pro/Max 8'6" Locking Handle
10458	HD Pro/Max 10'6" Locking Handle
10462	HD Pro/Max 12'6" Locking Handle
10464	Max 14'6" Locking Handle
10491	8'6" Stainless Edge
10492	10'6" Stainless Edge
10493	12'6" Stainless Edge

Item #	Description
10494	14'6" Stainless Edge
10499	8'6" Hinge Pin
10500	10'6" Hinge Pin
10501	12'6" Hinge Pin
10502	14'6" Hinge Pin
10504	12'6" Tape Measure
10505	10'6" Tape Measure
10506	8'6" Tape Measure
12369	14'6" Tape Measure
10511	8'6" Vinyl Strip
10512	10'6" Vinyl Strip
10513	12'6" Vinyl Strip
10514	14'6" Vinyl Strip
10519	1/4 -20 x 3/4" Hex Wash HD Screw
10534	3/8" Flat Washer
10535	3/8-16 Nylock Hex Nut
10536	3/8-16 X 2 1/4 HEX BOLT
10538	3/8" Lock Washer
10540	Hemming Handle Assembly
10887	T-Handle Hex Key
11332	Screw 1/4-20 x 7/8" Flat HD
14963	Power Link Kit
11397	1/4" x 1-1/4" Faspin Kit (4)

Item #	Description
11398	Hemming Handle Plug Kit
11400	Locking Handle Pin Kit
11408	Bolt and Nut Kit
11413	Hinge Clip Kit
11416	Max Handle Plug Kit
11420	Coupling Nut Kit
11531	Lifting Handle Cap
11532	Moving Hinge Cap
11533	Back Rail Cap
14274	Locking Bar Cap
11536	Left Base Hinge Cap
11537	Right Base Hinge Cap
11625	3/8-16 3-1/4" Hex Cap Bolt
12042	10'/12' MaxII Parts Bag
12055	8' MaxII Parts Bag
12056	14' MaxII Parts Bag
12061	Pro 19/Max C Casting
12075	8'6" Max Locking Anvil
12076	10'6" Max Locking Anvil
12077	12'6" Max Locking Anvil
12078	14'6" Max Locking Anvil

Care and Maintenance of MAX-I-Mum II

Your Tapco Port-O-Bender® is virtually maintenance free and will provide you with years of reliable and trouble-free performance. However, there are a few basic necessities required to keep your Port-O-Bender® like new.

1. Clean the clamping surfaces each day before using. Use only clean shop towels that are free of dirt, oil and metal chips.
2. Do not use your bender around your saw table as the cuttings may get in between clamping surfaces and cause excessive wear or material scratching. Brush away any cuttings or filings that accumulate.
3. Transport your Port-O-Bender® in the unlocked position. You may transport it in the locked position if you clamp a piece of cardboard or vinyl siding between the clamping surfaces.
4. If your material is getting scratched, examine the Stainless Bending Edge, Base Hinge and Moving Hinge for roughness or burrs. Remove burrs with emery cloth or replace excessively worn parts. Using the Adjustable MAX Cut-Off will help eliminate excessive wear to costly bending edge.
5. Use a lightweight spray oil along the moving pivot hinge after every 40 hours of use.

For Your Records

Complete the information below and save for future reference.

Model and Serial Number

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Date and Place Purchased

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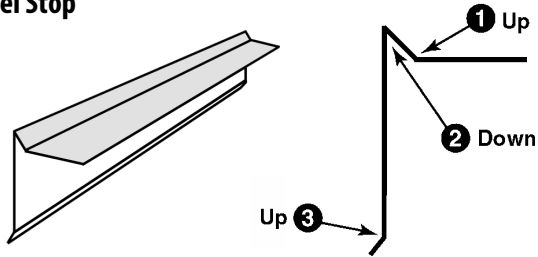
Specifications

ITEM #	PRODUCT	LENGTH		WORKING WEIGHT		CAPACITIES
		Feet	Meters	Pounds	Kilograms	
11017	MAX-I-MUM XL Commercial Bender System	8' 6"	2,59 m	133 lbs.	60,1 kg	Aluminum: Up to .040 Galvanized steel: Up to 24 ga. Soft & annealed copper: Up to 32 oz. Stainless steel, ¼ hard: Up to 24 ga.
11018	MAX-I-MUM XL Commercial Bender System	10' 6"	3,20 m	158 lbs.	71,6 kg	
11019	MAX-I-MUM XL Commercial Bender System	12' 6"	3,81 m	190 lbs.	86,0 kg	
10997	MAX-I-MUM XL Commercial Bender System	14' 6"	4,42 m	217 lbs.	98,3 kg	
12261	Adjustable MAX Cut-Off with case	—	—	9 lbs.	4,1 kg	

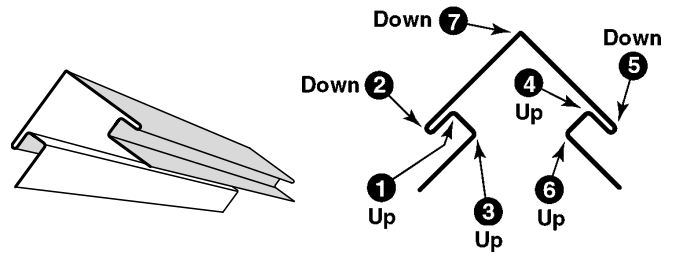
Examples of BASIC Shapes

NOTE: UP and DOWN refers to the clad, painted or FINISH SIDE of the material as it is placed into the Bender.

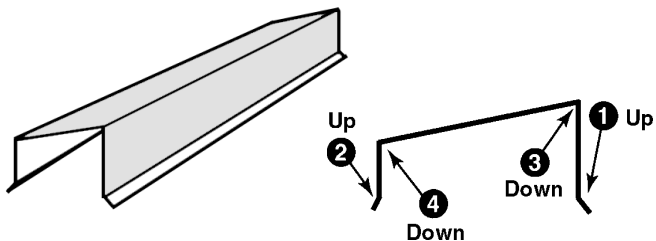
1. Gravel Stop



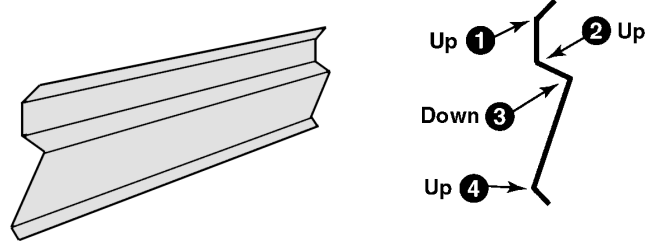
6. Outside Corner



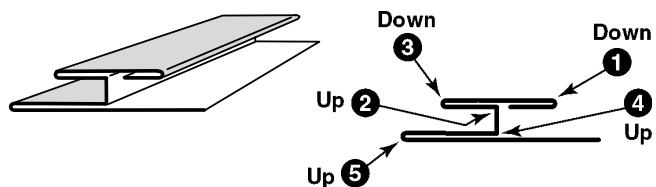
2. Coping Cover



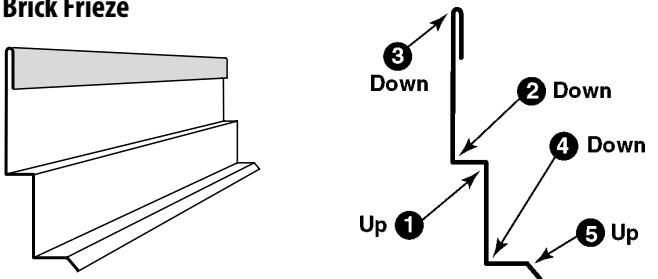
7. Counter Flashing



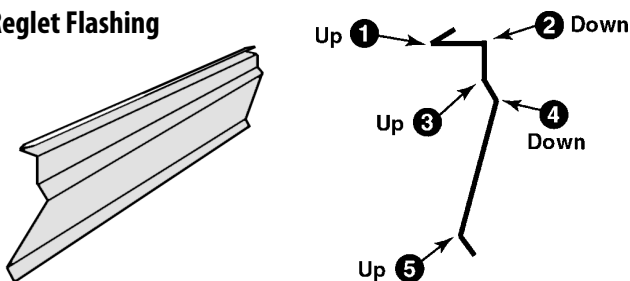
3. One Piece Soffit Mitre



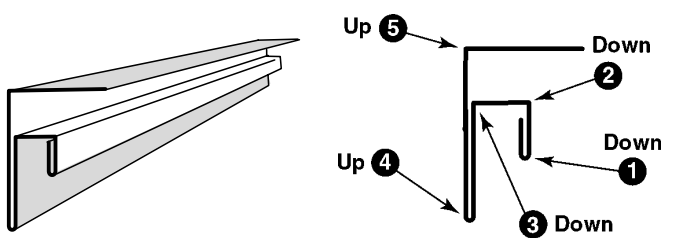
8. Brick Frieze



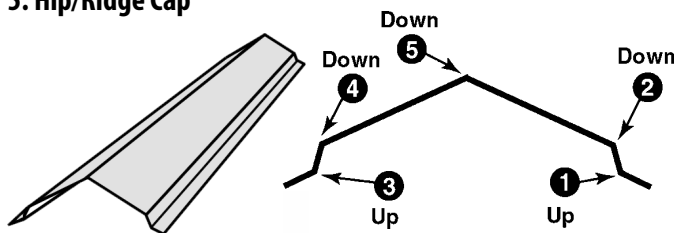
4. Reglet Flashing



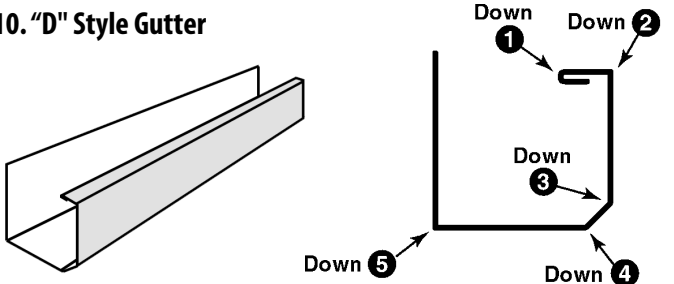
9. "F" Channel/Inside Corner



5. Hip/Ridge Cap



10. "D" Style Gutter



Setup for Adjustable MAX Cut-Off and Parts

LIST OF PARTS:

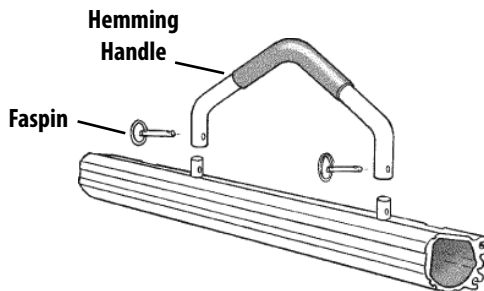
- (1) Adjustable MAX Cut-Off,
- (2) Material Stop Kit #11404,
- (2) Coupling Nut Kit #11420,
- (1) Storage/Coupling Nut,
- (1) Hinge Clip Kit #11413,
- (1) 10-24 x 5/8" Phillips screw.

Tools Needed for Initial Set Up:

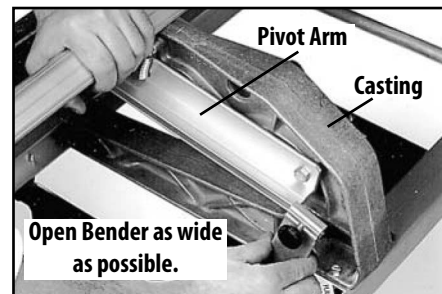
hammer, punch or nail set,
9/16" wrench, Phillips screw driver.

IMPORTANT! Read this safety information before using product.

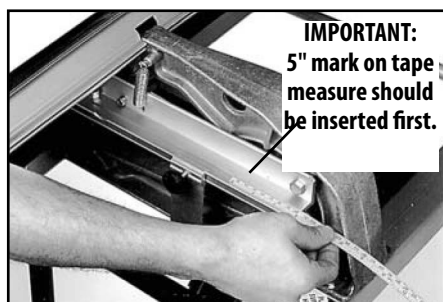
1. Always keep hands and fingers clear of the knives during all phases of use.
2. If using both hands to push tool through material, ensure hands are not in the path of the exiting material as it leaves the rear area of the tool.
3. Remove cut-off from anvil prior to bending material. Failure to do so can cause the tool to fall from brake resulting in tool damage or personal injury to user.
4. Never use tool to cut material not firmly clamped in brake.



- 1 Disconnect the Hemming Handle from your Bender by releasing the Faspins. This will allow the Bender to fully open making it easier to slide Cut-Off Stops onto the Pivot Arms.



- 2 Slide material stop onto Pivot Arms from rear as shown. **Note:** Recommended locations are on the second castings in from each end of your bender.



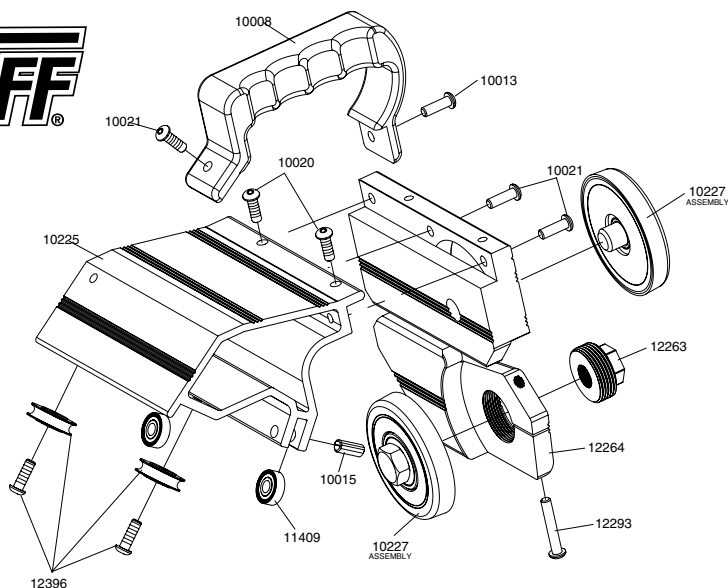
- 3 Slide measuring tapes into Pivot Arm slots from rear of Pivot Arm till they stop. Tape measures take into account 1½" difference between the bending edge and the shear point of Cut-Off for accurate cuts.



- 4 Secure the tape measures in place by "punching" down the edge of the pivot arm onto the tape measure. Use a standard nail set or punch.

Adjustable

MAX CUT-OFF®



* This kit replaces the Track Bearing Kit 11393. Both are still available for purchase.
** Please contact Customer Service if these parts need to be replaced.

Item#	Description
10225	Bridge
10008	Handle
12264	Adjustable MAX Cut-Off Body
11409	Cut-Off Guide Bearing Kit (2) Guide Bearing 10016 (2) 5/16" Roll Pin 10015
12396	Flange Track Bearing Kit* (2) Wide Flange Track Bearing 12334 (2) 1/4-20 x 5/8" Hex Button Hd Screw 12364
11393	Track Bearing Kit (not shown) (2) Track Bearing 10012
10021	1/4-20 x 1" Hex Button Hd Screw
10020	1/4-20 x 5/8" Hex Button HD Screw
10013	1/4-20 x 1-1/4" Button Hd Screw
10227	MAX Knife Assembly** Knife (10226), Bearing (10231) Nut (10232), .125 Shim
10349	Coupling Nut (hook, not shown)
10519	1/4-20 X 3/4" Hex Wash Hd Screw (not shown)
11404	Material Stop Kit (not shown) (2) Material Stop 10740 (2) 1/4-20 Knurled Knob 10776 (2) Cut-Off Tape Measure 10023
12263	Adjusting Nut
12293	1/4-20 X 1 1/2 Socket Head Cap Screws

MAX Snap Stand and Wheel Kit Setup



Figure 1A



Snap Button locations when legs are closed.

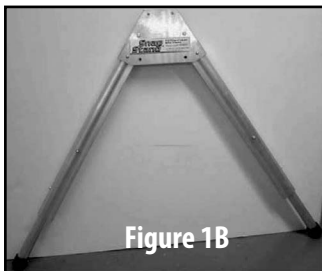
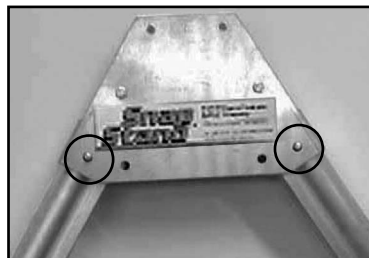


Figure 1B



Snap Button locations when legs are open.

STEP 1

To open each Leg Set, push in on the snap button and move each leg outward to the working position. Figure 1A above shows the leg set as shipped while Figure 1B shows the leg set open (working position). Make sure button snaps out to lock each leg.

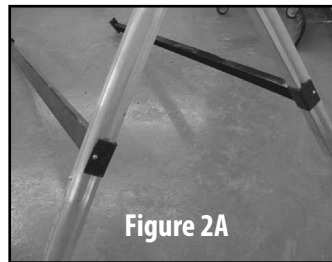


Figure 2A

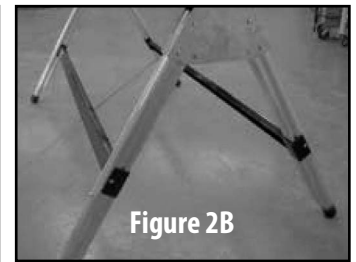


Figure 2B

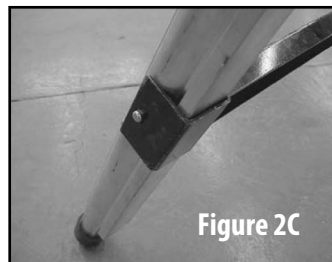


Figure 2C

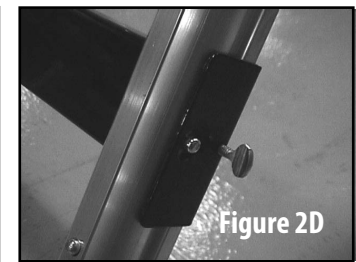


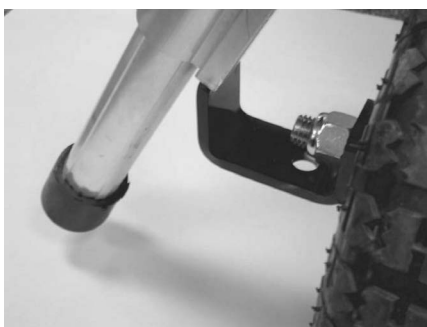
Figure 2D

STEP 2

Attach the Cross Braces to the Leg Sets. With the snap button of the Leg Set pointing to the outside, snap the Cross Braces into position. See Figures 2A and 2B above.

Be sure the C-shape of the Cross Brace is mating the leg as shown in Figure 2C above. After the Cross Braces are Locked in place add Spade Screws at each end. See Figure 2D above.

Attaching Wheel Kit (Optional)



STEP 1

Insert the wheel assembly into the leg of the Snap Stand as shown in the figure above. Tap the bracket with a hammer to wedge it tightly into the leg. Repeat this process for the other leg.



Use one of these positions to stop the stand from rolling.

STEP 2

To prohibit the stand from rolling on the wheels, lock the leg extensions into one of the bottom two locking positions. See figure above. If the leg extensions are in one of the other 3 positions, the wheels are in contact with the ground and are free to roll.

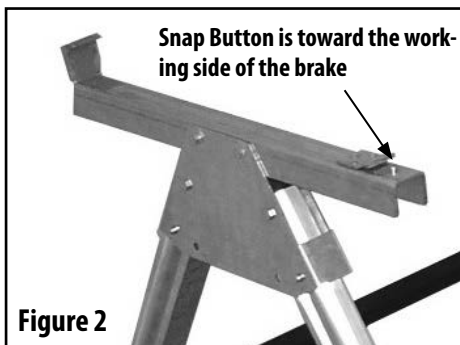
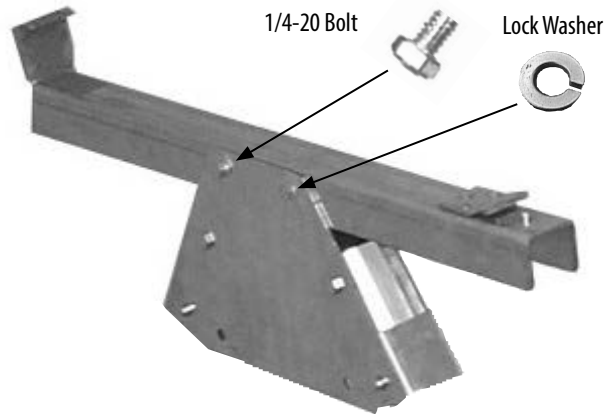
STEP 3

To remove the wheel assembly, tap the bracket downward with a hammer to disengage.

Installing a MAX Brake on MAX Snap Stand

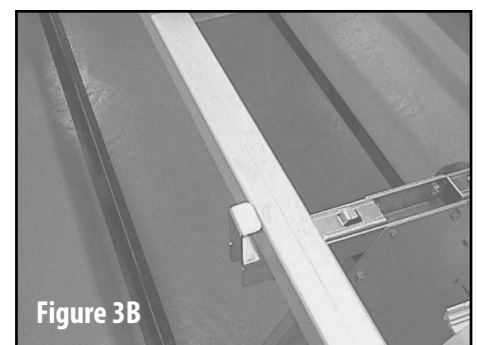
STEP 1

Using the 1/4-20 bolts and lock washers provided, fasten the brake mounts to the Leg Set.



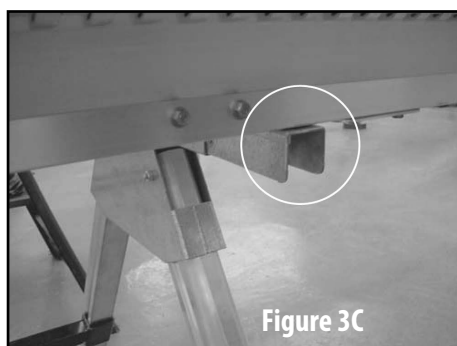
STEP 2

The snap buttons will be toward the working side of the brake. Repeat Step 1 for the other Leg Set. Be sure both ends of the Snap Stand are going the same direction (with the snap buttons on the same side). See Figure 2 above.

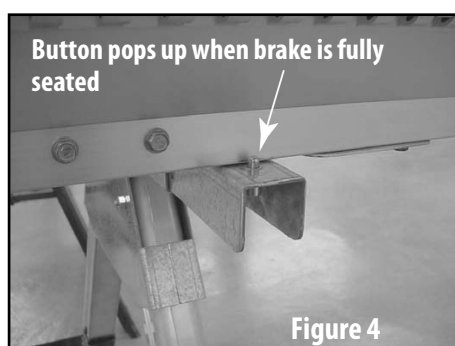


STEP 3

Place the brake on the assembled Snap Stand with the Back Rail of the brake clearing the adaptor hook as shown in Figures 3A and 3B above.



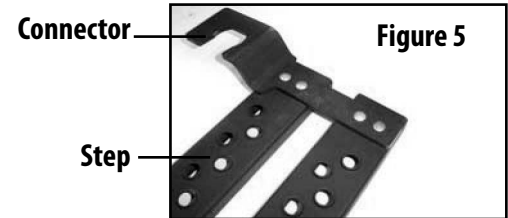
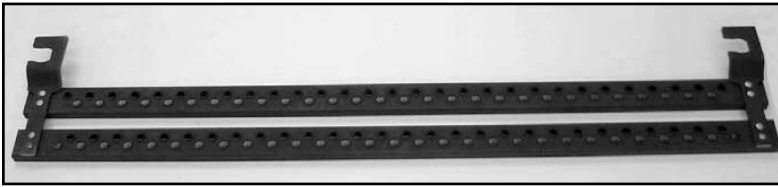
The snap button will be covered by the fixed hinge of the brake as in Figure 3C above.



STEP 4

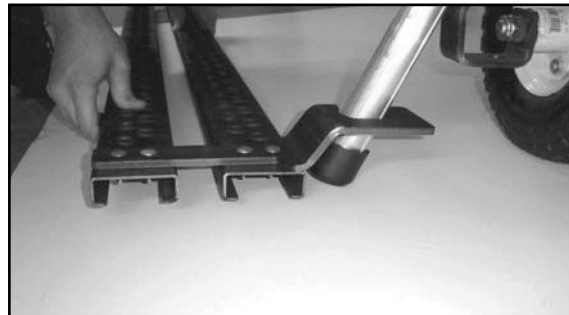
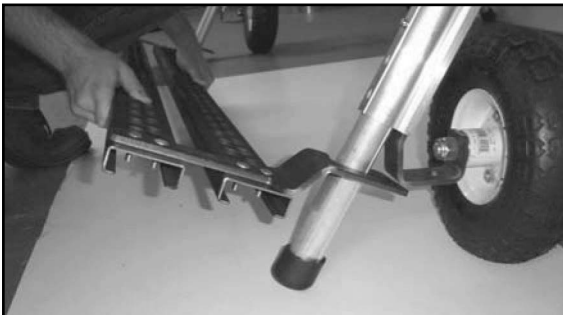
Push the brake firmly rearward into the adaptor hooks. The snap buttons by the front clips will pop up and secure the brake on the Snap Stand. See Figure 4 above. The brake is now ready for use.

Attaching the Counter Balance Assembly



STEP 1

Attach the Connectors to the Steps using the carriage bolts, lock washer and nuts provided. The square portion of the carriage bolt will fall into the square holes that are punched in the Connector. Tighten securely using a 7/16" wrench. See figure 5 above for Connector orientation.



STEP 2

To attach the Step Assembly to the Snap Stand, hold the assembly at an angle as shown and slide both connectors leftward over both legs of the Snap Stand as far as they will go. Allow the connectors to slip down the legs until the steps are flat and touching the ground. The connectors should be gripping the front and back of each leg. Standing on the steps while bending will lock the connectors in place on the legs.

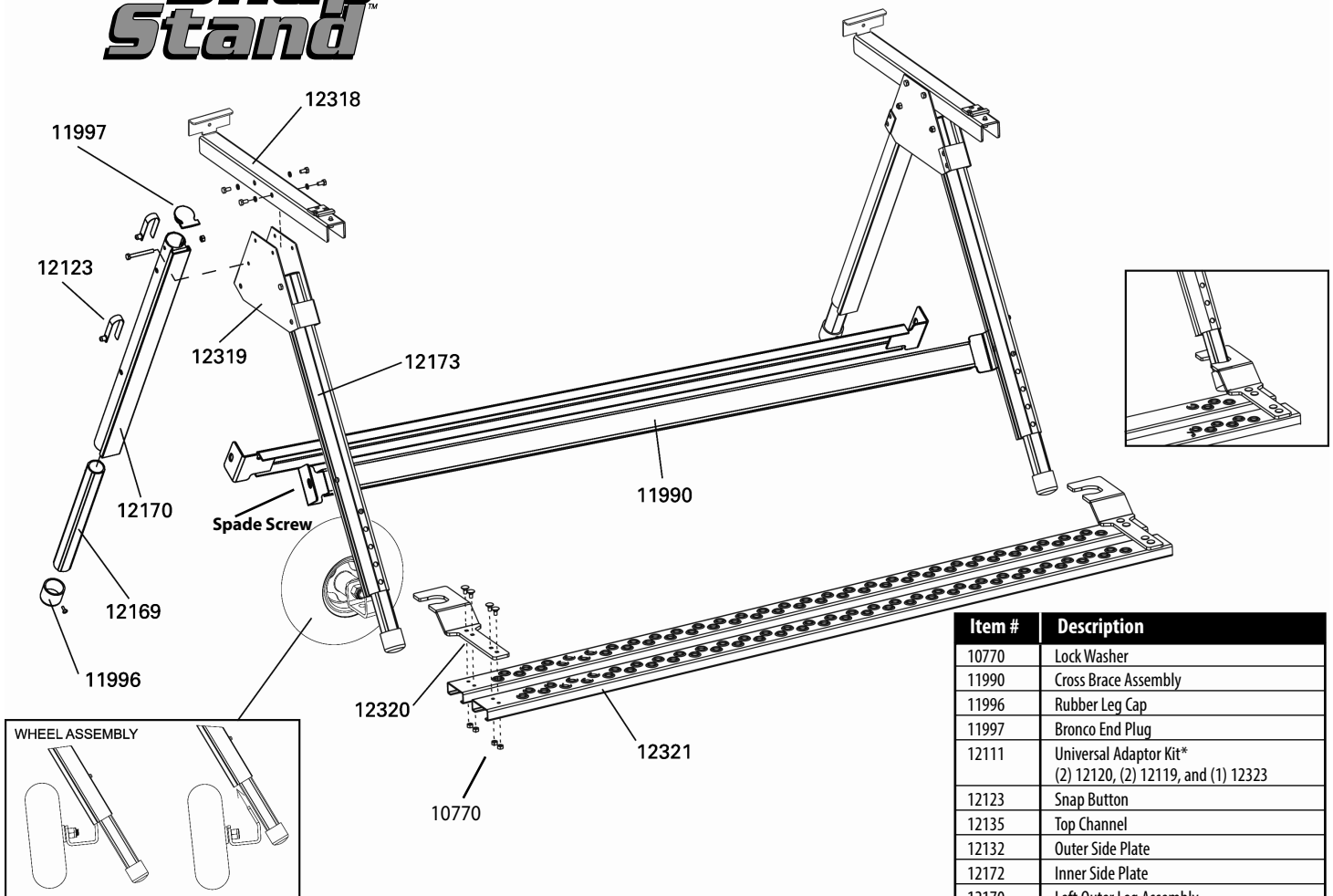
Removal is the reverse of assembly. Lift up on the steps to release them from the legs, and slide the assembly to the right until the connectors are free of the legs.

Removing a Brake from MAX Snap Stand

1. Removing the brake from the Snap Stand is essentially the opposite of attaching it to the stand.
2. Lifting the Moving Hinge, depress the snap button and pull the brake forward far enough to hold each snap button down.
3. Be sure the box rail is out of the Rear Clip. The brake can now be removed from the stand.
4. Reverse Steps 2 and 1 to disassemble the stand for transport.

MAX Snap Stand Parts List

**max Snap
Stand™**



Item #	Description
10770	Lock Washer
11990	Cross Brace Assembly
11996	Rubber Leg Cap
11997	Bronco End Plug
12111	Universal Adaptor Kit* (2) 12120, (2) 12119, and (1) 12323
12123	Snap Button
12135	Top Channel
12132	Outer Side Plate
12172	Inner Side Plate
12170	Left Outer Leg Assembly
12173	Right Outer Leg Assembly
12169	Inner Leg Assembly
12120	Front Universal Adaptor
12318	MAX Adaptor Bracket Assembly
12321	Counter Balance Step
12320	Counter Balance Step Connector
12322	MAX Snap Stand Parts Bag



TapcoTools.com
800-521-8486

Manufactured under one or more of the following U.S. Patents:

3,161,223	4,321,817	4,651,553	4,489,583	4,493,200	4,445,356
4,372,142	4,766,757	3,817,075	4,557,132	4,240,279	4,671,094
3,482,427	4,494,397	3,559,444			
5,343,728	5,353,620	5,505,069	Other U.S. & Foreign Pats. Pend.		

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