

The following procedures will convert any model B2000 to the latest electrical circuit control system. Models manufactured prior to 1993 will require a change to the molex connectors using the jumper wires enclosed.

A BMK3 assembly consists of the entire new circuit control mounted in a new rear handle. The Power cord and pendant control are not included. Those items must be removed from the bender and installed into the new BMK3 handle. Figure 1.

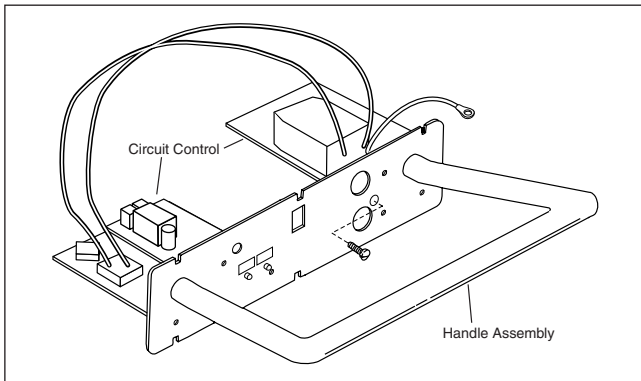


Figure 1. BMK-3 Assembly

⚠ WARNING: The power cord must be unplugged prior to working on the electrical circuits of the B2000 Bender.

1. Remove the six hex head screws, which mount the handle to the bender frame.

⚠ CAUTION: Once the mounting hardware is removed hold the handle to prevent it from falling. If the handle falls out of the frame it will damage the wiring harnesses.

2. Remove the four hex head bolts and two mounting brackets, which secure the rear handle to the bender frame.
3. Slide the handle assembly partially out of the bender frame. Disconnect the wire harness connectors from the printed circuit board. Units manufactured prior to 1993 will have two rectangular connectors for the harnesses and will require jumper wires to convert the harnesses. Units from 1993 to 2000 will have the current square connectors and do not require jumper wires.
4. Remove the power cord and pendant cord from the old handle assembly. Install these items into the BMK3 handle using the same hardware.
5. Plug the harness connectors into the correct receptacles on the printed circuit board.

6. Position the handle (BMK3) in the bender frame. Check the wire harnesses to be sure they are clear of the sprockets. Place the retaining brackets over the handle and loosely attach the mounting screws.
7. Plug in the power cord. Using the toggle switch check bender functions for bend, return, and jog. If all functions are working, install the six hex head screws securing the handle to the frame. Tighten the four screws, which secure the handle brackets. Figure 2.

NOTE: If the entire electronic control, handle assembly and cords are to be replaced order part number DA7040900.

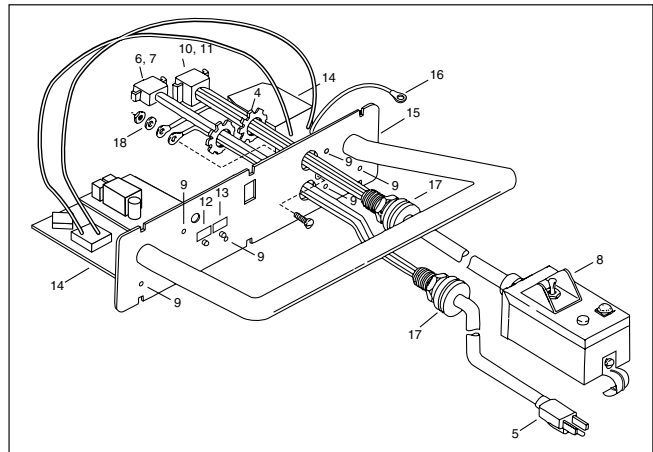


Figure 2. Handle and Circuit Control Assembly

Item No.	Part Number	No. Req'd	Description
DA7040900 INCLUDES:			
4	CJ458885	2	Locknut
5	CM178647	1	Plug Assembly
6	CM32006	1	Receptacle, Power Cord
7	CM25061	2	Pin, Cord Receptacle
8	CN982900W	1	Pendant Station Assm (Fig.8)
9	CW401028	6	Capscrew
10	DA6152006	1	Receptacle, Pendant
11	CM27061	8	Pin, Receptacle
12	DA6987026	1	Decal, High Voltage
13	DA6988026	1	Decal, Low Voltage
	BMK3	1	Relay Ctrl Circuit Assm (Fig.9)
			Includes: 15, 14, 9
15	DA7041900	1	Handle Assembly
16	DA7046900	1	Wire, Jumper
17	F1550	2	Grip, Cord
18	M231108	1	Lockwasher

**Item 4 is packed with item 5 loose.
Item 7 is packed with item 9 loose.
Instructions provided for assembling loose connectors.**