

# SERVICE BULLETIN SB-271



## 855-M2 EPROM Replacement Part Number 500 4073.1

### Purpose:

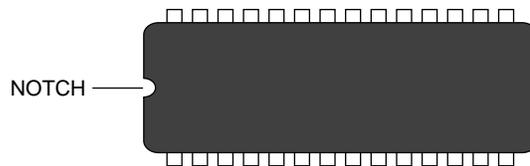
This procedure describes how to change the EPROM chip of the 855-M2 Smart Bender (S/N ABL0001 through ABL0420) to upgrade the bender control program. The new program improves bend accuracy and provides additional interlocks between the large roller supports and the bending shoes.

### Materials:

Flat Blade Screwdriver or 5/16" Nut Driver  
Grounding Strap  
Chip Puller  
New EPROM (GL P/N 918 6832.7 Ver 3.50)

### Procedure:

1. Turn off the bender and unplug it.
2. Remove the round top cover of the bender. Remove the two screws from each end of the cover.
3. Attach a grounding strap to your person and to a bare metal bracket or screw inside the bender. This will help minimize damage to the circuit due to electro-static discharge.
4. Locate EPROM chip on the I/O board (reference designator U4 on I/O silkscreen). The white label on the chip should read "918 6832.7 VER 3.10" where Ver 3.10 is the software revision.
5. Take note of the orientation of the chip relative to the silkscreen of the I/O board. The small notch in the chip lines



- up with the notch in the socket and the marking on the silkscreen.
6. Carefully remove EPROM chip from its socket using an appropriate chip puller. Place the chip in an ESD protected package. Please return it to the factory for reprogramming.
7. Carefully insert new EPROM into the socket. The white label on the chip should read "918 6832.7 Ver 3.50." Be sure that the chip orientation is proper; the notch on the chip should line up with the notch in the socket and the marking on the silkscreen of the I/O board.
8. Check that none of the legs to the EPROM chip are bent.
9. Disconnect the grounding strap from the bender.
10. Replace the top cover to the bender. Attach it with the four screws.
11. Check that the bender is turned off. Plug in the bender.
12. Plug in a deluxe pendant if available.
13. Turn on power to the bender.
14. At power on, the deluxe pendant will display the software version of the new EPROM, version 3.50. If the pendant indicates a different software version, please contact Greenlee.

### IMPORTANT:

"ACCURACY ADJUST ANGLES" will all be cleared when the new software is installed.