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P065

12TON AIR / HYD

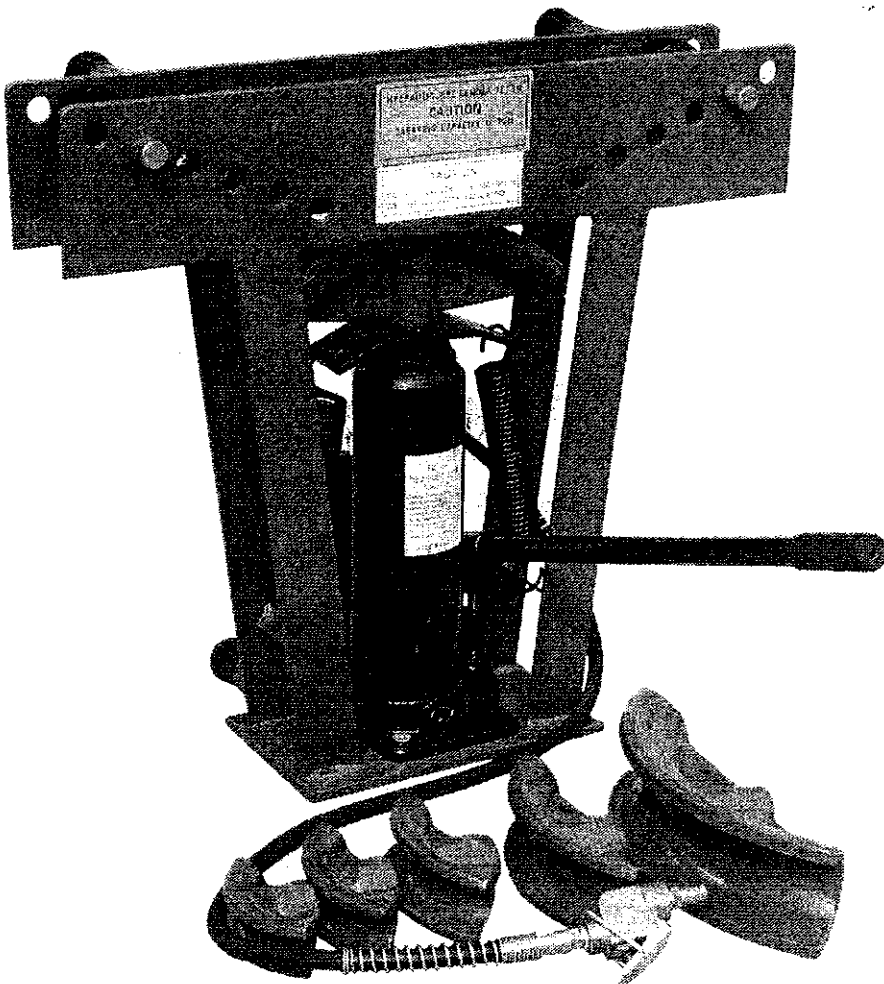
PIPE BENDER

OPERATION & PARTS MANUAL

18-08-2007

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12TON AIR/HYD PIPE BENDER



Assembly and Operation Instruction

Operation

The Pipe Bender is designed to bend water pipe and heavy gauge galvanized pipe used in commercial applications. When bending conduit or thin walled pipe, you may experience problems with kinks or creases. To help limit the problem, fill the pipe with sand and cap both ends, before bending.

Set up

1. Place the Pipe Bender on a solid, flat, level workbench. Pipe Bender must always be clamped or bolted down to the workbench.
2. Select the Bending Die (#11 thru #16) that matches the size of pipe you want to bend. Each Die is stamped with the size.
3. Place the Bending Die (#11 thru #16) onto the 12Ton Air/Hyd Bottle Jack (#8).
4. Depending on the Size of the pipe you wish to bend, the Rollers (#3) might need adjustment.
 - A. Remove both Cotter Pins (#4). Set Aside
 - B. Individually, remove a Roller Shaft (#7) and move the Roller (#3) to the desired hole in the Frame (#1). Repeat on other side.
 - C. One at a time, fully slide the Roller Shaft (#7) through the holes in the Frame (#1) and the Roller (#3). Repeat on other side.
 - D. Insert both of the Cotter Pins (#4) through the Roller Shafts (#7).
5. Slide the Pipe you want to bend, through the Pipe Bender on top of the Bending Die (#11 thru #16). Make sure the top of the pipe rests against the bottom of the Rollers (#3).
6. Using the slotted end of the Handle (#10), tighten (clockwise) the Bottle Jack Relief Valve.
7. Insert the Handle (#10) into the 12Ton Air/Hyd Bottle Jack (#8).Crank it up and down to raise the Jack and bend the pipe.
8. After bending pipe to desired angle, remove the Handle (#10) from the Jack and loosen the Relief Valve (counterclockwise). The ram of the Jack will lower. The pipe will release from the Pipe Bender. Carefully remove the pipe.

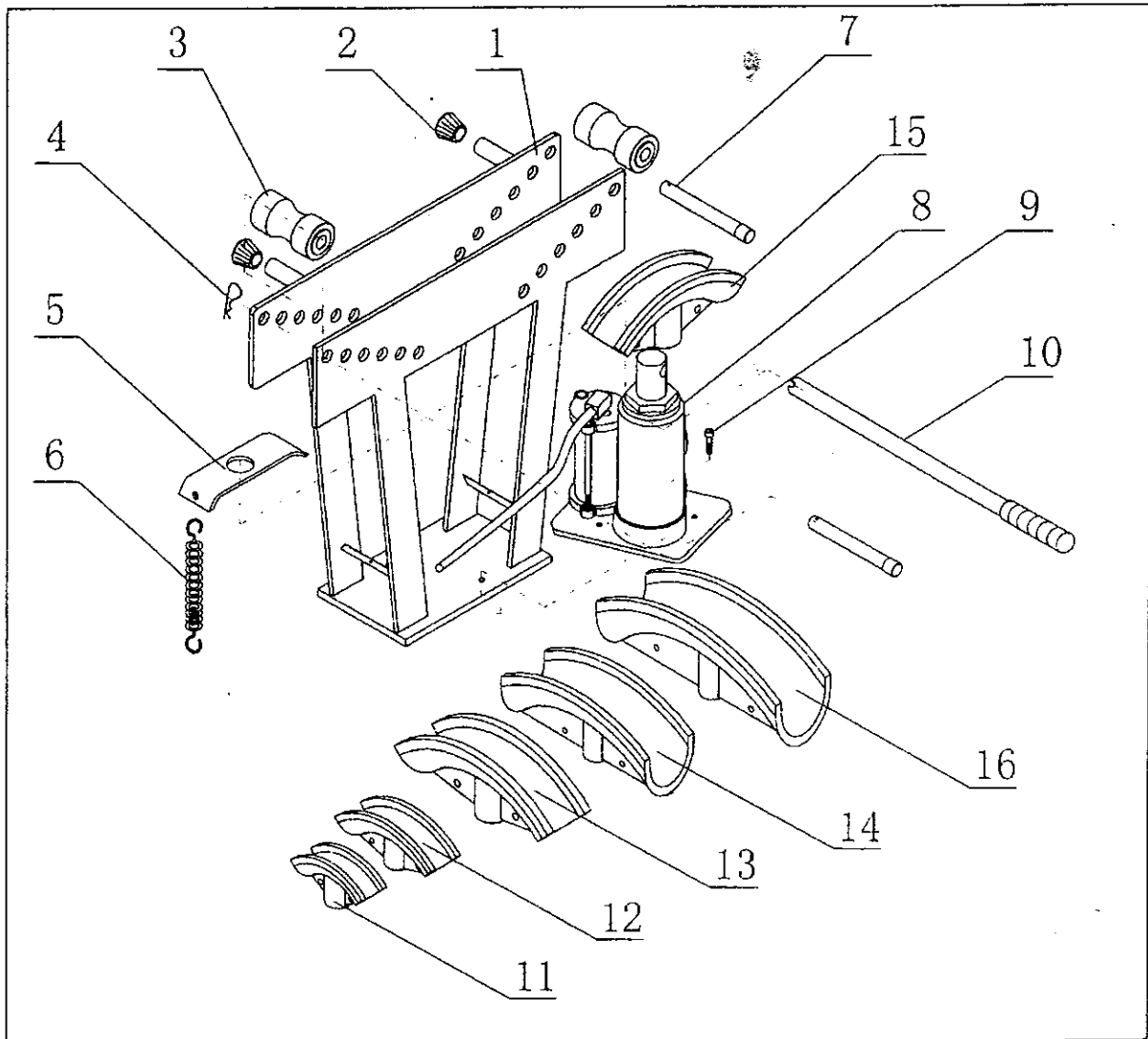
Warning

- ▲ **12TON LIMIT.** Do not exceed the maximum limit of the bottle jack.
- ▲ **KEEP WORK AREA CLEAN.** Cluttered areas invite injuries.
- ▲ **KEEP CHILDREN AWAY.** All children should be kept away from the work area. Don't let them handle tools.
- ▲ **TWO PERSON OPERATION.** For safety, when moving the Pipe Bender or bending large pieces of pipe, always use two people. When bending large pipe, one person is needed to balance the pipe in the bending dies, while a second person cranks the bottle jack's handle.
- ▲ **AVOID MOVING PARTS DURING OPERATION.** Keep fingers and hands away from rollers, bending dies and all moving parts.
- ▲ **STORE IDLE EQUIPMENT.** When not in use, jack should be stored in "closed" position and Pipe Bender stored in a dry location to reduce rust.

NOTES & TIPS

- ▲ The Pipe Bender is designed to bend water pipe and heavy gauge galvanized pipe that is used in commercial applications. When bending thin-walled pipe e.g. conduit, etc., you may have problems with the pipe becoming kinked or crease. To limit the amount of creasing, fill the pipe with sand and cap the ends before bending.
- ▲ The 12Ton Air/Hyd Bottle Jack (#8) should last for several years of use. The only parts that eventually wear out are the seals. If you notice hydraulic fluid leaking from the telescoping shaft (Ram) of the Jack, you need to install a Seal Kit.

Drawing & Parts List



| Part# | Description | Qty | Part# | Description | Qty |
|-------|---------------------|-----|-------|--------------------|-----|
| 1 | Frame | 1 | 9 | Bolt M8x16 | 2 |
| 2 | Support Bar Cover | 4 | 10 | Handle | 1 |
| 3 | Roller | 2 | 11 | 1/2" Bending Die | 1 |
| 4 | Cotter Pin | 2 | 12 | 3/4" Bending Die | 1 |
| 5 | Spring Plate | 1 | 13 | 1" Bending Die | 1 |
| 6 | Spring | 2 | 14 | 1-1/4" Bending Die | 1 |
| 7 | Roller Shaft | 2 | 15 | 1-1/2" Bending Die | 1 |
| 8 | Air/Hyd Bottle Jack | 1 | 16 | 2" Bending Die | 1 |