# 12 TON HYDRAULIC PIPE BENDER

# ASSEMBLY & OPERATION

PLEASE RETAIN THIS LEAFLET
FOR FUTURE REFERENCE

# Assembly
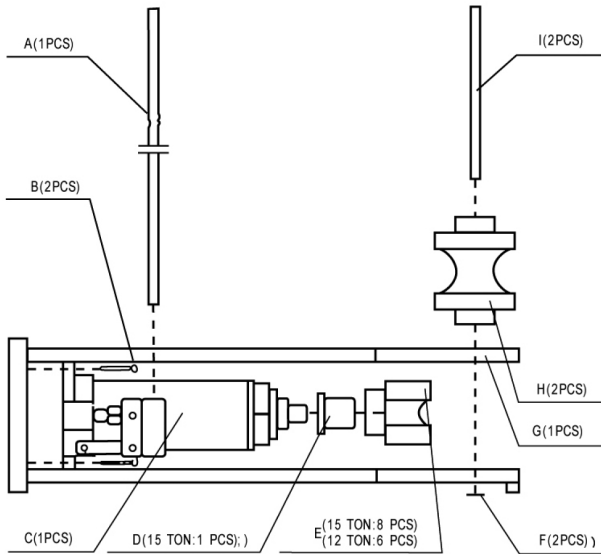


| | |
|---|---|
| A | Handle |
| B | Screw |
| C | Hydraulic jack |
| D | Cap |
| E | Shoe |
| F | Pin |
| G | Frame |
| H | Pipe support |
| I | Pipe support pin |

A(1PCS)

I(2PCS)

B(2PCS)

H(2PCS)

G(1PCS)

C(1PCS)     D(15 TON:1 PCS); )     E(15 TON:8 PCS)(12 TON:6 PCS)     F(2PCS) )

# Operation

1. Select required bending shoe and place on end of ram.

2. Place conduit in bending shoe and locate pipe supports at the correct holes in the frame. Insert pipe support pins.

3. To work with 12 ton hydraulic pipe bender. 90° can be made by 1/2" 3/4" 1" 1 - 1/4 1 - 1/2' and 2" bending shoes with bending shoe properly.

   Decide how many shots have to be made according to developed length. And make certain mark on the conduit. The number of marks depend on the size and thickness of conduit.

   Developed Length = 0. 01745 x Radius x Degrees.
   Formula for Making 90° Bends is:
     Radius x 1. 57 = Developed Length.
   Space= Developed Length Number

# Operation

5. Place handle over release valve and turn clockwise to close, insert handle into handle socket and pump to bend conduit.
   **CAUTION: Do not overfill the bending shoe.**

6. Turn release valve counter-clockwise and suitably return ram into cylinder. Shift conduit to the next bending position.

7. Move the one pipe support nearer pipe on bent end in proper alignment with pipe and make additional bends.
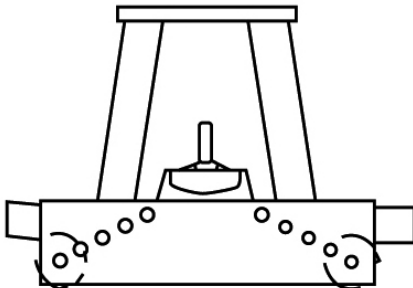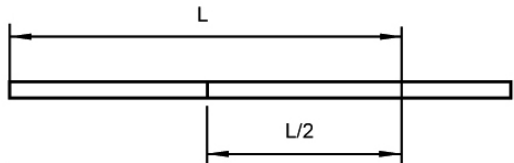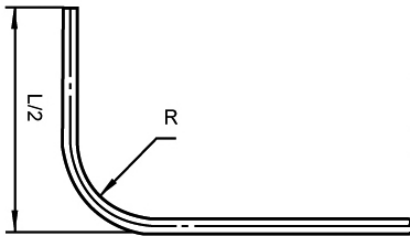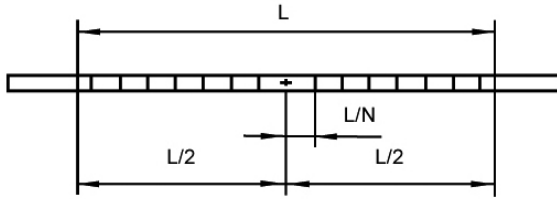
First Bend
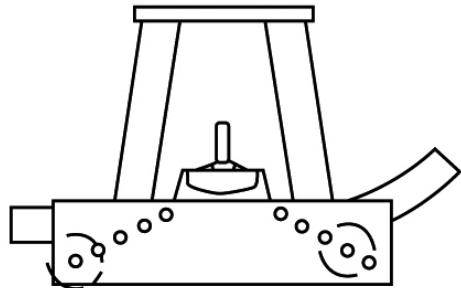
Succeeding Bends

# Technical Data

## The capacity of bending welded steel-tube of transporting fluid

| Nominal calibre | | Outer diameter mm | Wall thickness of steel-tube mm | Bended angle (a)° | Model | |
|---|---|---|---|---|---|---|
| mm | in | | | | | |
| 15 | 1/2 | 21.3 | 2.75, 3.25 | a<90 | TA1202 | TA1502 |
| 20 | 3/4 | 26.8 | 2.75, 3.25 | a<90 | | |
| 25 | 1 | 33.5 | 3.25, 4.00 | a<90 | | |
| 32 | 1-1/4 | 42.3 | 3.25, 4.00 | a<90 | | |
| 40 | 1-1/4 | 48.0 | 3.50, 4.25 | a<90 | | |
| 50 | 2 | 60.0 | 3.50, 4.50 | a<90 | | |
| 65 | 2-1/2 | 75.5 | 3.75, 4.50 | a<90 | | |
| 80 | 3 | 88.5 | 4.00, 4.75 | a<90 | | |

## The biggest capacity of bending steel - tube

| Outer diameter mm | Wall thickness of steel-tube mm | Bended angle (a)° | Model |
|---|---|---|---|
| 60 | 5 | a<90 | TA1202 |
| 88.5 | 5 | a<90 | |