12 TON AND 15 TON HYDRAULIC PIPE BENDER OPERATION INSTRUCTION

1. Selet 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.
4. To work with 15 ton hydraulic pipe bender. 90° can be made by 1/2″、3/4″、1″、1 – 1/4″、1 – 1/2″、2″、2 – 1/2″ and 3″ bending shoes with bending shoe properly. 90° can't be made by 2 – 1/2″ and 3″ bending shoes by one shot.

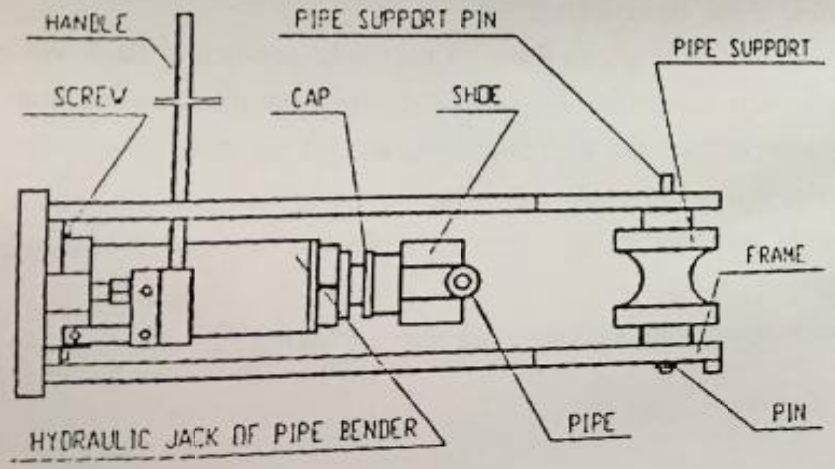
   Decide how many shots have to be made according to developed length. and make certain mark on the conduit. The number of marks depend on the size and thickness of conduit.

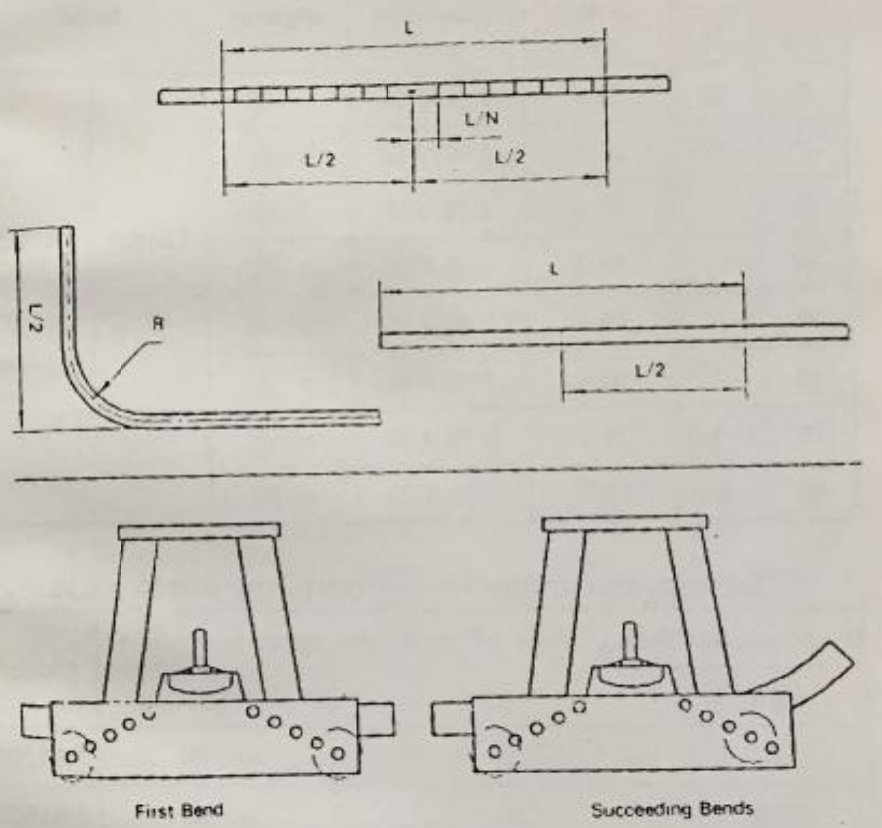
   Developed Length = 0.01745 × Radius × Degrees.

   Formula for Making 90° Bends is: Radius × 1. 57 = Developde Length.

   Space = Developed Length ÷ Number of Marks.

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 postion.
7. Move the one pipe support nearer pipe on bent end in proper alignment with pipe and make additional bends.





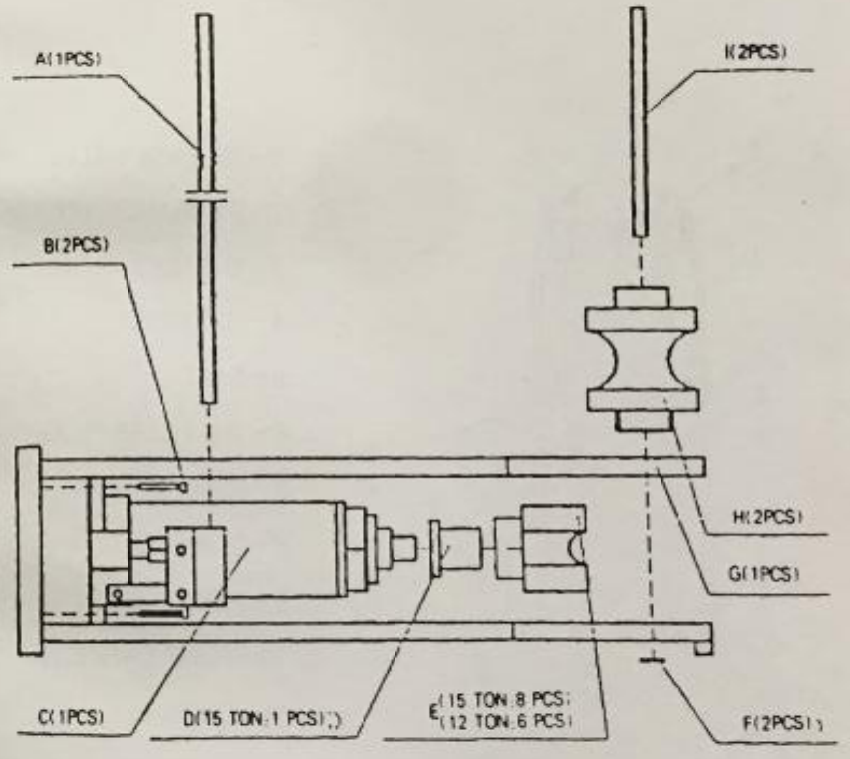
The capacity of bending welded steel-tube of transporting fluid

Nominal calibre		Duter daneter	Wall thdaess of steel-tube	Bended angle(a)	Model	
mm	in	mm	mm	°		
15	1/2	21.3	2.75.3.25	a≤90	TA1202	TA1502
20	3/4	26.8	2.75.3.50	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 - 1/2	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

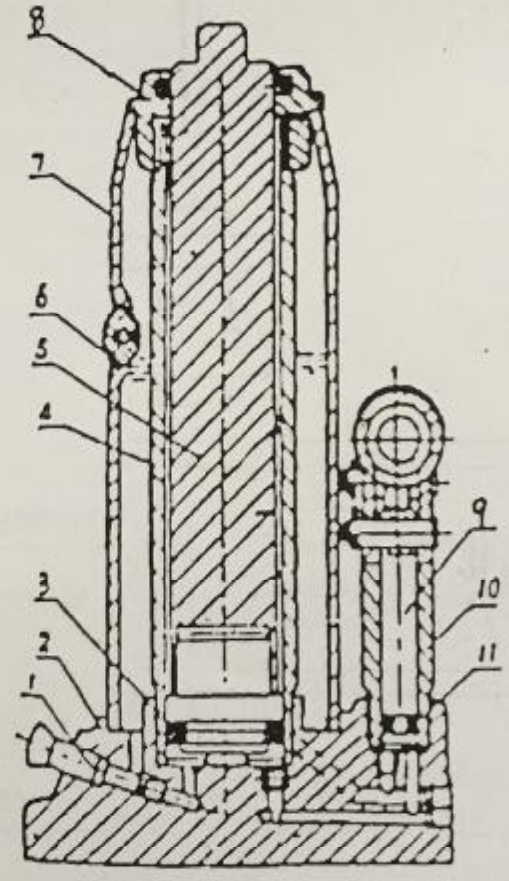
Duter daneter	Wall thdaess of steel-tube	Bending angle(a)	Model
mm	mm	°	
60	5	a≤90	TA1202
88.5	5	a≤90	TA1502

PIPE BENDER ASSEMBLY



A—HANDLE B—SCREW C—HYDRAULIC JACK OF PIPE BENDER D—CAP
E—SHOE F—PIN G—FRAME H—PIPE SUPPORT I—PIPE SUPPORT PIN

MAIN PARTS ON HYDRAULIC JACK OF HYDRAULIC PIPE BENDER



1 – RELEASE VALVE

2 – HYDRAULIC UNIT BODY

3 – O-RING

4 – CYLINDER

5 – RAM

6 – OIL FILLER PLUG

7 – RESERVOIR

8 – TOP NUT

9 – PUMP PISTON

10 – PUMP CYLINDER

11 – O-RING