

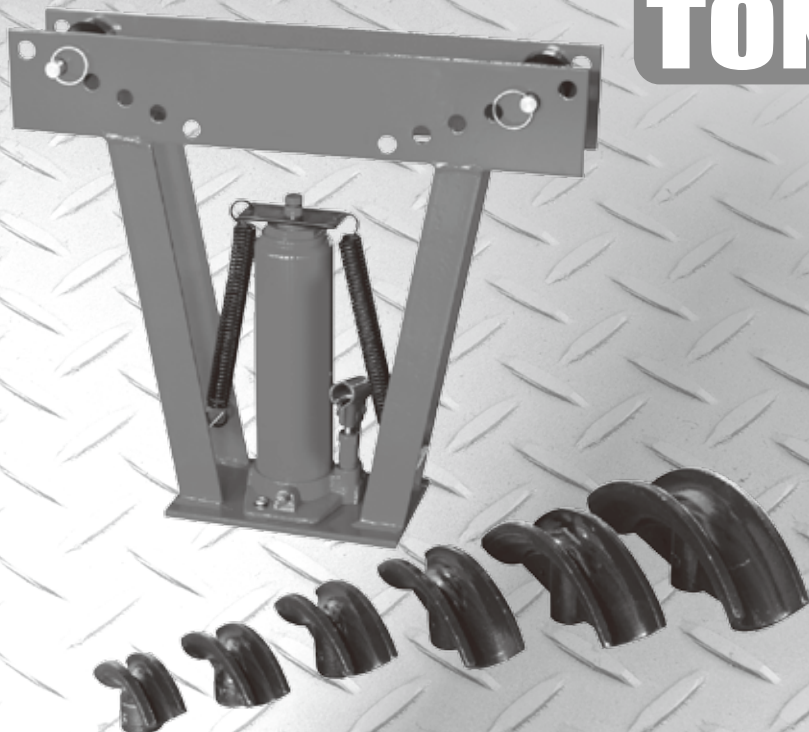


KING TONY

HYDRAULIC PIPE BENDER OPERATION MANUAL

NO.7CA0507S

12 TON



WARNING



Please wear proper safety gear while working.

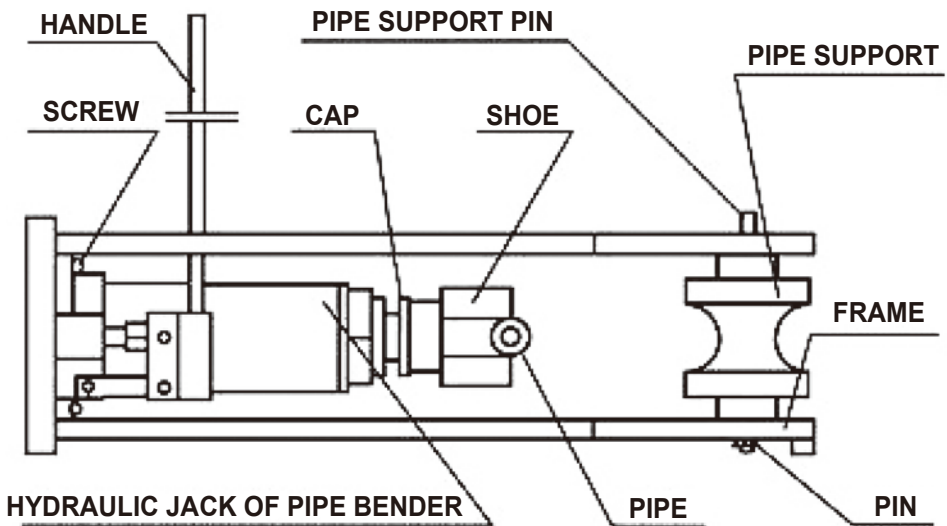


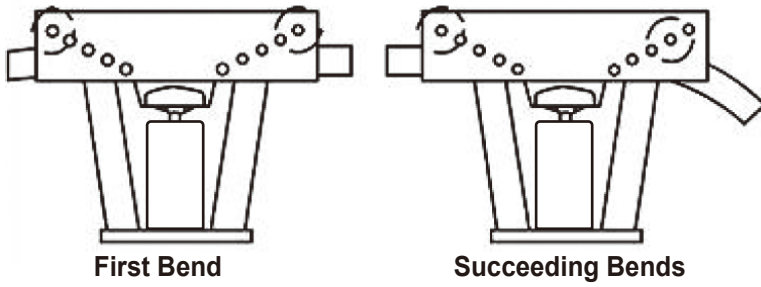
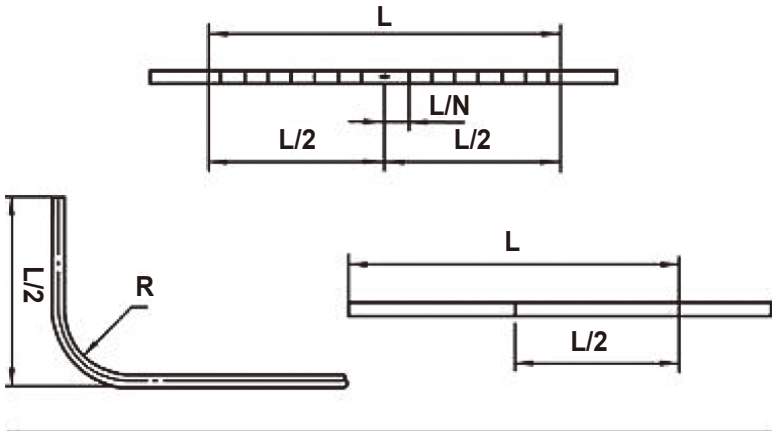
Enjoy your work

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.
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 = $0.01745 \times \text{Radius} \times \text{Degrees}$. Formula for Making 90° Bends is : $\text{Radius} \times 1.57 = \text{Developed Length}$. $\text{Space} = \text{Developed Length} / \text{Number of Marks}$.
5. Place handle over release valve and turn clockwise to close insert handle into handle socket and pump to 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.





The biggest capacity of bending steel-tube

Model	Outer Diameter	Thickness	Angle
7CA0507S	60	5mm	≤ 90

The capacity of bending welded steel-tube of transporting fluid

Metric System	Outer Diameter	Thickness	Angle
15	21.3	2.75	≤ 90
20	26.8	2.75	≤ 90
25	33.5	3.25	≤ 90
32	42.3	3.5	≤ 90
40	48	3.5	≤ 90
50	60	3.5	≤ 90



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