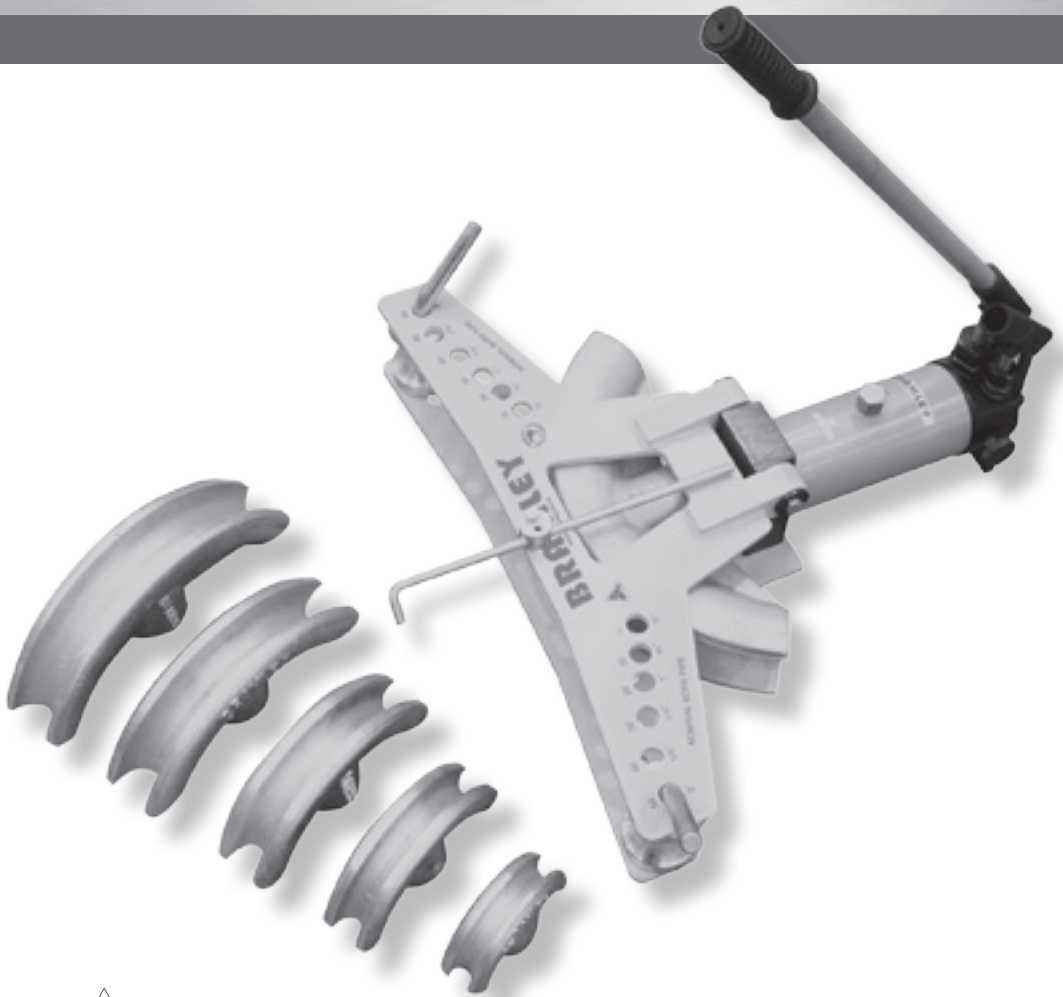


Safety/Operating Instructions

Bramley Model 024 Hydraulic Pipe Bender



BRAMLEY

Bramley 024 Hydraulic Pipe Bender

Thank you for purchasing the Bramley 024 Hydraulic Pipe Bender. This portable Pipe Bender is designed for bending up to schedule 40 pipe from 1/2" (15mm) to 2" (50mm NB).

The pipe bender features a 2-speed pump and a spring return allowing for quicker bending and easier operation.

The machine is supplied standard with;

- | | | |
|--|-------------------------------|----------------------|
| 1x Hydraulic Unit complete with bottom fixed frame and top pivoting frame. | 1x Bar Stop & Bar Stop Slide. | 1x 1.1/2" Former. |
| 2x Bobbins. | 1x 1/2" Former. | 1x 2" Former |
| 2x Bobbin Pins. | 1x 3/4" Former. | 1x Hydraulic Handle. |
| | 1x 1" Former. | |
| | 1x 1.1/4" Former. | |

Bending Operation

This machine is best used horizontal on a flat surface with plenty of room around it to allow for the pipe being bent (as shown at right).



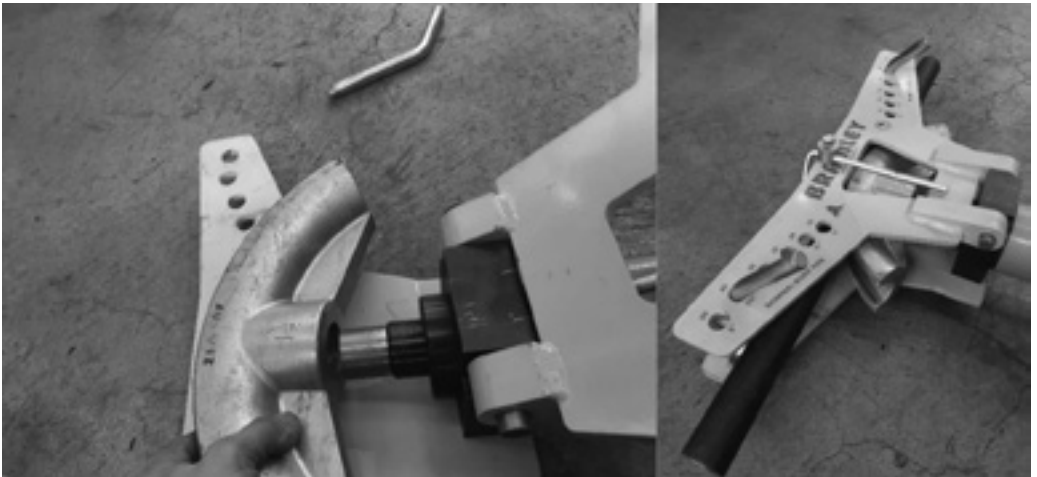
Before using the machine (pumping either pistons or retracting ram) open bleed/filler cap a turn to allow air to escape or enter the hydraulic unit. If the unit is pumped while filler/bleed cap is done up, the unit will simply stop working until you open this.



To retract hydraulic ram, open this valve about a half turn anti-clockwise. To pump hydraulic ram forward, close this valve by turning it clockwise hand tight. (Do not over tighten this valve as damage, or early failure will occur in valve seat).



Open the top frame and fit the correct former for the pipe being bent. Fit the pipe being bent and close top frame. Fit the Bobbin and Bobbin pins into the corresponding holes for this size former (if 1 1/2" former fitted the Bobbin and Bobbin pins must be fitted to the 1 1/2" hole).



Close the hydraulic valve and using either the fast or slow pistons pump the main ram and former against the pipe and bobbins. Before bend commences, check bend is in desired place. Repositioning is easy up until material bend is started. Bend material until desired angle is achieved. The stop can be set for multiple bends of the same angle. Note there is some bend back when ram is retracted so a slight over bend may be required.



If over time the ram fails to fully extend, or ram seems slow to move, check the level of hydraulic oil in the reservoir with the unit horizontal and the ram fully retracted, open the filler cap. The oil should be covering the cylinder inside unit. The hydraulic unit may need topping up with 32 grade hydraulic oil. (Fluid can be lost if filler cap is not nipped up after use and unit transported or tipped up in this state).

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