

Operating Instructions & Parts List

Bramley Electric/ Hydraulic Pipe Bender



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Precision and Mechanical Engineers
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Bramley Electric/Hydraulic Pipe Bender

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Thank you for purchasing the Bramley Electric/Hydraulic Pipe Bender. This portable Machine is designed for general-purpose use.

Figure 1 shows the Formers which are available with this Machine: 1/2", 3/4", 1", 1 1/4" 1 1/2" and 2" NB (15, 20, 25, 32, 40 and 50mm NB).

The Machine is designed to bend 1/2" to 2" (15 to 50mm) NB pipe to a maximum angle of 90°.

Operation and Assembly

1. Select the appropriate size Pipe Former for the pipe size that is to be bent and fit onto hydraulic ram between top & bottom plates.
2. Insert Pipe to be bent at appropriate location in the former.
3. Locate the two Support Bobbins in the appropriate designated positions on the outside of the pipe being bent.
4. Ensure that the oil filler Screw is loose allowing air to vent to the oil reservoir.
5. Ensure that the "Pressure Release Screw" located at the bottom left hand end of the hydraulic unit is firmly shut. (Clockwise rotation.)
6. Depress trigger switch located on the handle of the pump unit.
7. Keep trigger switch depressed until the desired angle of bend is achieved.
8. When the angle of bend is achieved, release the "Pressure Release Screw". The ram should retract by way of the internal retraction spring.
9. Remove the bobbins and then remove the bent pipe from the front of the machine.

Check oil at regular intervals. When topping up, ensure that the oil is free of any foreign matter. Check its level by lifting the front part of the unit by about 45 degrees and viewing in through the filler port. Use 32 Grade Hydraulic Oil (850 cc volume to fill).

The oil should reach the level of the filler port.

When the oil has been topped up, fit the Filler Knob in to the filler port loosely. In a near vertical position operate the pump unit. Let the ram extend for about 100mm. Then open the pressure release valve and ensure that the ram retracts fully.

The unit is now ready for full operation.

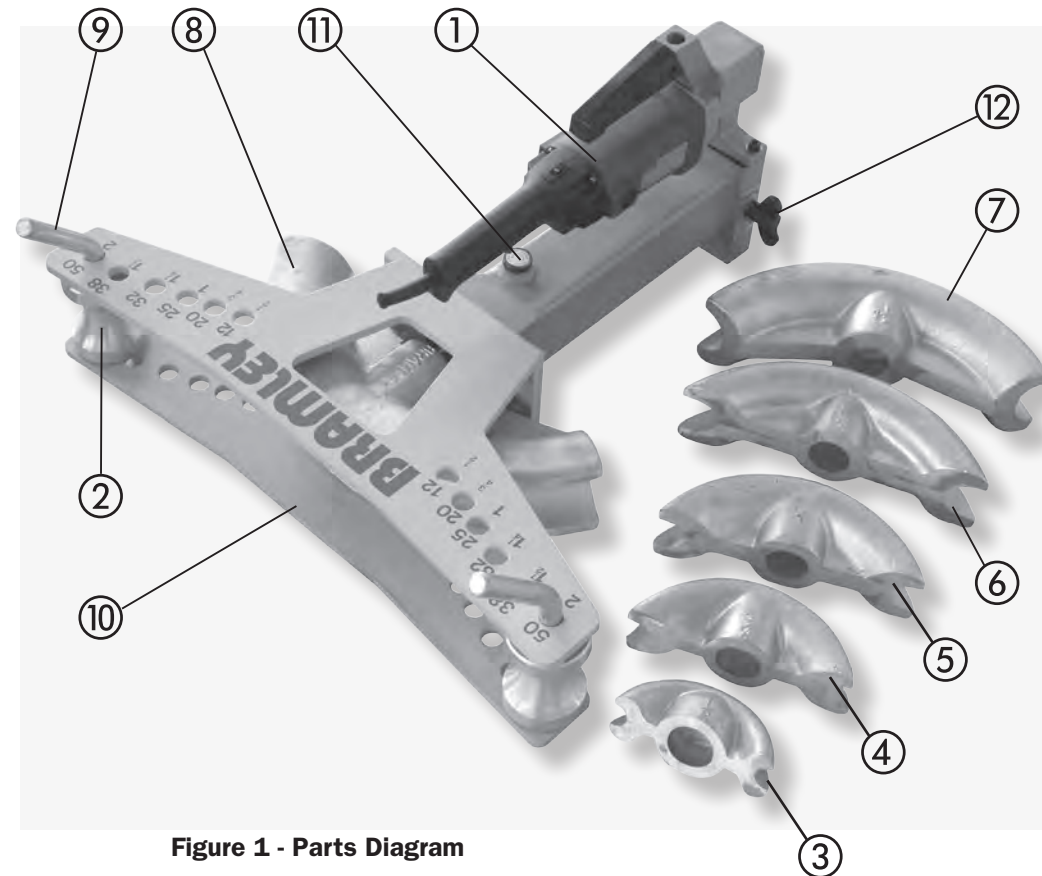


Figure 1 - Parts Diagram

| Ref No. | Part No. | Description | Centreline Radius of Bend | |
|---------|----------|---------------------------|---------------------------|-------|
| 1 | 22-05A | Motor & Ram | | |
| 2 | 22-10 | Bobbins | | |
| 3 | 22-11 | 1/2" (15mm) Pipe Former | 3" | 75mm |
| 4 | 22-12 | 3/4" (20mm) Pipe Former | 4" | 105mm |
| 5 | 22-13 | 1" (25mm) Pipe Former | 5 1/2" | 140mm |
| 6 | 22-14 | 1 1/4" (32mm) Pipe Former | 7" | 175mm |
| 7 | 22-15 | 1 1/2" (40mm) Pipe Former | 8" | 200mm |
| 8 | 22-16 | 2" (50mm) Pipe Former | 9 1/2" | 240mm |
| 9 | 22-09 | Bobbin Pins | | |
| 10 | 22-01 | Main Frame | | |
| 11 | | Oil Filler Hole | | |
| 12 | | Pressure Release Screw | | |