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How to use a manual hydraulic pipe bender

Image is not available forColor: 1 Install the mold: Choose a die based on the size of the pipe you want to bend. Remove the pivot pin die. Enter die in the die slot and insert the pin into the die to secure it. 2 Install the follower block: The size of the follower block must match the mold. Place the block next to the mould with enough tube space. Then take the tracking block needle and insert it into the main arm and the follower block. 3 Prepare the pipe: Take a pipe with a size corresponding to that of the mold and tracking block. Using a pencil or marker, mark randomly at the point where you want to start the curve. 4 Insert the pipe: The tracking block is kept free so that the height is adjusted when inserting the tube. Hold the valve between the adept block and the mold. Align the block vertically to the pipe, then insert the pipe into the machine. The mold will rotate outwards as you insert the valve. Once the pipe is in place, turn the die back into the correct position. 5 Install the U belt: The U belt holds the valve in position with the handle. It consists of a needle that corresponds to the size of the pipe and the adept block. Remove the strap needle. Pass the belt over the pipe and re-enter the needle. 6 Fix the drive pin: The drive pin blocks the pivot's arms to die, thus facilitating the bending process. Take the needle and throw it into the space between the arms and molds. 7 Align the pipe: Adjust the pipe so that the random mark that was previously made aligns with the front edge of the mould. You can achieve this by searching through one of the pin drive holes until the mark is visible. 8 Create tension in the pivot arms: Pivot arms are usually weakened. Put a little tension on the pivot's arms by pulling them. 9 Install the degree indicator: Take the pointer and place it at the end of the lug. The indicator consists of a crew of fingers. Use it to anchor the pointer to lug. Make sure the pointer rests on the grade ring and is aligned to zero degrees. At this point, you need to tighten the tensioning screw, which is located next to the mold. 10 Turn on the drive holder: arm the first notch of the drive holder into the sleeve at the end of the pivot arm. 11 Start the bending process: Pull the handle and the pivot arms will start to open. The mold will rotate and bend the valve. At the same time, the indicator will begin to indicate the measurement of curvature. As you bend the valve, engage the next teeth of the unit rack and work your way up to the last notch. 12 Reset bender: Once you have reached the last notch in the drive rack, you need to reset the bender. Complete the last half of the handle turn and hold it in the closed position. a little pressure on the handle and remove the anti-bow rear kit release lever. Then release the unit pin, allowing to become free. Put a little pressure on the release lever and reset the pivot arms. Place the unit needle in the next hole of the unit, keeping the arms in the reset position. Then you can continue the bending process. 13 Remove the pipe: Once you have got the curves you need, it's time to remove the pipe. Keep a little tension on the handle and detach the spring kit back. Balance the drive holder and handle in your path. Remove the needle from the unit and close the pivot arms. Loosen the tensioning screw, remove the U-strap needle and remove the valve from the appliance. The techniques used when bending pipes and tubes using pipe benders are quite simple. Although, there is a learning curve at every job, it can be greatly reduced by picking up clues from experienced technicians. The points mentioned below should help you overcome obstacles and perfect the art of bending pipe. Pipe Bending Tips When using a Bender pipe below are some form tips for pipe-bending experts that will help you achieve perfect bending: 1. When using a bender hydraulic pipe, make sure that the dimensions of the former and bender rollers are accurate for the size of the pipe. 2. Because the pipes are generally secured at one end, measure the length of the pipe, from the center. This will give you an accurate measurement. 3. Practice a few times until the perfect bending motion. A quick and fast move will give you a smoother bend. 4. Pipes when bent tend to spring back a bit. For the perfect amount of bending, it will be imperative for you to bend over the tube. Make sure you calculate the amount of spring back to be expected, and over bend the tube accordingly. It is difficult to unbend a tube over bent. So the percentage of spring back should be calculated accurately. 5. Lighter materials, such as aluminum and steel tubes tend to crimp when bent. This can be easily avoided by providing a firmer tube structure. The process is to fill the tube with water, and slowly add sand. The gentle touch of the tube will move the sand inside the tube, forcing the air bubbles to be released. This method cannot be used to bend heat-producing pipes. The heat will turn the water from the pipes into steam, causing the pipes to burst. When using a tube bender to bend pipes, it is important to pay attention to detail. Bending the tubes correctly will ensure that the pipes last longer and work brilliantly. An incorrectly folded pipe could cost a lot of money, and in terms of production. Therefore, the use of the correct processes pipe bending is imperative. Related to Woodward Fab Pipe Benders Blog Posts: Picture not available forColour: 1 Install die: Choose a die depending on the size of the pipe you want to bend. Remove the pivot pin die. 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