

Thank you for purchasing a Sealey product. Manufactured to a high standard this product will, if used according to these instructions and properly maintained, give you years of trouble free performance.

**! IMPORTANT: PLEASE READ THESE INSTRUCTIONS CAREFULLY. NOTE THE SAFE OPERATIONAL REQUIREMENTS, WARNINGS, AND CAUTIONS. USE THIS PRODUCT CORRECTLY, AND WITH CARE FOR THE PURPOSE FOR WHICH IT IS INTENDED. FAILURE TO DO SO MAY CAUSE DAMAGE AND/OR PERSONAL INJURY, AND WILL INVALIDATE THE WARRANTY.**

**1. SAFETY INSTRUCTIONS**

**1.1. GENERAL SAFETY**

- WARNING!** *Ensure Health & Safety, local authority and general workshop practice requirements are adhered to when using this equipment.*
  - ✓ Familiarise yourself with the application and limitations, as well as the potential hazards of the kit.
  - ✓ This kit is suitable for cutting/bending copper, brass or thin walled aluminium pipe. **DO NOT** use for cutting/bending steel pipe.
  - ✓ Maintain the kit in good condition (use an authorised service agent).
  - ✓ Replace or repair damaged parts. *Use genuine parts only. Unauthorised parts may be dangerous and will invalidate the warranty.*
  - ✓ Locate the kit in a suitable work area. Keep the area clean and tidy and ensure there is adequate lighting.
  - WARNING!** Always wear approved eye or face protection when using the kit.
  - ✓ Keep children and unauthorised persons away from the work area.
  - ✓ Secure the pipe to be cut, in a vice.
  - x **DO NOT** use the kit for any purpose other than for which it is designed.
  - x **DO NOT** use the kit if any parts are damaged or missing as this may cause failure and/or personal injury.
  - x **DO NOT** allow untrained persons to use the kit.
  - x **DO NOT** attempt to cut/bend piping when you are tired or under the influence of alcohol, drugs or intoxicating medication.
  - ✓ When not in use clean kit components, replace in case and store in a safe, dry, childproof area.
- Remember! The safe operation of a vehicle, or other equipment, may well depend on the quality of the bend/cut produced. Discard any pipe in which the bend/cut is malformed.**

**2. INTRODUCTION & SPECIFICATION**

Composite dies suitable for bending soft metal pipes, with diameters between Ø10mm and Ø22mm, up to 180°. Hand-held, ratchet action tool has interchangeable pipe guides. Tube cutter included. Supplied in carry-case.

|                                 |             |                   |                              |
|---------------------------------|-------------|-------------------|------------------------------|
| Pipe Bender Capacity: . . . . . | Ø10mm-Ø22mm | Dies: . . . . .   | 10mm, 12mm, 15mm, 18mm, 22mm |
| Tube Cutter Capacity: . . . . . | Ø3mm-Ø32mm  | Guides: . . . . . | 12mm, 15mm, 18mm, 22mm       |

**3. CONTENTS & PARTS LIST**

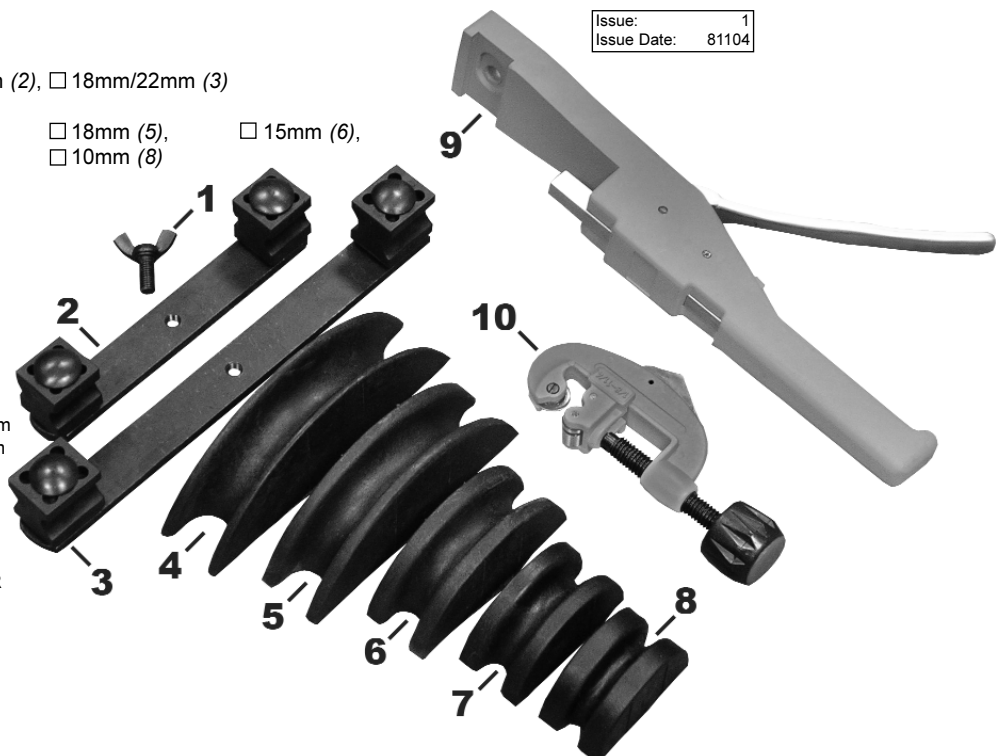
Check the content of the kit against the list below. If any item is missing or damaged, contact your supplier immediately.

**3.1 AK5061:**

- Wing Nut (1)**
- Guides:**
  - 12mm/15mm (2),  18mm/22mm (3)
- Dies:**
  - 22mm (4),  18mm (5),  15mm (6),
  - 12mm (7),  10mm (8)
- Tube Bender (9)**
- Tube Cutter (10)**

Issue: 1  
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| ITEM | PART NO.  | DESCRIPTION   |
|------|-----------|---------------|
| 1.   | AK5061.01 | WING NUT      |
| 2.   | AK5061.02 | GUIDE 12/15mm |
| 3.   | AK5061.03 | GUIDE 18/22mm |
| 4.   | AK5061.04 | DIE 22mm      |
| 5.   | AK5061.05 | DIE 18mm      |
| 6.   | AK5061.06 | DIE 15mm      |
| 7.   | AK5061.07 | DIE 12mm      |
| 8.   | AK5061.08 | DIE 10mm      |
| 9.   | AK5061.09 | TUBE BENDER   |
| 10.  | AK5061.10 | TUBE CUTTER   |



## 4. OPERATING INSTRUCTIONS

□ **WARNING!** Before using the bending/cutting kit ensure that you have read and understood the Safety Instructions in Section 1.

### 4.1 ASSEMBLY

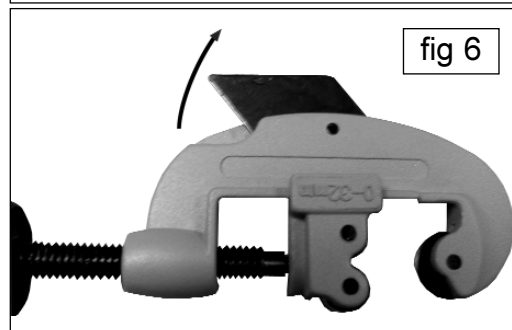
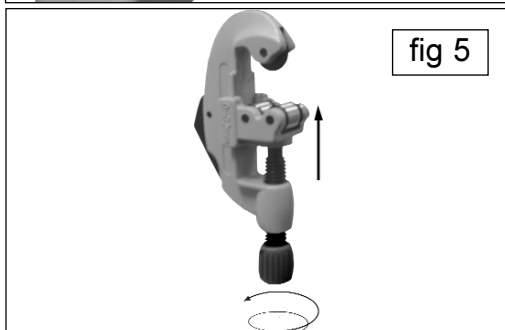
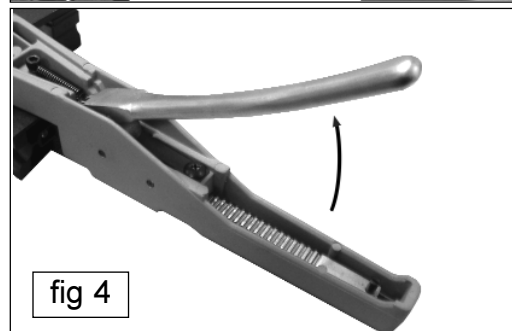
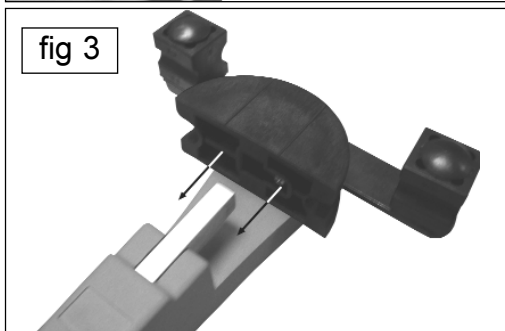
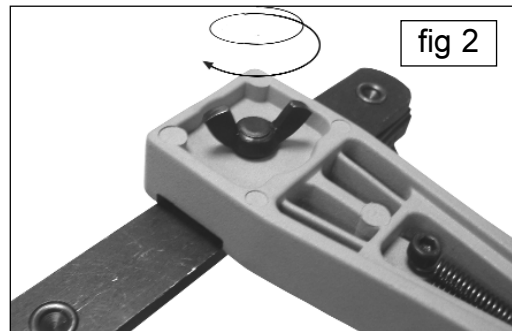
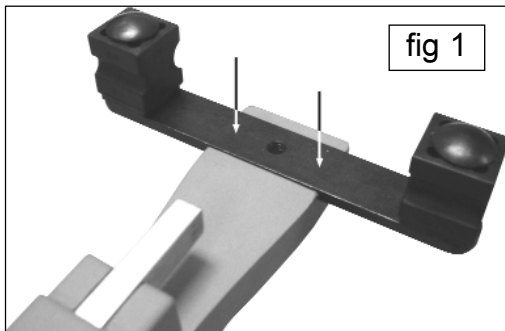
- 4.1.1 Ensure that the piece of pipe to be bent/cut is not damaged or buckled.
- 4.1.2 Construct the tube bender, applying the correct size guide for your piping (fig 1) and secure from underneath using the wing nut supplied (fig 2).
- 4.1.3 Select the correct size die for your pipe and guide selected and push it onto the end of the ram (fig 3), ensuring it is seated properly, with the ridged guidelines following the length of the tube bender.

### 4.2 BENDING THE PIPE

- 4.2.1 Mark the central point of the desired curve on the piece of piping.
- 4.2.2 Line up the rotating pipe guides so they face down towards the handle of the tube bender and insert the pipe to be bent into their grooves.
- 4.2.3 Hold pipe securely and begin to compress the tube bender's trigger until the die sits comfortably against the pipe.
- 4.2.4 Position the pipe so the centre of the arc to be made is situated in the centre of the die, proceed to operate the tube bender's trigger to bend the pipe to the desired degree.
- 4.2.5 To release pipe simply release the trigger and lever the trigger away from the body of the tube bender (fig 4), make sure pipe is secure before releasing the die.

### 4.3 CUTTING THE PIPE

- 4.3.1 Mark the point where you want to cut.
- 4.3.2 Place the pipe into the pipe cutter and line up the cutter's blade about 1-2mm **outside** of the line marked (this will be explained in step 4.3.4), then twist the screw-handle to contract the mouth of the cutter around the pipe (fig 5).
- 4.3.3 Begin to turn pipe in the blade until the pipe has been completely separated, you will need to tighten the cutter during this process to cut deeper.
- 4.3.4 The end of the pipe will naturally become slightly deformed during the cutting process and needs to be de-burred, to do this simply retract the de-burring blade from the spine of the tube cutter (fig 6) and firmly push the point into the end of the pipe, proceed to turn the blade in a screwing motion, which will scrape away the affected piece of pipe to leave a neat, clean opening. Leaving the extra 1-2mm will give a nice margin for error for when the pipe is de-burred.
- 4.3.5 It is recommended that the pipe is chamfered/brushed after being cut to remove any sharp edges, to reduce the risk of personal injury or damage.



**NOTE:** It is our policy to continually improve products and as such we reserve the right to alter data, specifications and component parts without prior notice. **IMPORTANT:** No liability is accepted for incorrect use of this equipment. **WARRANTY:** Guarantee is 12 months from purchase date, proof of which will be required for any claim. **INFORMATION:** For a copy of our latest catalogue and promotions call us on 01284 757525 and leave your full name and address, including postcode.



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