



INSTRUCTIONS FOR:

# INDUSTRIAL HYDRAULIC PIPE BENDER 15 TON WITH TRIPOD Model No: **PBS91**

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 & CAUTIONS. USE THE 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. PLEASE KEEP INSTRUCTIONS SAFE FOR FUTURE USE.**

## 1. SAFETY INSTRUCTIONS

- ✓ Ensure the pipe bender is in sound condition and good working order. Take action for immediate repair or replacement of damaged parts. *Use recommended parts only. The use of improper parts may be dangerous and will invalidate the warranty.*
- ✓ Keep bender and associated parts clean for best and safest performance.
- ✓ Locate the bender in a suitable, well lit work area.
- ✓ Keep work area clean and tidy and free from unrelated materials.
- ✓ Use on level and solid ground, preferably concrete.
- ✓ Ensure all non-essential persons keep a safe distance whilst the bender is in use.
- ✓ Check that bending die is correctly seated on ram and that roller shafts are fully engaged in the frame and pinned before operating hydraulic unit.
- ✓ Use only for DIN2440 and DIN2441 standard pipes.
- ✓ Use a qualified person to lubricate and maintain the hydraulic unit.
- ✓ Confirm that the recommended *hydraulic oil* is used during maintenance.
- ✗ **DO NOT** operate the pipe bender if damaged.
- ✗ **DO NOT** allow untrained persons to operate the bender.
- ✗ **DO NOT** exceed the rated capacity of the hydraulic unit (15 tons).
- ✗ **DO NOT** use the pipe bender for purposes other than that for which it is intended.
- ✗ **DO NOT** top up system with brake fluid. Use hydraulic oil only.
- ✗ **DO NOT** alter the pressure control valve.
- ✓ Store pipe bender in a dry, childproof area, with the hydraulic ram in the down position.

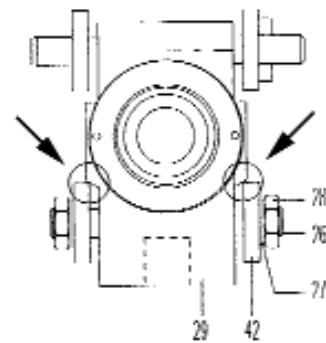
## 2. INTRODUCTION

Tripod mounting pipe bender suitable for bending pipes up to 180° (3x60°bends). Compact hydraulic design with integral 15 ton ram, pump and reservoir gives huge 235mm ram travel. Suitable for bending DIN2440 (medium) and DIN2441(heavy) pipe. The bending head is fabricated from heavy gauge steel and incorporates two bending rollers. The unit is supplied with six interchangeable dies covering 1/2" to 2" diameter pipes.

## 3. OPERATION & MAINTENANCE

- ☐ **WARNING! Ensure that you have read and understood Section 1 Safety Instructions before operating the pipe bender.**
- Note: Numbers in brackets refer to item numbers as shown on the parts diagram.**
- 3.1. Fit the lower roller plate (42) to the hydraulic unit (18) with pin (26), washers (27) and nuts (28). Tighten nuts (28) until the plate legs are flush with the inclined sides of the block (29), as shown in fig. 1.
- 3.2. Position the bender on the tripod.
- 3.3. Before using the pipe bender purge any air from the hydraulic system by opening the release valve (17) and pumping the handle (1) several times.
- 3.4. Introduce the pipe between the die (39) and the rollers (41), swing down upper roller plate (40) onto the roller pins and position the pipe so that the centre of the required bend is over the centre of the die.
- 3.5. Close relief valve (17) and pump handle (1) until the required degree of bend is achieved.
- 3.6. Open the relief valve (17) and ram (34) will retract under spring tension, raise upper roller plate (40) and remove/reposition pipe.
- 3.7. If the pipe bender is to be used on a work surface, rather than on the tripod, place feet (43) in the two forward holes in the lower roller plate (42) to provide stability.
- 3.8. After use, store the pipe bender with both piston (5) and ram (34) fully retracted.
- 3.9. Regularly oil all moving parts.
- 3.10. Annually, replace hydraulic oil using Sealey Hydraulic Jack Oil - HJO/500ML or HJO/5L. **Never use brake fluid.** Fill capacity 850ml.

fig. 1



## 4. DECLARATION OF CONFORMITY

### Declaration of Conformity

We, the sole importer into the UK, declare that the product listed below is in conformity with the following EC standards and directives.

**INDUSTRIAL HYDRAULIC PIPE BENDER 15 TON WITH STAND MODEL: PBS91**

98/37/EC Machinery Directive



The construction file for this product is held by the Manufacturer and may be inspected, by a national authority, upon request to Jack Sealey Ltd.

Signed by Mark Sweetman

23rd February 2001

For Jack Sealey Ltd. Sole importer into the UK of Sealey Quality Machinery.

**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 product.

**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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