



INSTRUCTIONS FOR:  
**HYDRAULIC PIPE BENDERS**  
Model No: **PBS99/10.V2**  
**PBS99/14.V2**

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 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 pipe bender and associated parts clean for best and safest performance.
- ✓ Locate the pipe bender in a suitable, well lit working area.
- ✓ Keep working area clean, 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 pipe bender is in use.
- ✓ Wear appropriate safety apparel, including eye-shields.
- ✓ Check that bending die is correctly seated on ram and that the roller shafts are fully engaged in the frame and pinned before operating hydraulic unit.
- ✓ Keep hands away from die and rollers when bending pipe.
- ✓ Use a qualified person to lubricate and maintain the hydraulic unit.
- ✓ Confirm that the recommended *hydraulic oil* is used during maintenance.
- x **DO NOT** top up system with brake fluid. Use hydraulic oil only.
- x **DO NOT** operate the pipe bender if damaged.
- x **DO NOT** allow untrained persons to operate the pipe bender.
- x **DO NOT** exceed the rated capacity of the hydraulic unit (see Section 2).
- x **DO NOT** use the pipe bender for purposes other than that for which it is intended.
- x **DO NOT** alter the pressure control valve.
- ✓ When not in use store pipe bender, with the hydraulic ram in the down position, in a dry, childproof area.

### 2. INTRODUCTION

Floor standing pipe bender with fabricated steel chassis and heavy-duty 10 ton (**PBS99/10.V2**) / 14 ton (**PBS99/14.V2**) hydraulics with integral pump and reservoir. Fitted with externally mounted return springs. Suitable for bending gas and air pipe from Ø13mm(1/2") up to Ø51mm(2") (**PBS99/10.V2**) / Ø15mm up to Ø75mm(3") (**PBS99/14.V2**). Supplied with six (**PBS99/10.V2**) / eight (**PBS99/14.V2**) steel dies to help prevent pipe distortion. Bends up to 180° (3 x 60° bends).

### 3. OPERATION & MAINTENANCE

- **WARNING! Ensure that you read, understand and apply Section 1 safety instructions before operating the pipe bender.**
- 3.1. With the hydraulic unit release valve open and the ram fully retracted, fit the appropriate sized die to the ram.
- 3.2. Move pipe rollers and shafts to appropriate holes in frame and ensure that shafts are properly fitted and secured using hitch pins.
- 3.3. Introduce the pipe between die and rollers, positioning it so that the centre of the required bend in the pipe is over the centre of the die.
- 3.4. Close release valve and pump handle until the required degree of bend is achieved.
- 3.5. Using the end of the handle, open the release valve and ram will retract under spring tension.
- 3.6. Annually, replace hydraulic oil using Sealey Hydraulic Jack Oil. With ram fully down, drain and refill to bottom of filler plug hole.

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

**HYDRAULIC PIPE BENDERS**  
**MODELS: PBS99/10.V2 & PBS99/14.V2**

37/EC Machinery Directive  
93/68/EEC CE Marking 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

13th December 2004

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.



Sole UK Distributor,  
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