



15T
Maximum
Load
Capacity

12T
Maximum
Load
Capacity

Pipe Bender | Hydraulic

**RIHPB15000
RIHPB12000**

INSTRUCTION MANUAL



Read through carefully
and understand these
instructions before use

INTRODUCTION



This pipe bender comes with six precision cast (RIHPB12000) bending dies attachments and eight precision cast (RIHPB15000) bending dies attachments. This pipe bender can reach up to a 90 degree maximum bend. This pipe bender can be use for exhaust pipes, bull bars, water pipes, and a wide variety of other, practical uses. However it is not suitable for thin wall tubing.

GENERAL SAFETY RULES

WARNING Read and understand all instructions. Failure to follow all instructions listed below may result in serious injury.

CAUTION Do not allow persons to operate or assemble this product until they have read this manual and have developed a thorough understanding of how the product works.

WARNING The warnings, cautions and instructions discussed in this instruction manual cannot cover all possible conditions or situations that could occur. It must be understood by the operator that common sense and caution are factors that cannot be built into this product, but must be supplied by the operator.

WARNING SYMBOLS

PLEASE READ THESE INSTRUCTIONS CAREFULLY. NOTE THE SAFETY INSTRUCTIONS AND WARNING. USE THE PRODUCT CORRECTLY AND WITH CARE FOR THE PURPOSE OF WHICH IT IS INTENDED. FAILURE TO DO SO MAY CAUSE DAMAGE TO PROPERTY AND/OR SERIOUS PERSONAL INJURY. PLEASE KEEP THIS INSTRUCTION MANUAL SAFE FOR FUTURE USE.

We've done all we can to assure this equipment offers the outmost in safety, but you have to do your part. No amount of warning can take the place of your good judgment, so make sure it's the first thing you bring to any job. Beyond that here are some obvious tips:



Do not exceed the maximum capacity.



Do not introduce any part of the body in the working area



Use safety gloves



Use safety glasses



Use safety footwears



Use HL or HM oil



Repair by qualified technician

OPERATION INSTRUCTIONS



1. Select required bending cast iron dies and place on end of ram.
2. Place pipe in bending cast iron dies and locate pipe supports at the correct holes in the frame. Insert pipe support pins.
3. To work with 12 ton hydraulic pipe bender, 90° can be made by 1/2", 3/4", 1", 1-1/4", 1-1/2" and 2" bending cast iron dies.
4. To work with 15 ton hydraulic pipe bender, 90° can be made by 1/2", 3/4", 1", 1-1/4", 1-1/2", 2", 2-1/2" and 3" bending cast iron dies.
5. 90° cannot be made by 2-1/2" and 3" bending cast iron dies in one go.

Decide how many shots have to be made according to developed length. and make certain mark on the pipe. The number of marks depend on the size and thickness of pipe.

Developed Length = $0.01745 \times \text{Radius} \times \text{Degrees}$.

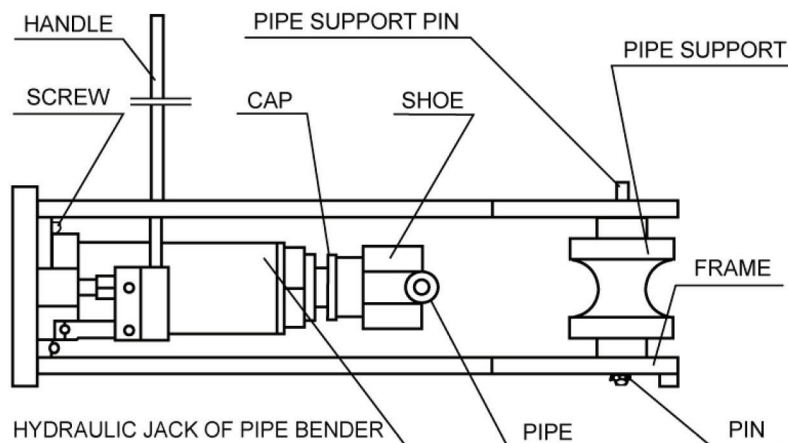
Formula for Making 90° bends is: $\text{Radius} \times 1.57 = \text{Developde Length}$.

Space= Developed Length / Number of Marks.

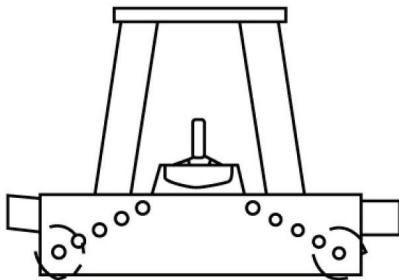
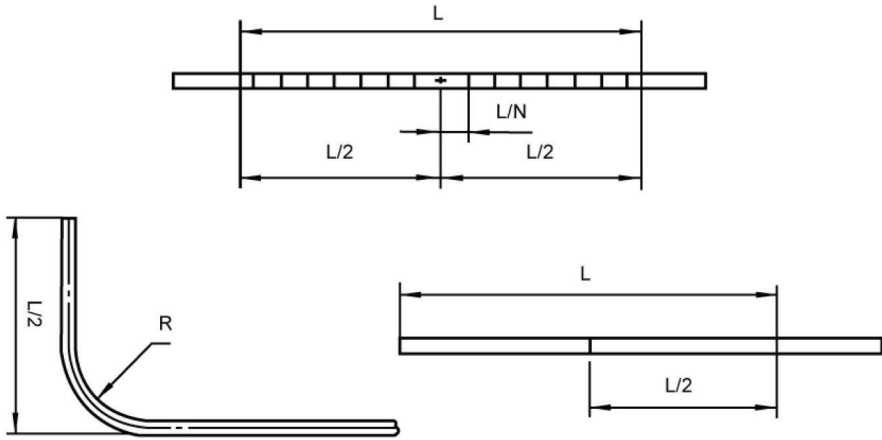
6. Place handle over release valve and turn clockwise to close. Insert handle into handle socket and pump to bend pipe.

CAUTION  Do not overfill the bending cast iron dies.

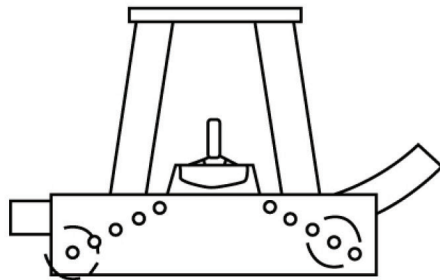
7. Turn release valve counter-clockwise and suitably return ram into cylinder. Shift pipe to the next bending postion.
8. Move the one pipe support nearer pipe on bent end in proper alignment with pipe and make additional bends.



OPERATION INSTRUCTIONS



First Bend



Succeeding Bends

STEEL PIPE BENDING CAPACITY

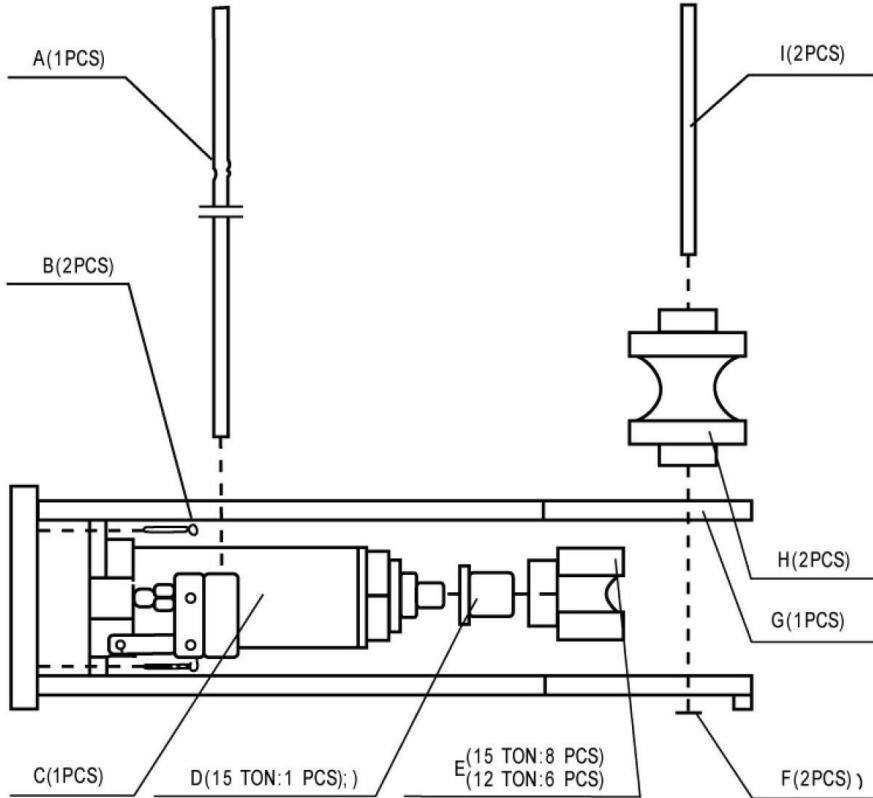


Nominal calibre		pipe diameter mm	pipe wall thickness mm	Bended angle (a)	Model
mm	in				
15	1/2	21.3	2.75, 3.25	a≤90	RIHPB12000 & RIHPB15000
20	3/4	26.8	2.75, 3.50	a≤90	
25	1	33.5	3.25, 4.00	a≤90	
32	1-1/4	42.3	3.25, 4.00	a≤90	
40	1-1/2	48.0	3.50, 4.25	a≤90	
50	2	60.0	3.50, 4.50	a≤90	RIHPB15000
65	2-1/2	75.5	3.75, 4.50	a≤90	
80	3	88.5	4.00, 4.75	a≤90	

STEEL PIPE MAXIMUM BENDING CAPACITY

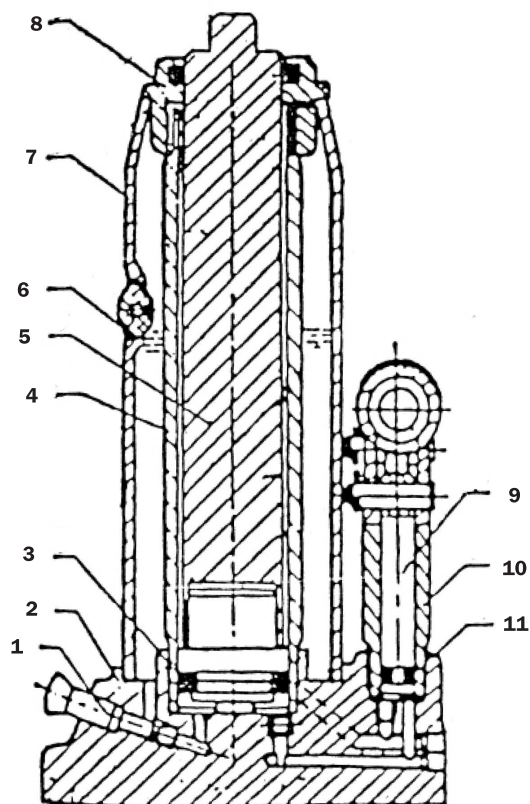
pipe diameter mm	pipe wall thickness mm	Bended angle (a°)	Model
60	5	a≤90	RIHPB12000
88.5	5	a≤90	RIHPB15000

PIPE BENDER ASSEMBLY



- A** HANDLE
- B** SCREW
- C** HYDRAULIC JACK
- D** CAP
- E** SHOE
- F** PIN
- G** FRAME
- H** PIPE SUPPORT
- I** PIPE SUPPORT PIN

HYDRAULIC JACK PART LIST



- 1 RELEASE VALVE
- 2 HYDRAULIC UNIT BODY
- 3 O-RING
- 4 CYLINDER
- 5 RAM
- 6 OIL FILLER PLUG
- 7 RESERVOIR
- 8 TOP NUT
- 9 PUMP PISTON
- 10 PUMP CYLINDER
- 11 O-RING



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