



OWNER’S MANUAL
PRODUCT CODE: 2006T

HYDRAULIC PIPE BENDER
12,000KG



Model Capacity	Bending Die	No of Attachments
12,000kg	1/2", 3/4", 1", 1-1/4", 1-1/2", 2"	6

WARNING INFORMATION

IMPORTANT: READ ALL INSTRUCTIONS BEFORE USE



WARNING

The instructions and warnings contained in this manual should be read and understood before using or operating this equipment. Do not allow anyone to use or operate this equipment until they have read this manual and have developed a thorough understanding of how this equipment works. Failure to observe any of the instructions contained in the manual could result in severe personal injury to the user or bystanders, or cause damage to the equipment and property. Keep this manual in a convenient and safe place for future reference.

Whilst every effort has been made to ensure accuracy of information contained in this manual, the TradeQuip policy of continuous improvement determines the right to make modifications without prior warning.

CONTENT

WARNING INFORMATION..... 2

CONTENT 2

SAFETY INSTRUCTIONS 3

ASSEMBLY, OPERATION & PREVENTATIVE MAINTENANCE..... 4

TROUBLESHOOTING 8

PARTS LIST 9

WARRANTY 10

SAFETY INSTRUCTIONS



SAFETY OPERATING INSTRUCTIONS

Save these instructions. For your safety, read, understand, and follow the information provided with and on this **12,000kg Hydraulic Pipe Bender** before using.

- ✓ DO NOT exceed the maximum load capacity of 12,000kg.
- ✓ Attach pipe bender securely to a solid, flat and level surface that can support the weight of the pipe bender and pipe. Ensure there is adequate clearance for movement of the pipe.
- ✗ DO NOT lay the pipe bender on its side. The hydraulic ram may leak and/or not function correctly.
- ✓ Keep hands away from the ram, pipe and rollers during use.
- ✗ DO NOT apply heat to the pipe as this may result in injury.
- ✓ Use only free standing pipe.
- ✗ DO NOT use pipe that is part of an assembly or that is installed into a structure.
- ✗ DO NOT allow untrained persons to operate this product and DO NOT make any modifications to this product.
- ✓ Study, understand, and follow all instructions before operating this device.
- ✓ Wear safety goggles, heavy-duty work gloves and steel toe work boots during set up and/or use.
- ✓ Keep rollers clean. If pipe rests on an obstruction, it creates an uneven surface, causing excess stress and possible breakage.
- ✗ DO NOT use on painted pipe or pipe that has debris on it.
- ✗ DO NOT adjust safety valve.
- ✗ DO NOT leave the pipe bender unattended when loaded.
- ✗ DO NOT expose the Hydraulic Pipe Bender to rain or any other kind of inclement weather.
- ✓ Maintain labels and nameplates. These carry important safety information.
- ✓ When servicing, use only TradeQuip identical replacement parts. Use of any other parts will void the warranty.
- ✓ Use the right product for the job. There are certain applications for which this Hydraulic Pipe Bender was designed. Do not modify the Hydraulic Pipe Bender and do not use the Hydraulic Pipe Bender for a purpose for which it was not intended.

ASSEMBLY, OPERATION & PREVENTATIVE MAINTENANCE

1. FEATURES

The **TradeQuip 12,000kg Hydraulic Pipe Bender** is specifically manufactured with a rugged high-grade steel frame that is finished with lead-free paint that covers the entire surface to ensure long-lasting wear and help prevent rust. The 12,000kg hydraulic ram is manufactured with a high quality large diameter polished steel cylinder results in lower oil pressure needed to apply necessary load, helping to reduce wear and extend service life. Six precision cast iron former dies are included.

2. BEFORE USE

Conduct a thorough visual inspection checking for leaks and any abnormal conditions, such as cracked welds, and damaged, loose, or missing parts.

Attach pipe bender securely to a solid, flat and level surface that can support the weight of the pipe bender and pipe. Ensure there is adequate clearance for movement of the pipe.

Check Hydraulic Fluid Level

Check hydraulic fluid level and fill to 6mm below the fill port as needed. Thoroughly check the ram for proper operation. If it does not work properly bleed air from its hydraulic system. Refer bleeding instructions.

Purge the hydraulic system to eliminate any air in the system.

- remove the oil fill plug from the top of the hydraulic ram.
- turn the release valve counter-clockwise to open.
- pump the handle up and down quickly several times to purge air from the system.
- check the hydraulic oil level and fill to 6mm below the fill port.
- replace the oil fill plug and close the release valve by turning it clockwise.

3. OPERATION

Prior to each use always conduct a visual inspection checking for leaks and any abnormal conditions, such as cracked welds, and damaged, loose, or missing parts.

Bending Pipe

- A certain amount of deformation will occur when using this pipe bender. Choosing the right pipe will reduce deformation. Use on 40 or 80 malleable steel pipe.
- To further reduce deformation, internal support may be provided by:
 - a) Using mandrels. Follow mandrel manufacturer's directions.
 - b) Packing pipe with clean sand, then capping off ends with steel caps (sold separately) before bending.

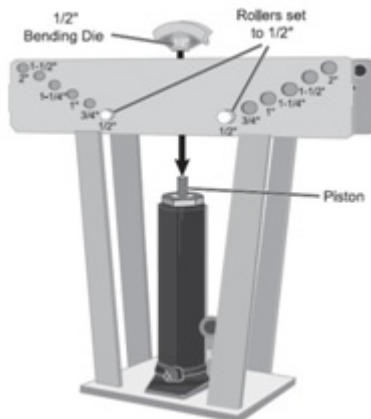
Note: To prevent injuries from burns do not heat pipe.

Figure A:

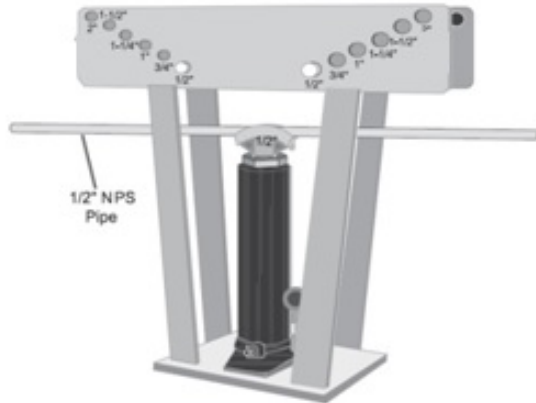
NPS (Nominal Pipe Size / Inches)	PIPE OD (Outside Diameter / Inches)
1/2"	0.840
3/4"	1.050
1"	1.315
1-1/4"	1.660
1-1/2"	1.900
2"	2.375

Practice on a scrap work piece until familiar with the pipe benders capabilities.

1. Choose bending die the same nominal pipe size as pipe. Use 1/2" bending die with the size marked on it for 1/2" pipe. Note: Outside pipe diameters are larger than the pipe size. See Figure A.
2. Attach bending die to piston.
3. Adjust rollers to correspond with size of bending die.
 - a) Remove r-pins from cotter pins, then remove cotter pins.
 - b) Move rollers to correct positions, then replace cotter pins and r-pins.



4. Mark centre line of bend on pipe.
5. Slide pipe into bending die, lining up centre line marked on pipe with centre of bending die. Note: use only with pipe that fits the bending die exactly. Pipe will deform significantly if it does not fit the bending die exactly.

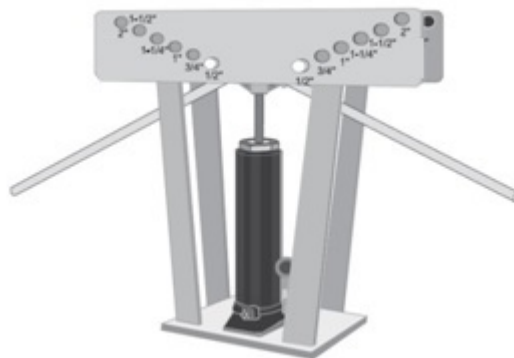


ram

6. Place handle over

release valve.

7. Twist handle clockwise to close valve.
8. Insert handle into fulcrum, then pump handle until pipe reaches bending die.
9. Continue pumping slowly until desired angle is reached. Keep in mind that pipe may rebound slightly, therefore you may need to bend very slightly beyond your desired bend to get the correct bend. Practice on a scrap work piece first.



10. Place ram handle over release valve.
11. Twist handle counter-clockwise to open the valve and lower the piston.
12. Remove pipe. If necessary, remove roller(s) to allow room to remove pipe.

4. MAINTENANCE

Inspection: Inspect the product for damage, wear, broken or missing parts and that all components function before each use. DO NOT use damaged equipment.

1. Change the hydraulic oil at least once a year.
2. Remove ram from pipe bender by removing the two bolts.
3. With the ram fully retracted, remove the oil fill plug.
4. Tilt the ram to allow the old hydraulic oil to drain out of the housing completely, dispose of the old hydraulic oil in accordance with local regulations.
5. With the ram upright, completely fill the hydraulic ram with a high quality hydraulic oil (not included) until the oil just begins to run out of the oil fill hole.
6. Open the release valve and pump the handle to bleed air from the system.
7. Reinstall the oil filler plug.
8. Clean with a clean cloth using a mild detergent.
9. Always store the hydraulic pipe bender in a safe, dry location.

5. STORAGE

This Hydraulic Pipe Bender should always be stored in a dry location with the hydraulic pump piston and ram fully retracted on a level surface. Coupler valves should always be screwed in when not in use to keep equipment clean. Always keep couplers and valves debris, dirt and dust free.

6. SERVICE & REPAIR

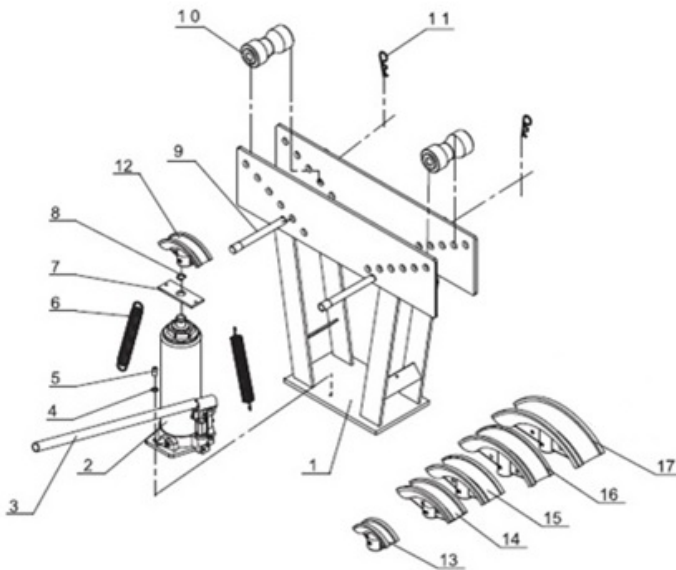
Any Hydraulic Pipe Bender found damaged in any way, or found to be worn or operates abnormally should be removed from service until repaired by an authorised service agent. Owners and / or operators should be aware that repair of this product may require specialised equipment and knowledge. Only authorised parts, labels, decals shall be used on this equipment. Annual inspection of the hydraulic auto repair kit is recommended and can be made by an authorised repair facility to ensure that your equipment is in optimum condition and that the equipment has the correct decals and safety labels specified by the manufacturer.

TROUBLESHOOTING

PROBLEM	POSSIBLE CAUSE	ACTION
Ram does not operate when handle is pumped	<ol style="list-style-type: none"> 1. Release valve not closed tightly. 2. The steel ball is immersed inside for too long. 3. Air in the hydraulic system. 	<ol style="list-style-type: none"> 1. Firmly close the release valve. 2. Open the release valve by turning it counter-clockwise, pump up the handle 10-15 times. 3. Close the release valve by turning it clockwise, pump up the handle 5-10 times. 4. Repeat step 1 & 2 x 3 times.
Ram will not hold load	<ol style="list-style-type: none"> 1. Release valve not tightly closed. 2. Malfunction in lifter such as dirt inside valve mechanism. 	<ol style="list-style-type: none"> 1. Firmly close the release valve. 2. Open the release valve by turning it counter-clockwise, pump up the handle 10-15 times. 3. Close the release valve by turning it clockwise, pump up the handle 5-10 times. 4. Repeat step 1 & 2 x 3 times.
Ram reluctant to retract when load removed	<ol style="list-style-type: none"> 1. Oil reservoir overfilled. 2. Piston binding. 3. Over extended the ram. 	<ol style="list-style-type: none"> 1. Drain oil to correct level. 2. Clean and lubricate moving parts. 3. Replace lifter.
Ram will not extend to full range of stroke	<ol style="list-style-type: none"> 1. Low oil level. 	<ol style="list-style-type: none"> 1. Add hydraulic oil to the lifter.

PARTS LIST

Part #	Description	QTY	Part #	Description	QTY
1	Frame	1	10	Roller	2
2	Ram	1	11	R-Pin	2
3	Ram Handle	1	12	1/2" Bending Die	1
4	Washer	2	13	3/4" Bending Die	1
5	Bolt	2	14	1" Bending Die	1
6	Spring	2	15	1-1/4" Bending Die	1
7	Spring Base	1	16	1-1/2" Bending Die	1
8	Circlip	1	17	2" Bending Die	1
9	Cotter Pin	2			



WARRANTY

TradeQuip products have been carefully tested and inspected before shipment and are guaranteed to be free from defective materials and workmanship for a period of 12 months from the date of purchase except where tools are hired out when the guarantee period is ninety days from the date of purchase.

Should the machine develop any fault, please return the complete tool to your nearest authorised warranty repair agent or contact TQB Brands Pty Ltd Warranty team – warranty@tqbbrands.com.au.

If upon inspection it is found that the fault occurring is due to defective materials or workmanship, repairs will be carried out free of charge. This guarantee does not apply to normal wear and tear, nor does it cover any damage caused by misuse, careless or unsafe handling, alterations, accident, or repairs attempted or made by any personnel other than the authorised TQB Brands Pty Ltd repair agent.

This guarantee applies in lieu of any other guarantee expressed or implied and variations of its terms are not authorised.

Your TQB Brands Pty Ltd guarantee is not effective unless you can produce upon request a dated receipt or invoice to verify your proof of purchase within the 12 month period.

Consumer Guarantee

Our goods come with a guarantee that cannot be excluded under the Australian Consumer Law. You are entitled to a replacement or refund for a major failure and compensation for any other reasonably foreseeable loss or damage. You are also entitled to have the goods repaired or replaced if the goods fail to be of acceptable quality and the failure does not amount to a major failure.

