

# 10 Ton Hydraulic Pipe Bender - With Super Grade Formers 15 To 50mm



- 10 Ton Heavy Duty Hydraulic Unit based on military jack design
- Robust construction with quick bending and release action
- Designed to bend from extra light to extra heavy pipes with excellent results.
- Simple set up and operation produces accurate bend every time.
- Pipes do not require heating and it is portable – thus saving time.
- Concealed pressure relief valve minimises the possibility of damaging working parts
- Comes complete with six formers made from S.G. (Ductile) iron
- Applications – water services, gas services, handrails, gates, framework etc.
- For bending ERW, galvanised, gas, water & steam pipes
- Size of former relates to inside diameter of pipe
- Formers have 36mm diameter hole to take 35mm diameter hydraulic ram



**Pipe Bender Stand**

Stand Sold Separately  
Part No. 62151M



PART NO.	ITEM	WT KG
62168	PIPE BENDER - SET COMPLETE	63.0
67043	HYDRAULIC UNIT AND HANDLE	18.6
67086	FRAME	14.0
67087	PIPE SUPPORT PIN(2)	0.8
67088	PIPE SUPPORT	5.0
67080	15 MM FORMER	2.2
67081	20 MM FORMER	2.4
67082	25 MM FORMER	3.2
67083	32 MM FORMER	4.5
67084	40 MM FORMER	5.1
67085	50 MM FORMER	7.2

PIPE SIZE		MINIMUM WALL THICKNESS MM	CENTRE LINE RADIUS	
I.D.	O.D.		MM	RATIO TO O.D.
15	21.3	3.15	80	3.8
20	26.9	3.45	100	3.7
25	33.7	4.35	140	4.2
32	42.4	5.2	190	4.5
40	48.3	4.15	225	4.7
50	60.3	5.15	300	5.0

PART NO.	DESCRIPTION	WT KGS
62151M	FOLDING VICE STAND	19.0

## Technical data

### “Elliptical” profile formers

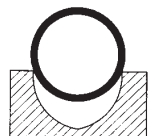
Sizes 20, 25, 32 and 40 mm formers have elliptical profile. The pipe sits close to, but not on, the bottom of the former. This gives good side support for extra light gauge pipes.

### “Cathedral” profile formers

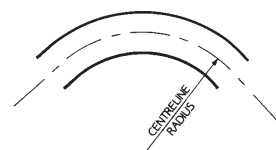
Sizes 15 and 50 mm formers have cathedral profile. The Cathedral profile is a registered design of Dawn. The pipe sits on the entry to the former and will move to the bottom when bending starts. The former squeezes the sides of the pipe, allowing lighter gauge pipes to be bent at tighter radii. The former also supports the pipe through the bending process, giving a more aesthetic rounded appearance.



**Elliptical**



**Cathedral**



## Operating Instructions

When fitting the hydraulic unit to the pipe bender frame, ensure that the carry handle on the hydraulic unit is in the upright position (top). The unit has been tested and is filled with OM33 Hydraulic Oil ready to use.

Select size of former required. Fit former to the ram on hydraulic unit. Locate pipe support and pins in the holes on frame bearing the same number as the size of the former selected. If the pins holding the pipe support are located in the wrong holes, the former would possibly get damaged. Care must be taken to see that the pins pass through the top and bottom plates of the frame. The centre of the former should contact the pipe at the centre of the proposed bend.

### To make bend

Close release valve on hydraulic unit and operate handle until the ram has travelled sufficient distance to give the desired bend. Owing to the spring reflex of the pipe it is necessary to travel a little more than the actual bend, but with a little practice the operator will soon become proficient in making excellent bends.

### To remove bend

Open the release valve partially (approximately 1 turn) on the hydraulic unit and push the ram down. If difficulty is experienced in removing the bend from the former, insert a lever between bend and the former. A small quantity of grease placed on the pipe or the former will also assist.

### Pipe Bender Stand (Sold Separately)

Extremely rigid and durable, this lightweight portable stand is easily set up and taken down, saving operators valuable time and effort. This stand will also accommodate the Dawn pipe vices, and up to a 100mm Engineers' vice.