

# **WORKING & ASSEMBLY INSTRUCTIONS FOR TUBELA TUBEBENDING MACHINES**

## **MODELS H3PR FLOOR OR BENCH MOUNTING**



### **ASSEMBLY**

Stand winghead on floor in vertical position, threaded portion uppermost. Check oil filler plug is screwed up tight on hydraulic pump, screw pump unit into former head to full extent of thread. Place machine in horizontal position. Unscrew oil filler plug 2 or 3 turns for air venting.

### **OPERATION (Standard equipment ½” – 2” tubes) H3PR 90° Model**

Set control handle to rear of pump and operate pump handle to ensure ram is fully retracted. Place selected former on ram spigot and locate with former retaining pin. Set end rollers and roller pins in appropriate holes indicated on the winghead and position tube to be bent as required. Put control handle fully forward and commence pumping until desired degree of bend is obtained. It is sometimes advisable to over bend slightly to allow for any spring in the tube. Release pressure by turning control handle to rear of machine; re-position the end former pins only, behind bent tube. In some instances it may be necessary to extend the ram slightly to clear the most suitable hole positions. With the control handle fully returned operate the pump handle to retract ram and release the bent tube from the former.

### **OPERATION (180 ° Bending) H3PR 180° MODEL OR EXTREME BENDING SET**

When using the extreme bending set for 180° bending it is advisable to use the standard end rollers and operate as above until approx. 90° of bend is achieved and then substitute the end rockers for the end rollers. Always use the 6” extension ram when more than 10” of ram travel is required.

### **IMPORTANT INFORMATION**

- 1) Top up oil reservoir to top of filter built under the oil filler cap. (Ram retracted)
- 2) Return ram fully when machine is out of use.
- 3) Filler plug must be open when the machine is in use and otherwise kept closed.
- 4) Bending rollers must, at all times, be placed equidistant from the ram centre and in the correct holes specified on the former head according to the diameter of the tube to be bent.
- 5) Use only Shell Tellus 37 oil or equivalent mineral based oil. Other lubricants may damage the internal seals.

**HEALTH & SAFETY AT WORK ACT 1974** – Refer to product safety data sheet enclosed.

### **Information**

The capacity of the model can be increased for bending up to 3” N.B pipes by means of the extension winghead. Ref. H.3.W.

For bending 4”, 5” and 6” bore pipes consult the manufacturers.