



- 1) Open 'A' Frame to its initial bending location. (A)
- 2) Screw attachment nut onto pump thread and locate attachment through holes with two long bolts provided (this will be easier if the attachment is at 90 ° to the horizontal bending position)
- 3) Slide ram nose into the 1 ¼" hole in centre block, align and lighten set screw. (Rotate attachment frame to the horizontal for bending). (B)
- 4) Position required size of bending former in scissor attachment and locate with long 'T'-Pin through all centre pivot holes. Ensure pin is fully through top and bottom 'A' Frames. (C)
- 5) Insert tube and tube retaining strap and pin
- 6) Place back guide over tube and adjust pressure roller to give required degree of 'lead'. (D)
NOTE: This will vary from approx.10 ° for light gauge non-famous and stainless steel tubes to 15°/20 ° for thicker wall tubes.
- 7) Operate hand pump in normal method until required degree of bend is produced.
- 8) After completion of bend retract ram and scissor attachment and remove tube. A slight resistance may be felt initially until a few bends have been produced due to general assembly tightness and spray painting.
- 9) Where fitted, the adjustable degree of bend indicator can be set at 0° after the desired initial bending point is found. The angle of bend being produced can then be read off the scale.