

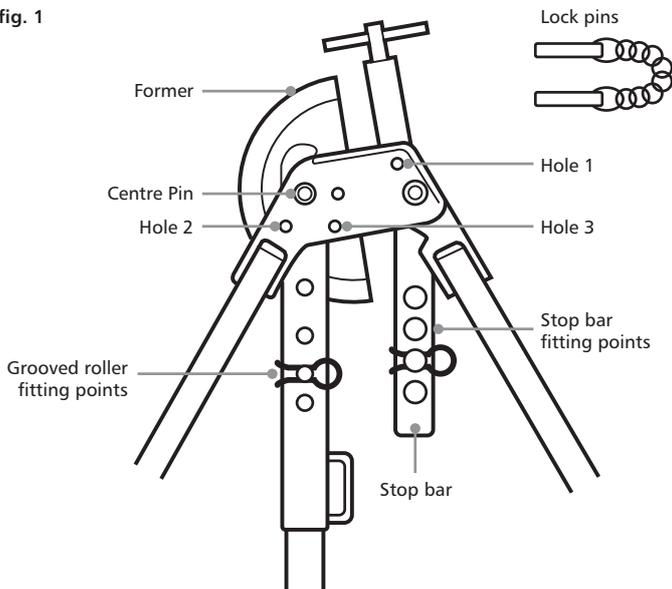
Warning

This machine is designed to form 20, 25 and 32mm steel conduit and should not be used for other materials. Only use steel conduit compliant with BS EN 51386.

OPERATING

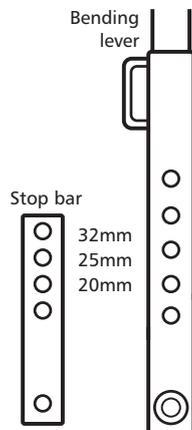
1. Open the stand to its fullest extent and insert locking pin into hole 1 (fig. 1) to secure the legs in the open position.

fig. 1



2. Bolt the vice into position on top of the platform.
Note: The vice should only be used for cutting and treading of conduit.

fig. 2



3. Remove the bender locking pin 2 from hole 2 (see fig. 1); ensure the grooved roller is fitted in the correct position (fig. 2) for the conduit being formed.

4. Select the correct former for the conduit being formed, remove the centre pin (fig. 1) and place the former into position, reinsert the centre pin, ensuring it is fully inserted into both sides of the machine's frame.
5. Lift the bending lever into the upright position and insert the lever locking pin 2 into hole 3 (fig. 1).
6. Swing the stop bar into the upright position and insert the stop into the correct hole for the conduit size being formed.
7. Push the conduit into the machine so it passes under the stop, ensuring the conduit is fitted into the groove of the former and it passes under the grooved roller.
8. Check the length of the tube after the bend point to ensure it will not touch the floor when the bend is complete. The maximum length of tube is 800mm.
9. Fit the extension bar onto the bending lever. For safety, the extension bar should only be fitted when forming conduit.

Note: If there is insufficient clearance to form the conduit downwards, an upwards form can be carried out: Remove the extension bar from the bending lever if fitted. Release the bending lever and swing it and the stop bar downwards. Move the stop one position up and reinsert the conduit.

TRANSPORTATION

When transporting the machine, lock the bending lever into position by pushing locking pin 2 into hole 2 (fig. 1). Remove the leg locking pin 1 (fig. 1) and fold up the machine. Reinsert the locking pin 1 into hole 1 to hold the legs in the locked position.