



90° PIPE BENDER SET

INSTRUCTION



ST-R999



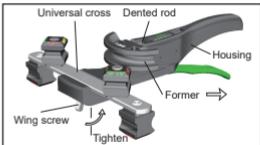
PREMIUM REFRIGERATION TOOL SERIES

Thanks for purchasing  products. For safe and correct using, please read this user instruction carefully before using the product.

Tube Bending Instruction

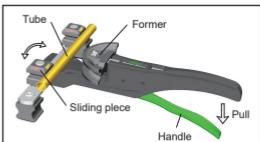
(1) Prepare before bending - universal crossbar and former install

Insert correct size former in dented rod, then place correct size universal crossbar on housing and tightened it by a wing screw. Notice: there are 2 pairs of sliding pieces with sized slots on universal crossbar. We must choose the same size sliding pieces with sized slots and face them to the former slot. (Sizes are engraved on formers and sliding pieces)



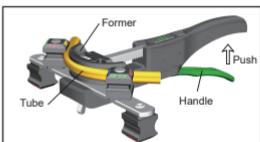
(2) Prepare before bending - placing a tube

Upright the bender housing and pull out the feed lever. Former with dented rod will retract back under the effect of gravity. Turn the sliding pieces with correct size slots and face them to the former slot. Then place the tube between former and sliding pieces. (Figure)



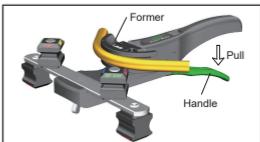
(3) Bending - push the feed lever repeatedly

Push the feed lever repeatedly until the tube is bended to a certain angle you need. Notice: maximum angle is 90°.



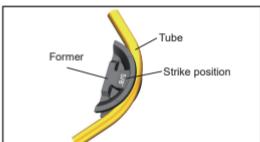
(4) Bending finished - take the bended tube out

Upright the bender and pull out the feed lever. Former with dented rod will retract back under the effect of gravity. Take the bended tube out. If the bended tube get stuck in the former slot, remove them from housing together.



(5) Bending finished - take out the stuck tube

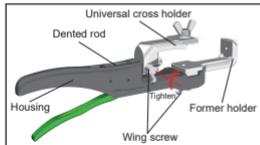
Hold the tube with one hand and use some tools such as hammer to strike the former in the position in figure. Notice: don't strike the tube.



Revers Tube Bending Instruction

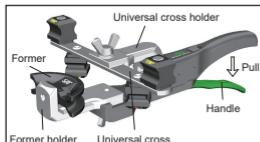
(1) Prepare before bending - fix former holder and universal crossbar holder on housing

Insert universal crossbar in dented rod and tighten it by a wing screw. Fix former holder in housing slot and tighten it by a wing screw. (Figure)



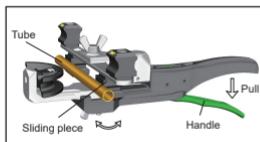
(2) Prepare before bending - universal crossbar and former install

Insert correct size former in former holder, the place correct size universal crossbar on universal crossbar holder and tightened it by a wing screw. Notice: there are 2 pairs of sliding pieces with sized slots on universal crossbar. We must choose the same size sliding pieces with sized slots and face the former slot. (Sizes are engraved on formers and sliding pieces)



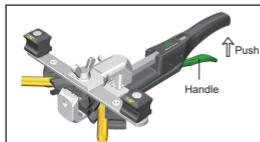
(3) Prepare before bending - placing a tube

Upright the bender and pull out the feed lever. univer sal crossbar holder with dented rod with retract back under the effect of gravity. Turn the sliding pieces with correct size slots and face the former slot. Then place the tube between former and sliding pieces. (Figure)



(4) Bending - push the feed lever repeatedly

Push the feed lever repeatedly until the tube is bended to a certain angle you need. Notice: maximum angle is 90°.



(5) Bending finished - take the bended tube out

Upright the bender and pull out the feed lever. Univer sal crossbar holder with dented rod retract back will under the effect of gravity. Take the bended tube out. If the bended tube get stuck in the former slot, remove them from housing together. (Refer to 5 step of tube bending instruction)

