

Safety/Operating Instructions

Bramley Hydraulic Pipe Benders

Model 026E - Electric/Hydraulic

Model 024 - Manual/Hydraulic



Licence Number
706519

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Bramley 026E Electric/Hydraulic Pipe Bender

Thank you for purchasing the Bramley 026E Electric/Hydraulic Pipe Bender. This portable Pipe Bender is designed for bending up to schedule 40 pipe from 1/2" (15mm) to 2" (50mm NB) to a maximum angle of 90°.

The electric pipe bender has a 15 ton rated ram and features a variable speed electric motor and pump allowing for quicker bending and easier operation. The unit is designed for horizontal operation only.

Operation and Assembly

Select the appropriate size Pipe Former for the pipe size that is to be bent and fit onto hydraulic ram between top & bottom plates.

NOTE: The formers are designed for use on standard schedule 40 (max 4.00mm wall) nominal bore mild steel water pipe.

Insert pipe to be bent at appropriate location in the former.

Locate the two Pipe Bobbins (2) in the appropriate designated positions on the outside of the pipe being bent.

Ensure that the Oil Dipstick Screw (11) is loose – allowing air to vent to the oil reservoir and that the Pressure Release Screw (12) located at the bottom left hand end of the hydraulic unit is firmly shut – clockwise rotation.

Depress trigger switch located on the handle of the pump unit. Keep trigger switch depressed until the desired angle of bend is achieved. DO NOT exceed speed #4 for 2" pipe.

(When bending large diameter pipe, the application of a smear of grease on the contact face of the Bobbins can reduce the force required to achieve the desired bend.)

NOTE: Bending over 90° will cause damage to both the pipe being bent and the former.

When the angle of bend is achieved, release the Pressure Release Screw (12). The ram will retract by way of the internal retraction spring. Remove the Bobbin Pins (9) and then remove the bent pipe from the front of the machine.

Check oil at regular intervals. When topping up, ensure that the oil is free of any foreign matter.

Check the oil level by screwing in the Oil Dipstick Screw (11) tightly in a horizontal position.

Then remove the Oil Dipstick Screw. When the oil is of correct level there should be witness of it in the groove on the dipstick.

When the oil has been topped up, fit the Oil Dipstick Screw in to the filler port loosely. In a near vertical position operate the pump unit. Let the ram extend for about 100 mm. Then open the pressure release valve and ensure that the ram retracts fully.

The unit is now ready for full operation.

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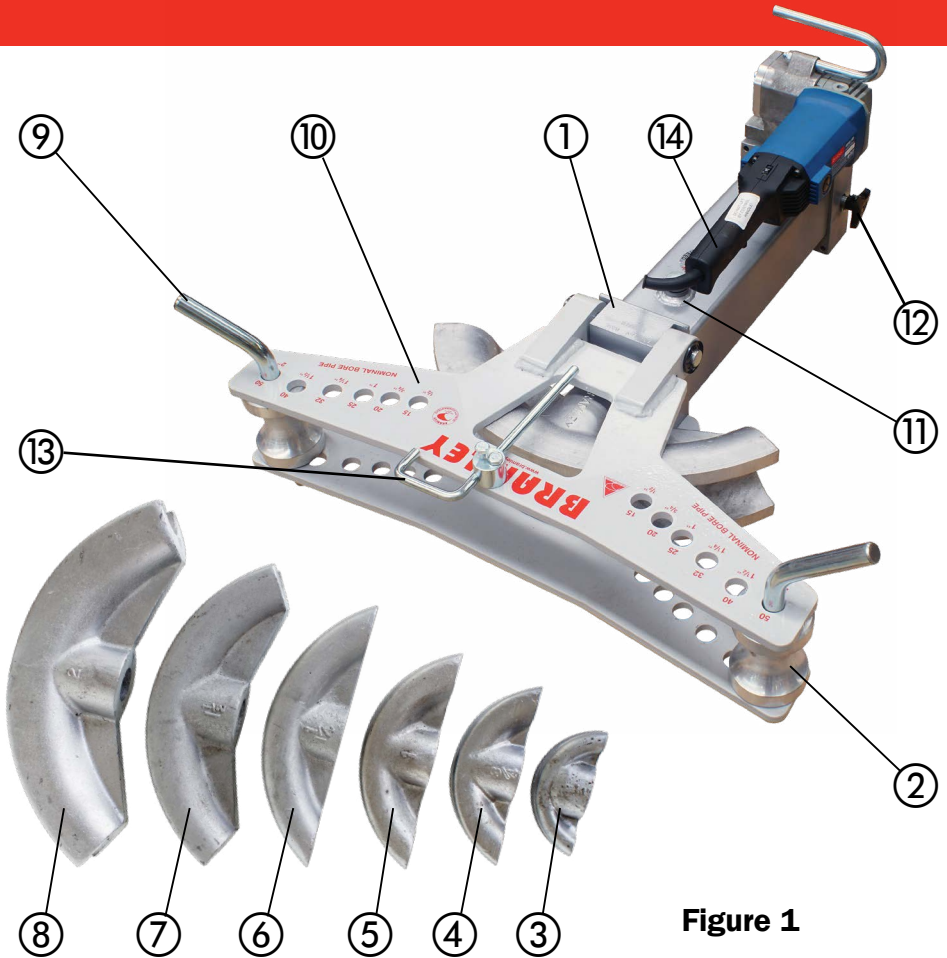


Figure 1

Ref No.	Part No.	Description	Fits Model	Centreline Radius of Bend	
1	26-25E	Electric/Hydraulic Unit Sub Assembly Pipe Bender 15t	026E		
2	22-10	Bramley Bobbin	026E / 024		
3	22-11	Bramley Pipe Former 1/2" (15mm)	026E / 024	3"	75mm
4	22-12	Bramley Pipe Former 3/4" (20mm)	026E / 024	4"	105mm
5	22-13	Bramley Pipe Former 1" (25mm)	026E / 024	5 1/2"	140mm
6	22-14	Bramley Pipe Former 1 1/4" (32mm)	026E / 024	7"	175mm
7	22-15	Bramley Pipe Former 1 1/2" (40mm)	026E / 024	8"	200mm
8	22-16	Bramley Pipe Former 2" (50mm)	026E / 024	9 1/2"	240mm
9	22-09	Bobbin Pins	026E / 024		
10	22-01	Top and Bottom Frame	026E / 024		
11		Oil Dipstick Screw	026E		
12		Pressure Release Screw	026E		
13		Radius Gauge Rod	026E / 024		
14	26-25M	Electric/Hydraulic Motor Unit Only	026E		
Not shown	24-05A	Hydraulic Unit HL-16T (for 024 manual bender)	024		

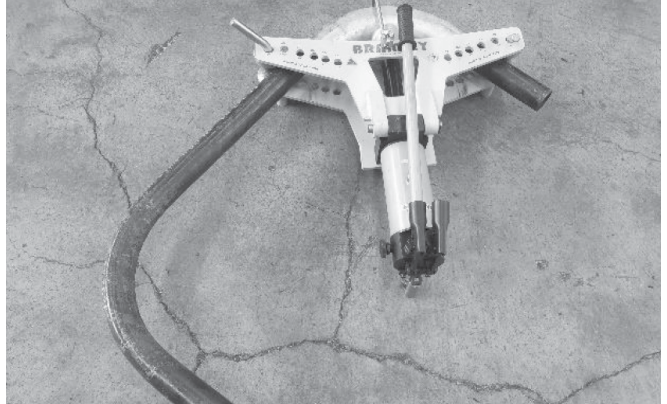
Bramley 024 Hydraulic Pipe Bender

Thank you for purchasing the Bramley 024 Hydraulic Pipe Bender. This portable Pipe Bender is designed for bending up to schedule 40 pipe from 1/2" (15mm) to 2" (50mm NB) to a maximum angle of 90°.

The manual pipe bender has a 16 ton rated ram and features a 2-speed pump with spring return allowing for quicker bending and easier operation. The unit is designed for horizontal operation only.

Operation

This machine is designed to be used horizontal on a flat surface with plenty of room around it to allow for the pipe being bent (as shown at right).



Before using the machine (pumping either pistons or retracting ram) open bleed/filler cap (as shown at right) a turn to allow air to escape or enter the hydraulic unit. If the unit is pumped while filler/bleed cap is done up, the unit will simply stop working until you open this.

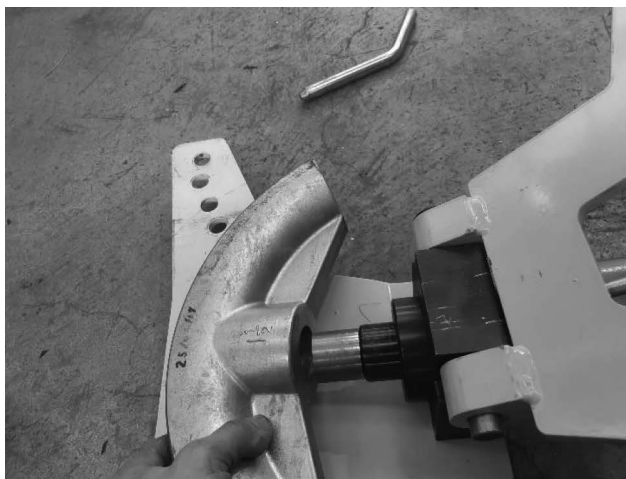


Bramley 024 Hydraulic Pipe Bender (continued)

To retract hydraulic ram, open the valve shown below about a half turn anti-clockwise. To pump hydraulic ram forward, close this valve by turning it clockwise hand tight. (Do not over tighten this valve as damage, or early failure will occur in valve seat).

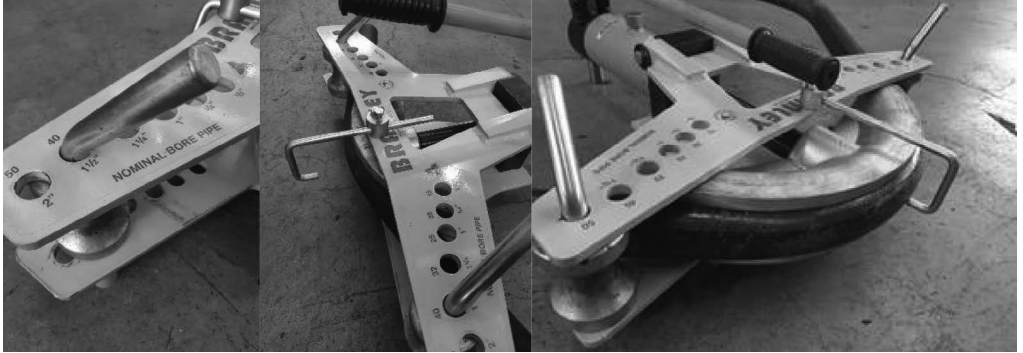


Open the top frame and fit the correct former for the pipe being bent. Fit the pipe being bent and close top frame. Fit the Bobbin and Bobbin pins into the corresponding holes for this size former (if 1 ½" former fitted the Bobbin and Bobbin pins must be fitted to the 1 ½" hole).



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Close the hydraulic valve and using either the fast or slow pistons pump the main ram and former against the pipe and bobbins. Before bend commences, check bend is in desired place. Repositioning is easy up until material bend is started. Bend material until desired angle is achieved. The stop can be set for multiple bends of the same angle. Note there is some bend back when ram is retracted so a slight over bend may be required.



If over time the ram fails to fully extend, or ram seems slow to move, check the level of hydraulic oil in the reservoir with the unit horizontal and the ram fully retracted, open the filler cap. The oil should be covering the cylinder inside unit. The hydraulic unit may need topping up with 32 grade hydraulic oil. (Fluid can be lost if filler cap is not nipped up after use and unit transported or tipped up in this state).

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