



# SAFETY WARNINGS AND PRECAUTIONS

**WARNING:** When using tool, basic safety precautions should always be followed to reduce the risk of personal injury and damage to equipment. Read all instructions before using the tool!

- **Work area conditions.** Cluttered areas invite injuries.
- **Additional work area conditions.** Do not use machines or power tools in damp or wet locations. Do not expose to rain. Keep work area well lighted.
- **Keep children away.** Children must never be allowed in the work area. Do not let them handle machines, tools or extension cords.
- **Store idle equipment.** When not in use, tools must be stored in a dry location to inhibit rust. Always lock up tools and keep out of reach of children.
- **Use the right tool for the job.** Do not attempt to force a small tool or attachment to do the work of a larger industrial tool. There are certain applications for which this tool was designed. It will do the job better and more safely at the rate for which it was intended. Do not modify this tool and do not use this tool for a purpose for which it was not intended.
- **Dress properly.** Do not wear loose clothing or jewelry as they can be caught in moving parts. Protective, electrically non-conductive clothes and non-skid footwear are recommended when working. Wear restrictive hair covering to contain long hair.
- **Use eye protection.** Always wear ANSI approved impact safety glasses underneath a full face shield during use. Also, wear heavy duty work gloves.
- **Do not overreach.** Keep proper footing and balance at all times. Do not reach over or across running machines.
- **Maintain tools with care.** Keep tools sharp and clean for better and safer performance. Follow instructions for lubricating and changing accessories. The handles must be kept clean, dry, and free from oil and grease at all times.
- **Remove adjusting keys and wrenches.** Check that keys and adjusting wrenches are removed from the tool or machine work surface before starting work.
- **Stay alert.** Watch what you are doing, use common sense. Do not operate any tool when you are tired.
- **Check for damaged parts.** Before using any tool, any part that appears damaged should be carefully checked to determine that it will operate properly and perform its intended function. Any part that is damaged should be replaced.
- **Replacement parts and accessories.** When servicing, use only identical replacement parts. Use of any other parts will void the warranty. Only use accessories intended for use with this tool. Approved accessories are available from Cummins Industrial Tools.
- **Do not operate tools if under the influence of alcohol or drugs.** Read warning labels on prescriptions to determine if your judgment or reflexes are impaired while taking drugs. If there is any doubt, do not operate the tool.

**WARNING:** The warnings, cautions, and instructions discussed in this instruction manual can not cover all possible conditions and situations that may occur. It must be understood by the operator that common sense and caution are factors which can not be built into this product, but must be supplied by the operator.

# OPERATING INSTRUCTIONS

## Additional Safety Instructions

- **TWO PERSON OPERATION.** For safety, when moving the Pipe Bender or bending large pieces of pipe in the bending dies, while a second person cranks the bottle jack's handle.
- **12 TON LIMIT.** Do not exceed the maximum limit of the bottle jack.
- **STORE IDLE EQUIPMENT.** When not in use, jack should be stored in "closed" position and Pipe Bender stored in a dry location to reduce rust. For safety, store the Pipe Bender in a locked cabinet, out of reach of children.
- If you need to bend tubing for special projects like exhaust tubing, electrical conduit, Schedule 40 or 80 pipe, motorcycle frames, certain types of roll cages. This is the perfect Bender to handle those projects without and expense of a fully automatic bender. This Hand pump gives you ultimate control. No over bending and wasted pipe.

## Notes & Tips

- The Pipe Bender is designed to bend water pipe and heavy gauge galvanized pipe that is used in commercial applications. When bending thin-walled pipe, e.g. conduit etc., you may have problems with the pipe becoming kinked or creased. To limit the amount of creasing, fill the pipe with sand and cap the ends before bending.
- The BOTTLE JACK (#2) is a heavy-duty 12-Ton tool that should last through several years of use. The only parts that eventually wear out, during normal use, are the seals. If hydraulic fluid is found to be seeping from the telescoping shaft of the BOTTLE JACK (#2), you can fix the problem by installing a Seal Kit.
- The Bottle jack may be "spongy" upon arrival, or become so during operation. A simple bleeding procedure is required when this occurs. The instructions are follow:
  1. Make sure Bottle Jack is completely lowered and in upright position.
  2. Remove oil fill plug and top off with hydraulic fluid.
  3. Raise Bottle Jack to maximum height.
  4. Loosen release valve, and push Bottle Jack down all of the way.
  5. Top off with hydraulic fluid replace plug.

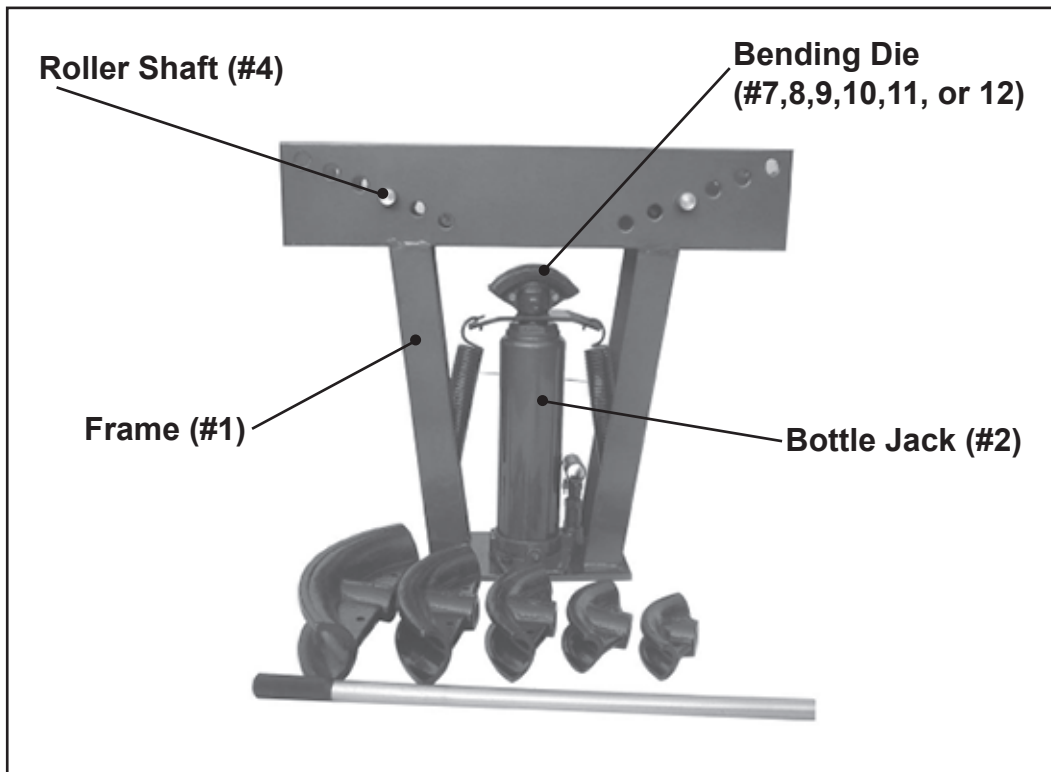
## Setup & Operation

The Pipe Bender requires no major assembly. However, some setup is needed before you use the machine. Use the instructions listed below to setup and operate the Pipe Bender.

- **Step 1.** Place the Pipe Bender on a solid, level floor or workbench.
- **Step 2.** Each BENDING DIE (#7, 8, 9, 10, 11 or 12) is stamped with a number on the front (e.g -æ", 1"1Ω, etc.). Select the BENDING DIE (#7, 8, 9, 10, 11 or 12) that matches the size of pipe you want to bend .

# OPERATING INSTRUCTIONS

- **Step 3.** Place the BENDING DIE (#7, 8, 9, 10, 11 or 12) onto the BOTTLE JACK (#2) as shown in Figure 1.

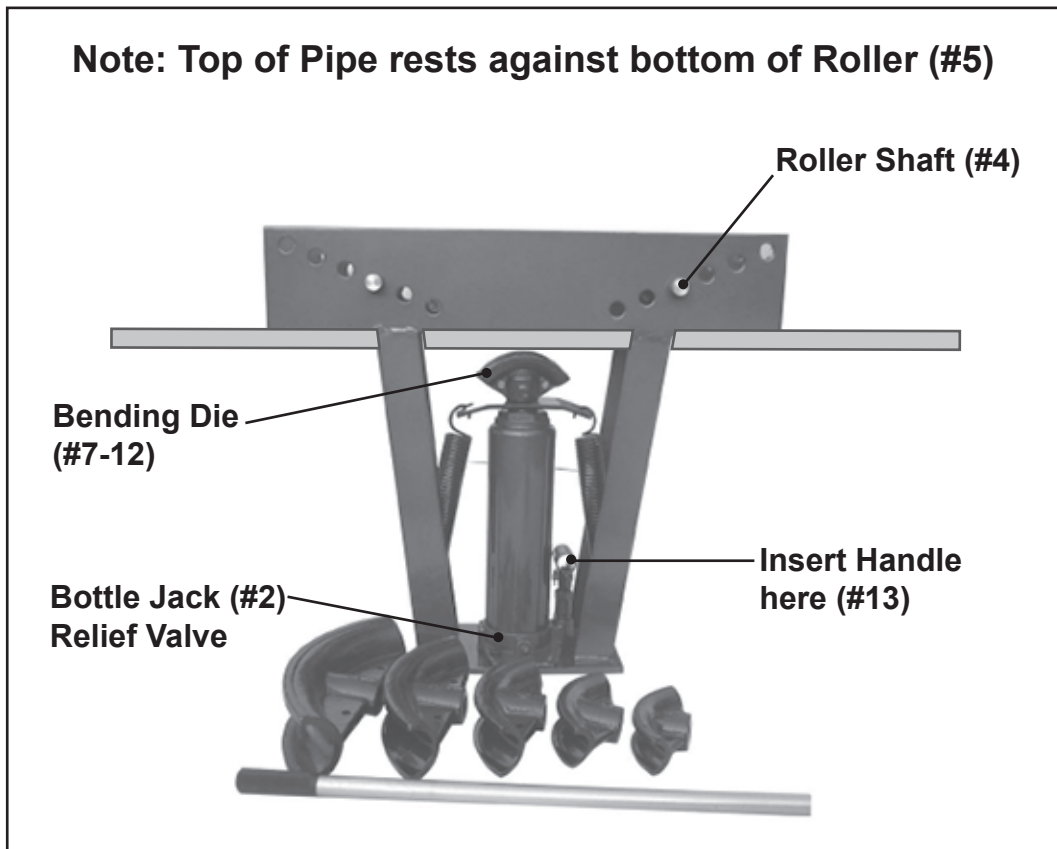


- **Step 4.** Depending on the size pipe and the desired results, you may need to move the ROLLERS (#5):
  - A. Remove both HITCH PINS (#6).
  - B. One at a time, remove a ROLLER SHAFT(#4) and move the ROLLER (#5) to the desired location (hole) in the FRANE (#1).
  - C. Fully slide the ROLLER SHAFT(#4) through the holes in FRAME (#1) and ROLLER (#5).
  - D. Secure the ROLLER SHAFT (#4) by inserting a HITCH PIN (#6) through the ROLLER SHAFT (#4), as it was when you removed it.
  - E. Repeat Steps B, C and D for the other roller.

**Note: See Parts List Exploded View Drawing in next section for location of parts.**

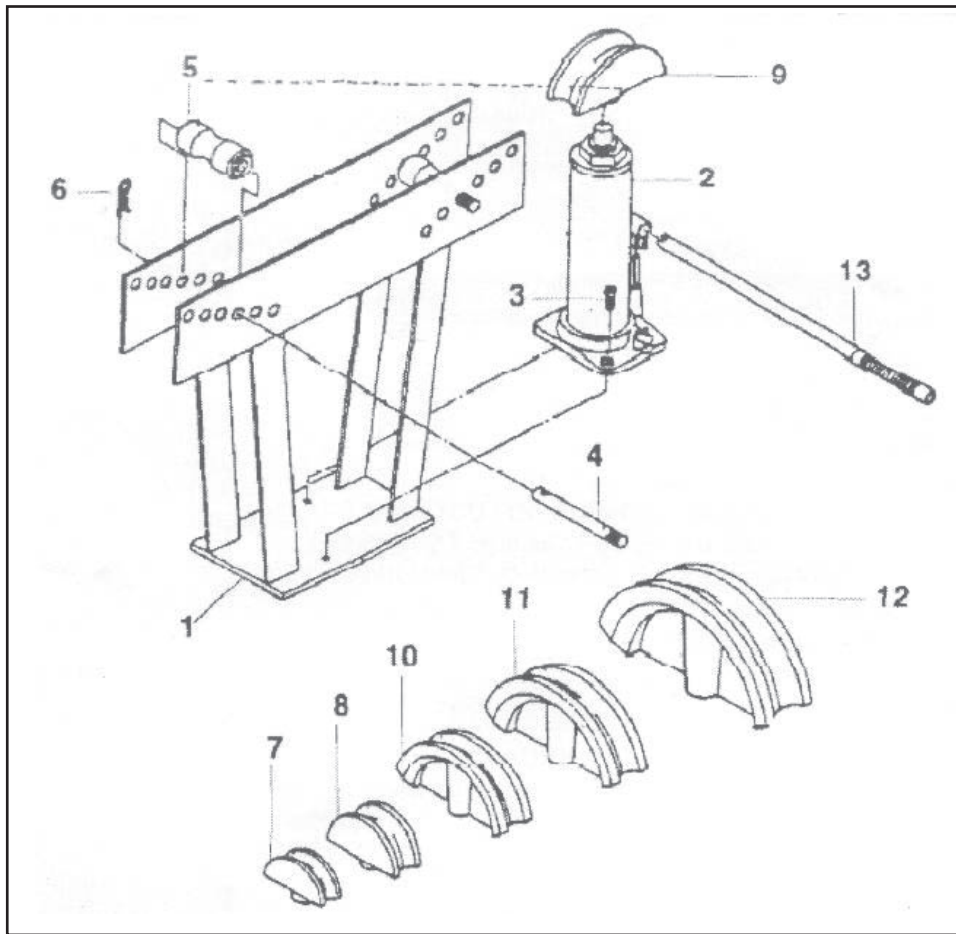
# OPERATING INSTRUCTIONS

- **Step 5.** Slide the pipe you are going to bend through the Pipe Bender, as shown in Figure 2.



- **Step 6.** Using the slotted end of HANDLE (#13), tighten (turn clockwise) the BOTTLE TACK'S (#2) relief valve (see Figure 2).
- **Step 7.** Insert the HANDLE (#13) into the BOTTLE JACK as shown in Figure 2, and crank it up and down to raise the BOTTLE JACK (#2) and bend the pipe.
- **Step 8.** When the pipe has been bent to the desired angle, remove the HANDLE (#13) from The BOTTLE JACK and loosen (turn counter-clockwise) the BOTTLE JACK' s (#2) relief valve. This will release the pipe from the Pipe Bender and allow you to carefully remove it.

# PARTS LIST



No.	Description	Qty	No.	Description	Qty
1	FRAME	1	8	3/4" BENDING DIE	1
2	BOTTLE JACK (12 TON)	1	9	1" BENDING DIE	1
3	HEX BOLT	2	10	1-1/4" BENDING DIE	1
4	BOLLER SHAFT	2	11	1-1/2" BENDING DIE	1
5	BOLLER	2	12	2" BENDING DIE	1
6	HITCH PIN	2	13	HANDLE (FOR JACK)	1
7	1/2" BENDING DIE	1			