

HYDRAULIC PIPE BENDING MACHINE

CE

MODEL: SWG - 1A



INSTRUCTIONS

6. Guarantee

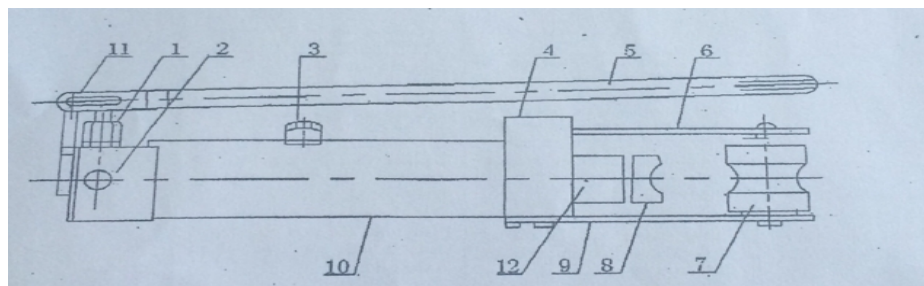
1. Length of warranty: three months after machine has sale, a month for sealing parts.

2. guarantee range: as product quality problem, during the warranty period, our factory

is responsible for repair, change, refund. If more than warranty, or under warranty, not according

To specifications or disassemble by yourself, we provide repair service, but the users pay the cost

7. structural drawing



1. piston pump 2. switch 3. oil nozzle 4. oil pump seat

5. handle 6. upper plate 7. supporting rollers 8. bending moulds

9. lower plate 10. bracket 11. handle seat 12. operating strut

We look very much forward to entering into business relation

Ship with customers from all over the world based on mutual benefits.

PAPER OF USER OPINIO

Identification		Date of arrival	
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Shortcomings and process problems during use			
suggestion			
Company in detail			
Communications office			
superintendent			
SEND THIS FILLED PAGE TO TECHNOLOGY DEPARTMENT OF YUHUAN HUANHU MACHINERY-ELECTRIC TOOLS FACTORY			

PACKING LIST

Code	Description	pcs	
1	Body	1	
2	Upper & Lower plates	2	
3	mould	4	1/4", 5/16", 3/8", 1/2", 3/4, 1"
4	Supporting Rollers	2	
5	Handle	2	
6	Instruction Manual	1	
7	Bag of Spare Parts	1	Sealing element, lock-spanner

Product performance and instructions

1.Introductions

Our factory produce "HUANHU"series pipe bender reference japan homogeneous series products design and manufacture, the products has been Produced with the usage of manual operated oil pump which has the functions Of low and quick speeds and has equipped releasing Device for overloading. Owing a refined forged mould steel, the pipe bender features ideal Structring, light weight, compact size and long period of usage. It can be applies to the Industries of building construction, chemical,petroleum etc.

2.operation methods:

(1)tighten the switch. Oil the touching surfaces of the supporting rollers,moulds and the pipes To be bended.

(2)in line with the size of the pipes to be bended, select the appropriate bending mould and fix it on The top of pump stem the slots of the two supporting rollers should face the bending mould and and Please pay special attention to fixing the supporting rollers with max. Size are to be fixed in the holes On the outer lane. Thus it is possible to prevent the wrong assembling of the supporting rollers and Avoid the mould and the other parts from being damaged.

(3)Recautions:

(1) before operation please check the oil level of the oil tank.if it is lack of oil,fill the oil substantially Into the oil tank.

2.before the working starts, the switch should be closed tightly, otherwise the pressure will Not not be raised. Please loose the screw of the oil nozzle so as to circulate the air in the oil tank

3.the dia of the pipe to be bended should be similar to that of slots on the mouid, otherwise.pipe To be bended will deformed and the mould will be damaged.

4.the seam of the welded pipe should not be faced directly to the mould surface.during the Processions of the bending, the tow supporting rollers should be rolling simultaneously while The pipe is sliding within the slot of the mould.if only one supporting roller is in action, stop the Operation at once.

5.clean the equipment periodically and when add oil to the oil tank,the oil must be filtered With the special filtering mesh .the filtering device should be cleansed frequently.

6.the machine oil used by this equipment is 15#.

4.spare parts:

For customers convenience of maintenance,some, spare parts have been packed into the dags

5.troubles shooting

troubles	causes	Tackling methods
The pushing rod moves unsteadily after the piston has extended to a certain length by the operation of the handle	The screw of oil nozzle has not been loosen	Loose the screw of the oil nozzle
	Unsealing existed at the oil outlet valve On the pump or the steel ball of the oil Outlet valve is not round smooth.	Dirty existed in the oil.clean the oil and change the steal ball.
The oil leakage appears at the ends of piston stems of both large and small pumps	The seal rings have damaged.	Replace them with the spare parts in the bags supplied
the oil leakage existed at the Location of the switch.	The inner pressure ring has been loosen.	After dismantling tho limit screw and the switch tighten the pressure ring
Unhopeful pushing force of The pushing stem .	Unperfcted sealing of the steel ball within the switch.	Change the steel ball.
	The steel ball has not been clamped Tightly at the top of the switch or the Steel ball has fallen switch or the steel.	Tighten the switch or add a. Steel ball To the top of the switch if there is no Steel bail.
Oil leakage appears at the top side of the pushing stem	The seal ring at the top side of the pushing stem has been damaged.	Replace the o ring 14 . 2.4 prepared by the customers themselves.
Insufficient oil suction from the large and small pumps	Either being lack of oil or dirty existed upon the surfaees of filtering mesh	Dismantle the pat no.13.and clean it with gasolie. Fill oil in the oil tank
The assembling hole of the mould has cracked	While the mould is being pushed out, it has a,load at one side e.g. When a bended Pipe is put on the mould again,it is not located properly.	Check if the positions of the two supporting rollers are the same. Put some oil to the touching surfaces. Of supporting rollers and the pipe to be bended
Abnormal withdrawal of the pump stem	The steel ball at the outlet valve can not reset.	Extend the actin stm NO.7whe thre has pressure force upon the piston pump,strike the handle seat with hammer several times.the steel ball will be reset

