



OPERATOR'S MANUAL



ROTARY DRAW BENDER MODEL: RDB-175 (B8080)

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INTRODUCTION

The quality and reliability of the components assembled on a Baileigh Industrial machine guarantee near perfect functioning, free from problems, even under the most demanding working conditions. However if a situation arises, refer to the manual first. If a solution cannot be found, contact the distributor where you purchased our product. Make sure you have the serial number and production year of the machine (stamped on the nameplate). For replacement parts refer to the assembly numbers on the parts list drawings.

Our technical staff will do their best to help you get your machine back in working order.

In this manual you will find: (when applicable)

- Safety procedures
- Correct installation guidelines
- Description of the functional parts of the machine
- Capacity charts
- Set-up and start-up instructions
- Machine operation
- Scheduled maintenance
- Parts lists

GENERAL NOTES

After receiving your equipment remove the protective container. Do a complete visual inspection, and if damage is noted, **photograph it for insurance claims** and contact your carrier at once, requesting inspection. Also contact your distributor and inform them of the unexpected occurrence. Temporarily suspend installation.

Take necessary precautions while loading / unloading or moving the machine to avoid any injuries.

Your machine is designed and manufactured to work smoothly and efficiently. Following proper maintenance instructions will help ensure this. Try and use original spare parts, whenever possible, and most importantly; **DO NOT** overload the machine or make any unauthorized modifications.



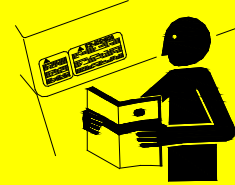
Note: This symbol refers to useful information throughout the manual.



IMPORTANT

PLEASE READ THIS OPERATORS MANUAL CAREFULLY

It contains important safety information, instructions, and necessary operating procedures. The continual observance of these procedures will help increase your production and extend the life of the equipment.



SAFETY INSTRUCTIONS

LEARN TO RECOGNIZE SAFETY INFORMATION

This is the safety alert symbol. When you see this symbol on your machine or in this manual, **BE ALERT TO THE POTENTIAL FOR PERSONAL INJURY!**



Follow recommended precautions and safe operating practices.

UNDERSTAND SIGNAL WORDS

A signal word – **DANGER**, **WARNING**, or **CAUTION** is used with the safety alert symbol. **DANGER** identifies a hazard or unsafe practice that will result in severe **Injury or Death**.



Safety signs with signal word **DANGER** or **WARNING** are typically near specific hazards.





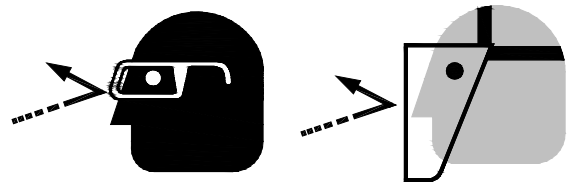
General precautions are listed on **CAUTION** safety signs. **CAUTION** also calls attention to safety messages in this manual.

SAVE THESE INSTRUCTIONS.
Refer to them often and use them to instruct others.



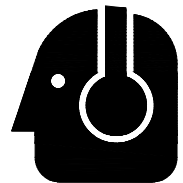
PROTECT EYES

Wear safety glasses or suitable eye protection when working on or around machinery.



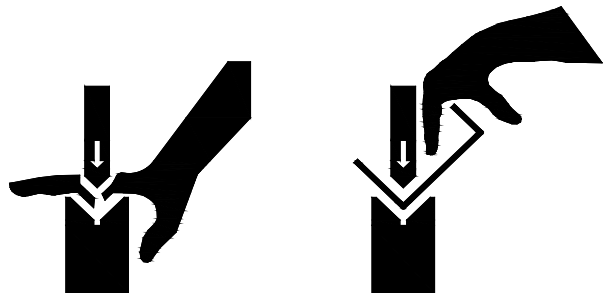
PROTECT AGAINST NOISE

Prolonged exposure to loud noise can cause impairment or loss of hearing. Wear suitable hearing protective devices such as ear muffs or earplugs to protect against objectionable or uncomfortable loud noises.



BEWARE OF CRUSH HAZARD

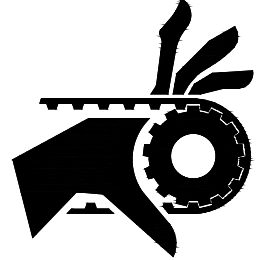
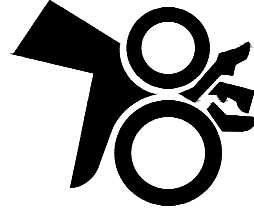
NEVER place your hands, fingers, or any part of your body in the die area of this machine. Be aware of the area on either side of the dies for crush points created by material movement.





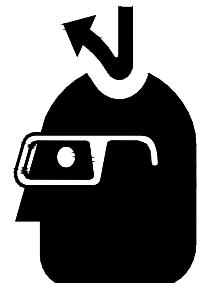
BEWARE OF PINCH POINTS

Keep hands and fingers away from the drive mechanisms, cylinders, ratchets, and other moving linkage while the machine is in operation.



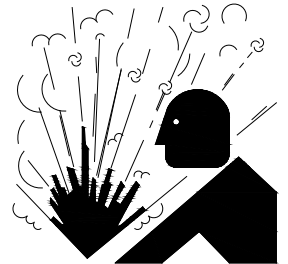
KEEP CLEAR OF MOVING OBJECTS

Always be aware of the position of the material and the swing area in which the material will travel. The material will swing with significant force. This swing area will create pinch points and the force of the material movement may cause serious bodily injuries.



HYDRAULIC HOSE FAILURE

Exercise **CAUTION** around hydraulic hoses in case of a hose or fitting failure.



HIGH VOLTAGE

USE CAUTION IN HIGH VOLTAGE AREAS. DO NOT assume the power to be off.
FOLLOW PROPER LOCKOUT PROCEDURES.





SAFETY PRECAUTIONS



Metal working can be dangerous if safe and proper operating procedures are not followed. As with all machinery, there are certain hazards involved with the operation of the product. Using the machine with respect and caution will considerably lessen the possibility of personal injury. However, if normal safety precautions are overlooked or ignored, personal injury to the operator may result.

Safety equipment such as guards, hold-downs, safety glasses, dust masks and hearing protection can reduce your potential for injury. But even the best guard won't make up for poor judgment, carelessness or inattention. **Always use common sense** and exercise **caution** in the workshop. If a procedure feels dangerous, don't try it.

REMEMBER: Your personal safety is your responsibility.



WARNING: FAILURE TO FOLLOW THESE RULES MAY RESULT IN SERIOUS PERSONAL INJURY

1. **Only trained and qualified personnel can operate this machine.**
2. **Make sure guards are in place and in proper working order before operating machinery.**
3. **Remove any adjusting tools.** Before operating the machine, make sure any adjusting tools have been removed.
4. **Keep work area clean.** Cluttered areas invite injuries.
5. **Overloading machine.** By overloading the machine you may cause injury from flying parts. **DO NOT** exceed the specified machine capacities.
6. **Dressing material edges.** Always chamfer and deburr all sharp edges.
7. **Do not force tool.** Your machine will do a better and safer job if used as intended. **DO NOT** use inappropriate attachments in an attempt to exceed the machines rated capacity.
8. **Use the right tool for the job. DO NOT** attempt to force a small tool or attachment to do the work of a large industrial tool. **DO NOT** use a tool for a purpose for which it was not intended.
9. **Dress appropriate. DO NOT** wear loose fitting clothing or jewelry as they can be caught in moving machine parts. Protective clothing and steel toe shoes are recommended when using machinery. Wear a restrictive hair covering to contain long hair.
10. **Use eye and ear protection.** Always wear ISO approved impact safety goggles. Wear a full-face shield if you are producing metal filings.



11. **Do not overreach.** Maintain proper footing and balance at all times. **DO NOT** reach over or across a running machine.
12. **Stay alert.** Watch what you are doing and use common sense. **DO NOT** operate any tool or machine when you are tired.
13. **Check for damaged parts.** Before using any tool or machine, carefully check any part that appears damaged. Check for alignment and binding of moving parts that may affect proper machine operation.
14. **Observe 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. **DO NOT** use electrically powered tools in the presence of flammable gases or liquids.
15. **Keep children away.** Children must never be allowed in the work area. **DO NOT** let them handle machines, tools, or extension cords.
16. **Store idle equipment.** When not in use, tools must be stored in a dry location to inhibit rust. Always lock up tools and keep them out of reach of children.
17. **DO NOT operate machine if under the influence of alcohol or drugs.** Read warning labels on prescriptions. If there is any doubt, **DO NOT** operate the machine.
18. **DO NOT** touch live electrical components or parts.
19. **Turn off** power before checking, cleaning, or replacing any parts.
20. Be sure **all** equipment is properly installed and grounded according to national, state, and local codes.
21. **DO NOT** bypass or defeat any safety interlock systems.
22. Keep visitors a safe distance from the work area.



TECHNICAL SPECIFICATIONS

Maximum Center Line Radius (CLR)*	9" (229mm)
Minimum Center Line Radius (CLR)*	.5" (12.7mm)
Minimum OD	.25" (6.35mm)
Mild Steel Pipe (Schedule 40) Based on a material tensile strength of 60000 PSI – mild steel	2" (50.8mm)
Aluminum Pipe (Schedule 40)	2" (50.8mm)
Stainless Steel Pipe (Schedule 40)	1.5" (38.1mm)
Mild Steel Round Tube (Wall)	2.5" (.125) (63.5mm [3.175mm])
Aluminum Round Tube (Wall)	2.5" (.156) (63.5mm [3.96mm])
Stainless Steel Round Tube (Wall)	2.375" (.125) (60.325mm [3.175mm])
Chromolly Round Tube (Wall)	2" (.125) (50.8mm [3.175mm])
Mild Steel Solid Rod	1.25" (31.75mm)
Mild Steel Square Tube (Wall)	2" (.125) (50.8mm [3.175mm])
Power Supply	240VAC, 15A, 1ph, 50Hz
Sound level	<70db
Shipping Weight (Lbs.)	700lbs. (318kg)
Shipping Dimensions (L x W x H)	68 x 60" x 44" (1727 x 1524 x 1118mm)

*CLR will vary based upon actual material and wall thickness.



Note: The photos illustrations used in this manual are representative only and may not depict the actual color, labeling or accessories and may be intended to illustrate technique only.



Note: The specifications and dimensions presented here are subject to change without prior notice due to improvements of our products.



UNPACKING AND CHECKING CONTENTS

Your Baileigh machine is shipped complete in one crate. Separate all parts from the packing material and check each item carefully. Make certain all items are accounted for before discarding any packing material.



WARNING: SUFFOCATION HAZARD! Immediately discard any plastic bags and packing materials to eliminate choking and suffocation hazards to children and animals.

If any parts are missing, do not plug in the power cable, or turn the power switch on until the missing parts are obtained and installed correctly.

Cleaning

Your machine may be shipped with a rustproof waxy oil coating and grease on the exposed unpainted metal surfaces. To remove this protective coating, use a degreaser or solvent cleaner. For a more thorough cleaning, some parts will occasionally have to be removed. **DO NOT USE** acetone or brake cleaner as they may damage painted surfaces. Follow manufacturer's label instructions when using any type of cleaning product. After cleaning, wipe unpainted metal surfaces with a light coating of quality oil or grease for protection.



WARNING: DO NOT USE gasoline or other petroleum products to clean the machine. They have low flash points and can explode or cause fire.



CAUTION: When using cleaning solvents work in a well-ventilated area. Many cleaning solvents are toxic if inhaled.





TRANSPORTING AND LIFTING



CAUTION: Lifting and carrying operations should be carried out by skilled workers, such as a truck operator. Make sure the machine is well balanced. Choose a location that will keep the machine free from vibration and dust from other machinery. Keep in mind that having a large clearance area around the machine is important for safe and efficient working conditions.

Follow these guidelines when lifting:

- The lift truck must be able to lift at least 1.5 – 2 times the machines gross weight.
- Make sure the machine is balanced. While transporting, avoid rough or jerky motion, and maintain a safe clearance zone around the transport area.
- Use a fork lift with sufficient lifting capacity and forks that are long enough to reach the complete width of the machine.
- Remove the securing bolts that attach the machine to the pallet.
- Approaching the machine from the side, lift the machine on the frame taking care that there are no cables or pipes in the area of the forks.
- Move the machine to the required position and lower gently to the floor.
- Level the machine so that all the supporting feet are taking the weight of the machine and no rocking is taking place.

INSTALLATION

IMPORTANT:

Consider the following when looking for a suitable location to place the machine:

- Overall weight of the machine.
- Weight of material being processed.
- Sizes of material to be processed through the machine.
- Space needed for auxiliary stands, work tables, or other machinery.
- Clearance from walls and other obstacles.
- Maintain an adequate working area around the machine for safety.
- Have the work area well illuminated with proper lighting.



- Keep the floor free of oil and make sure it is not slippery.
- Remove scrap and waste materials regularly, and make sure the work area is free from obstructing objects.
- If long lengths of material are to be fed into the machine, make sure that they will not extend into any aisles.
- **LEVELING:** The machine should be sited on a level, concrete floor. For stationary machines, provisions for securing it should be in position prior to placing the machine. The accuracy of any machine depends on the precise placement of it to the mounting surface.
- **FLOOR:** This tool distributes a large amount of weight over a small area. Make certain that the floor is capable of supporting the weight of the machine, work stock, and the operator. The floor should also be a level surface. If the unit wobbles or rocks once in place, be sure to eliminate by using shims.
- **WORKING CLEARANCES:** Take into consideration the size of the material to be processed. Make sure that you allow enough space for you to operate the machine freely.
- **POWER SUPPLY PLACEMENT:** The power supply should be located close enough to the machine so that the power cord is not in an area where it would cause a tripping hazard. Be sure to observe all electrical codes if installing new circuits and/or outlets.

ASSEMBLY AND SET UP



WARNING: For your own safety, **DO NOT** connect the machine to the power source until the machine is completely assembled and you read and understand the entire instruction manual.

1. Remove the machine from the skid it was shipped on and install the casters and wheels.
2. Check the oil level and top off if necessary.
3. Read through the remainder of the manual and become familiar with the die installation and settings as well as normal operation.
4. Position the machine as desired following the installation guidelines.
5. Follow the electrical guidelines to connect the machine to a power supply.



GETTING TO KNOW YOUR MACHINE





Item	Description	Function
A	Forward Foot Pedal	Will operate the machine in the cw direction
B	Reverse Foot Pedal	Will operate the machine in the ccw direction
C	Power Switch	For turning power on/off to the bender
D	Allen Wrench	Used for adjusting and tightening the ratchet slide plate.
E	Bend Angle Controller	For programming bend angle and displaying the bend angle position.
F	Hydraulic Cylinders	Supply the bending force to rotate the forming die.
G	Main Spindle And Drive Pins (shown with a forming die installed)	For supporting and driving the forming die.
H	Quick Release (shown with a counter die installed)	For pivoting counter die away from bend die to remove material quickly.
I	Grease Zerk	For greasing main spindle bearing
J	Encoder	Recording the spindle rotation and sending that information back to the controller to display the bend angle and stop bending at the programmed angle.

GENERAL DESIGN DESCRIPTION

You have made a practical choice in purchasing the RDB-175 Hydraulic Bending Machine. It has been carefully built of high quality materials and designed to give many years of efficient service. The simplicity of design and minimum effort required to operate the machine contributes towards meeting schedules and producing greater profits.

The RDB-175 is an electric powered hydraulically operated “Rotary Draw” bending machine. To bend material, a bending die and counter die are required. The material is hooked by the bending dies’ hook arm and is powerfully rotated in the clockwise direction. As the bending die rotates, the counter die arm also rotates about the same axis, forcing the material to conform to the radius and shape of the bending die.

The RDB-175 Bending Machine you have purchased is built of solid steel ensuring maximum rigidity. Tongue and groove design with grade 8 bolts throughout provides very high rigidity and stability.

Throughout this manual are listed various safety-related descriptions for attention. These matters for attention contain the essential information to the operators while operating, and maintaining. Failure to follow these instructions may result in great damage to the machine or injury to the operator.



ELECTRICAL



CAUTION: HAVE ELECTRICAL UTILITIES CONNECTED TO MACHINE BY A CERTIFIED ELECTRICIAN!

Check if the available power supply is the same as listed on the machine nameplate.



WARNING: Make sure the grounding wire (green) is properly connected to avoid electric shock. DO NOT switch the position of the green grounding wire if any electrical plug wires are switched during hookup.

Motor Specifications

Your tool is wired for 240 volt, 50Hz alternating current. Before connecting the tool to the power source, make sure the machine is cut off from power source.

Considerations

- Observe local electrical codes when connecting the machine.
- The circuit should be protected with a time delay fuse or circuit breaker with a amperage rating slightly higher than the full load current of machine.
- A separate electrical circuit should be used for your tools. Before connecting the motor to the power line, make sure the switch is in the "OFF" position and be sure that the electric current is of the same characteristics as indicated on the tool.
- All line connections should make good contact. Running on low voltage will damage the motor.
- In the event of a malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This tool is equipped with an electric cord having an equipment-grounding conductor and a grounding plug. The plug must be plugged into a matching outlet that is properly installed and grounded in accordance with all local codes and ordinances.



WARNING: In all cases, make certain the receptacle in question is properly grounded. If you are not sure, have a qualified electrician check the receptacle.



- Improper connection of the equipment-grounding conductor can result in risk of electric shock. The conductor with insulation having an outer surface that is green with or without yellow stripes is the equipment-grounding conductor. If repair or replacement of the electric cord or plug is necessary, do not connect the equipment-grounding conductor to a live terminal.
- Check with a qualified electrician or service personnel if the grounding instructions are not completely understood, or if in doubt as to whether the tool is properly grounded.
- Repair or replace damaged or worn cord immediately.

Extension Cord Safety

Extension cord should be in good condition and meet the minimum wire gauge requirements listed below:

AMP RATING	LENGTH		
	25ft	50ft	100ft
0-6	16	16	16
7-10	16	16	14
11-12	16	16	14
13-16	14	12	12
17-20	12	12	10
21-30	10	10	No
WIRE GAUGE			

An undersized cord decreases line voltage, causing loss of power and overheating. All cords should use a ground wire and plug pin. Replace any damaged cords immediately.



OPERATION

⚠ CAUTION: Always wear proper eye protection with side shields, safety footwear, and leather gloves to protect from burrs and sharp edges.

⚠ CAUTION: Keep hands and fingers clear of the dies and swing arms. Stand to the front of the machine to avoid getting hit with the material during the bending process. When handling large heavy materials make sure they are properly supported.

Dry Running Machine

Before actually bending, several “dry runs” should be performed. This will remove any trapped air from the cylinders and hoses. Also, this will familiarize you with the controls and functions of the machine. To do this, set a bend angle and then activate the hydraulics to extend and retract the cylinders to simulate a bend.

Setting Bend Angle

1. Reverse machine until both cylinders are fully retracted.
2. Set the digital controller to “0” by pressing the “F1/RST (reset)” button. The lower green number is preset position and the top red number is the machine position.
3. In order for the machine to function the digital control needs to have a stop point programmed for more than 5 degrees.
4. Press the “Right/Down” arrow key to activate the lower preset degree field. Pressing the “Right/Down” arrow key will highlight each digit field. The digit field will slowly blink when highlighted. Machine will only bend to 200 degrees. The cylinders will deadhead when the reach full extension.
5. When the digit is highlighted, press the “UP” arrow key to change to the desired digit in that field.
6. When the desired bend degree is entered, press the “Circle” button to save. The machine will now stop at this preset degree.





7. The digital control and preset should only be used in whole degrees. For example 90, 91, 92 not 90.1 or 90.5. If any number is entered after the decimal the control will add 1 to the final degree. So it's best to leave it at 0.

8. If you want to compensate for spring back the "0" position can be set anywhere.

- For example: Take a piece of material and insert it into the die and close the counter die.
- Activate the FWD pedal until the material just starts to bend.
- Set your "0" point here and that should compensate for most of your spring back.
- Now the preset value can be entered exactly to the desired degree + / -.



9. Another way is to "Add on" spring back values to the preset.

- To do this set your "0" position with the cylinders fully retracted.
- Insert material and bend a part to exactly 90° using a framing square.
- When still at the final position. Document the actual machine position.
- For example: If the control reads 105° take $105 - 90 = 15^\circ$ (90 deg being your desired bend angle). This will be the value you will add to your nominal degree setting when entering preset values.



10. There is no right or wrong way to use this control. It is purely the user's preference.



Home position with 90° Preset Stop Point.



Stop position with 90° Preset Stop Point.



DIE SELECTION AND INSTALLATION

Before any bending can take place, the proper die set must be chosen to match the material being bent. (EX) 1-1/2" diameter tubing requires a die set marked 1-1/2" tube.

- A Hook Arm
- B Bend Die
- C Hold down Bolts
- D Plastic Slide
- E Counter Die Mount
- F Bronze Counter Die Insert
- G "0" Mark



Note: Pipe and Tube are not the same, (see table 1) for nominal pipe sizes. All RMD dies are color coded to avoid confusion between pipe and tube (see table 2).



IMPORTANT: Damaged or worn tooling should be replaced before attempting to bend material. This will ensure that bends are correct and provide a longer life to machine components. When handling large heavy dies and/or material, make sure it is properly lifted and supported.

1. To install the die, slip the die over the centering pin until the three unequally spaced drive pins engage the receiving holes formed in the die.

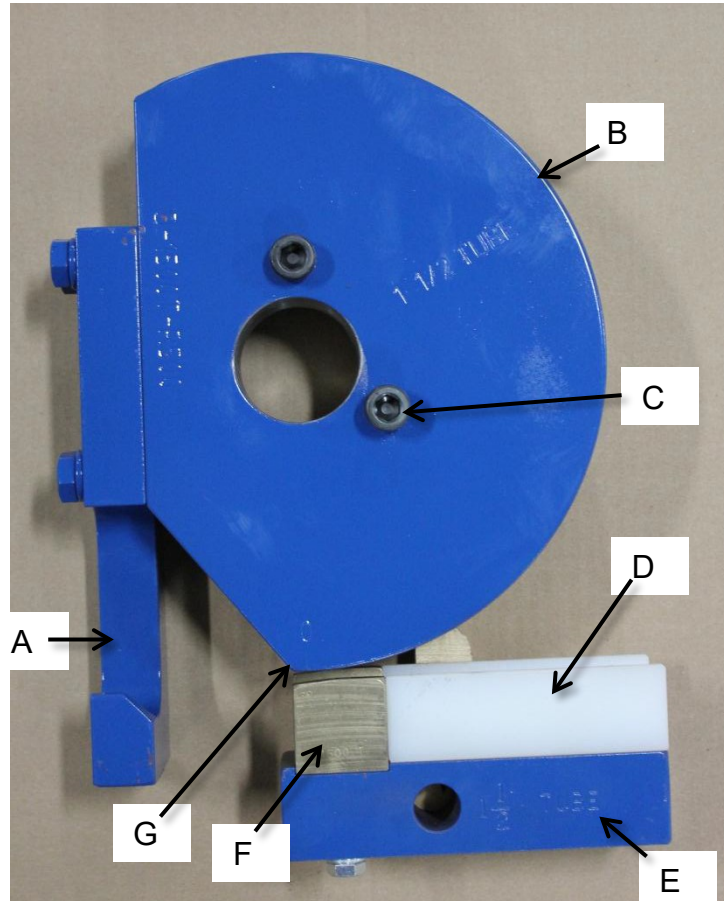


Note: The die will only fit one way.

2. When the drive pins line up the die will drop all the way down to the spindle.
3. Install and tighten the 1/2-13 socket head bolts provided with the die. Tighten these bolts enough to hold the die firmly down to the spindle. Approximately 30-40ft-lb. (40-50N•m).



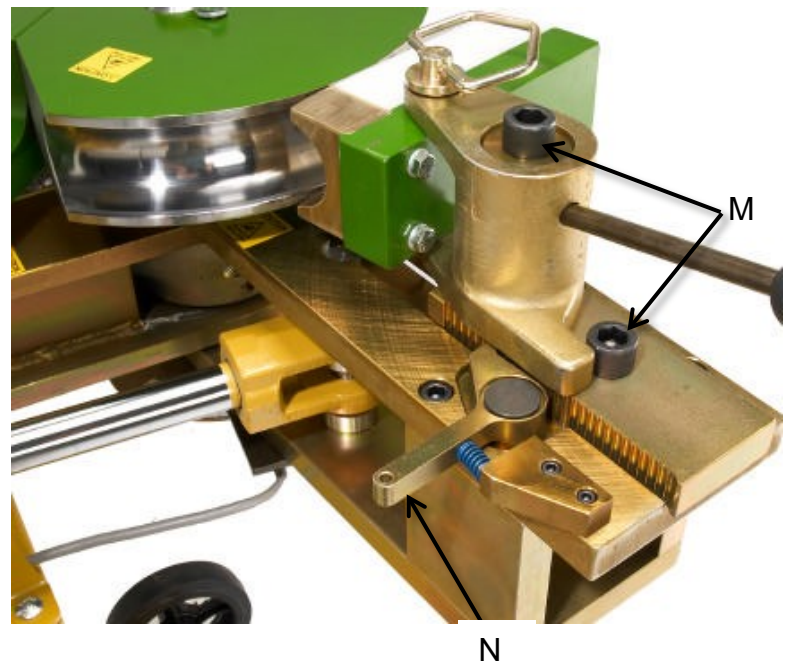
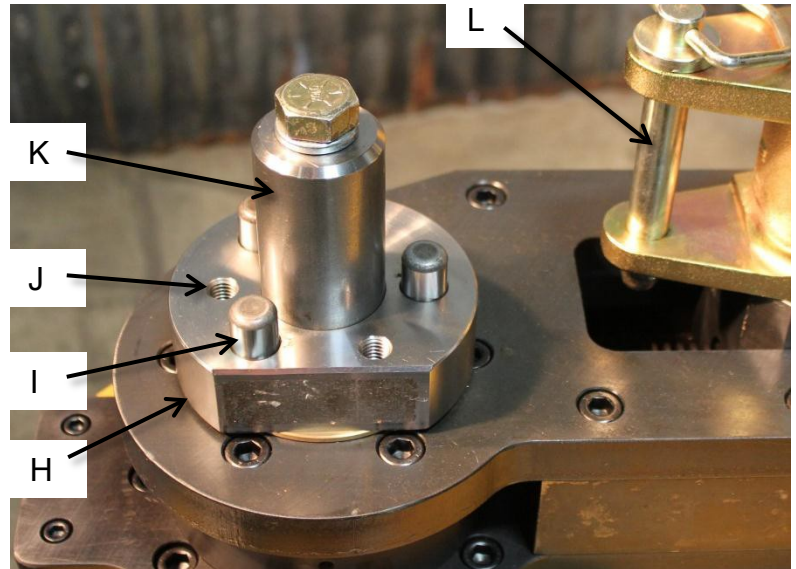
IMPORTANT: FAILURE TO PROPERLY BOLT DOWN DIE WILL RESULT IN DAMAGE TO MACHINE AND TOOLING.





- H Spindle
- I Die Drive Pins
- J 1/2-13 Tapped holes for bolting down dies
- K Center Pin
- L Hitch Pin

4. To install the counter die, remove the hitch pin and insert the counter die in the opening in the counter die mount until the 3/4" holes line up.
5. Now insert the hitch pin through all the holes, reinstall clip on the hitch pin with the engraved side of the counter die facing up.
6. The counter die should be positioned approximately 1/8" (3mm) away from the die. This can be accomplished by loosening the two socket head bolts (M) which hold the counterdie pin tight.
7. Pull on the ratchet lock mechanism (N) and slide the whole assembly so that the counterdie is approximately 1/8" away from the die.
8. Tighten the two socket head bolts to 200lbf ft. (27Nm).



IMPORTANT: THE RATCHET WILL FAIL IF THE BOLTS ARE NOT TIGHTENED PROPERLY.

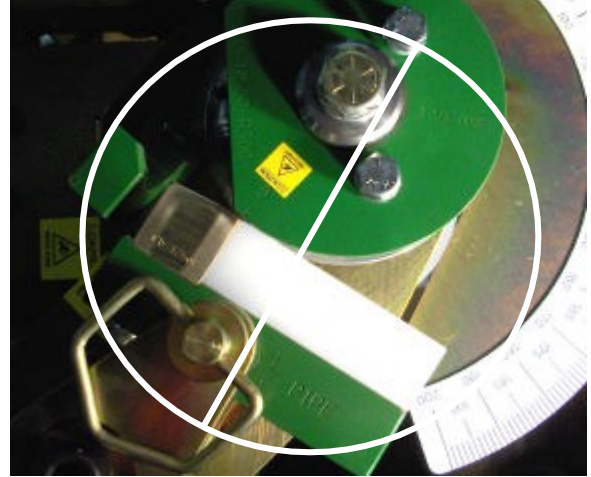
The ratcheting mechanism is for POSITIONING ONLY. The two 3/4-10 bolts hold the mechanism in place against the force generated during bending. Use the supplied wrench plus any needed assistance to achieve the proper torque.



Incorrect Counterdie Position



Too far away from die




Touching die

Correct Counter Die Position



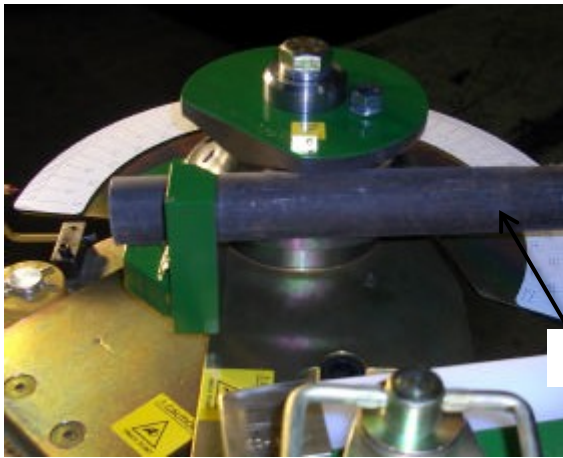
Approximately 1/8" (3mm) away

 **IMPORTANT:** Be sure the long end of the counter die points away from the hook arm, or to the right of machine.



Material Insertion

1. Once the die set is properly installed, the material that matches the die can be inserted (I.E. 1-1/4" tube would go into a die mark D-1250T-R***).
2. Open the counter die quick release assembly and insert the material past the hook arm. The start of bend mark is engraved with an "O" on the top of the die. Once the material is placed properly, the counter die slide block assembly can be tightened.



Inserting material to start



Lubricating counter die bending



Important: Liberally apply lubricant along the counterdie and the 1/2 of the material that contacts the counter die (A) with a WD-40 style lubricant or equivalent. Do not lubricate the bending die. Lubricating the bending die will encourage slipping of material in the bending die.

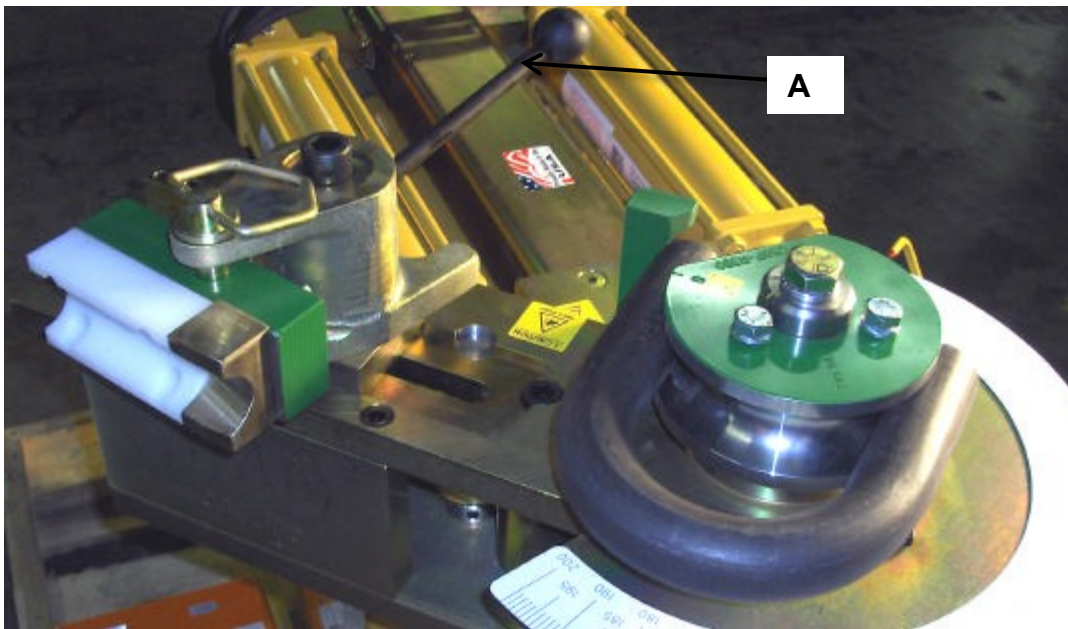
3. Rotate the quick release counter die assembly until it firmly stops against its stop bolt. In some cases usually with pipe the quick release will not close all the way. This is ok, as the forward foot pedal is activated the material will force its way into the die and bend properly.
4. After the material is installed, bending can take place.
5. Turn on the power switch.
6. Set the desired bend angle on the bend angle controller.
7. Keep hands away from the bending zone.
8. Press the right foot pedal switch to rotate the die forward. Keeping the foot pedal activated, visually watch the digital display. The cylinders will stop when the forming die rotates to the desired bend angle as shown on the controller. The material will need to be bent past desired degree as all material has some degree of "springback". This varies by material and can even vary between the same grades of material.



9. If the bend requires more degrees. The controller will need to be set at a higher degree number. Increase the degrees by further activating the forward foot pedal switch. This allows the operator to gradually reach a bend angle, on the first set up piece. To determine the amount of springback for a certain material, it is necessary to bend a sample piece. Using a framing square or the like, bend a piece of material until a perfect 90° bend is achieved, when checked with a square. At that point, document the machines degree position. For example to achieve a 90° on the piece in the picture, 105 degrees was the total bend amount or 15 degrees of springback. Now you can add 15 degrees to any nominal bend angle to achieve accurate results for this material.

Material Removal

1. After reaching the desired angle, the material needs to be removed.
2. Press the reverse (left) foot pedal. Both the die and the counter die will retract simultaneously. Run in reverse until all bending pressure is released from the bend.



Activating the quick release lever

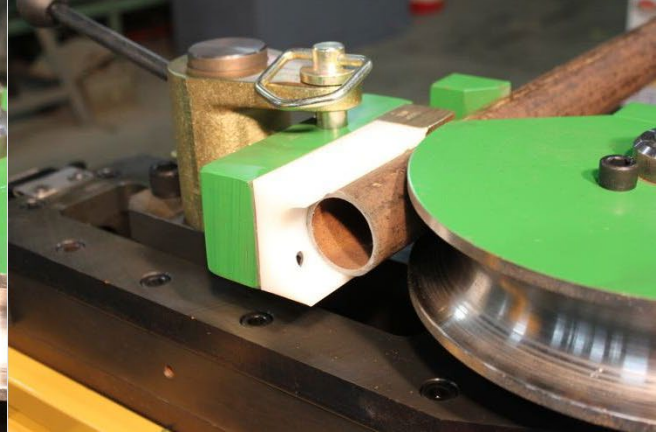
3. Activate the quick release counter die lever (A) and completely remove the material.
4. After the material is safely removed, press the reverse (left) foot pedal keeping hands clear until both cylinders fully retract.
5. The machine is now at the “home” position and can be reloaded for the next bend.
6. Repeat previous steps.



Material Insertion Limitations



Left



Right

- The left figure shows the recommended minimum / correct amount of material remaining to be fully supported in plastic slide.
- The right figure shows the maximum amount the material can be pulled through the counter die. Pulling the material further than shown into the counter die, it will destroy the plastic slide.
- Extreme care must be taken when bending material with an existing bend. There must be enough straight material to complete the bend. If there is not enough material the bent part of the material will crash into the counter die and damage the machine and tooling. In the left figure, there is not enough material to complete a 90deg. bend. This bend will damage the dies.



IMPORTANT: Orienting your material in this fashion will cause damage to your tooling and machine!! DO NOT pull bent material into the counter die! Make sure you have enough straight material on the draw side of the material to create your bend.



Bending More than 180 Degrees

- This machine is capable of bending more than 180 degrees. Contact Baileigh Industrial about your application.
 - It will require a password to make the machine go past 200 degrees.
 - Requires special tooling to allow removal of bent part. If standard tooling is used, the material will be locked onto the die.

UNDERSTANDING SPRINGBACK

Springback can be difficult to understand. As material is bent, the materials yield strength resists being formed. As a final degree is reached, the machine will have enough power to hold the bend at a set degree, but as the pressure of the machine is released, the material has a resistance built in, so it “springs back”

Springback will vary with every size, type and wall thickness, so it will never be consistent from size to size.

The best way to determine a materials springback is to do sample bends to 90 degrees until a perfect 90 is obtained.

- At that point document the actual machine degrees.
- Full manual mode is the best place to do these tests.
- Use the overbend amount and enter that value into the springback field.

MATERIAL SELECTION



CAUTION: It must be determined by the customer that materials being processed through the machine are NOT potentially hazardous to operator or personnel working nearby.

When selecting materials keep these instructions in mind:

- Material must be clean and dry. (without oil)
- Material should have a smooth surface so it processes easily.
- Dimensional properties of material must be consistent and not exceed the machine capacity values.
- Chemical structure of material must be consistent.
- Buy certificated steel from the same vendor when possible.



Material Layout

In order to create accurate parts, you will have to layout the material in flat form. First you will need to determine how much material is used per degree of bend. Use the multiplier table on Table #3 to determine the arc lengths for the die in use. Or use the following formula:

Alternate arc length formula:

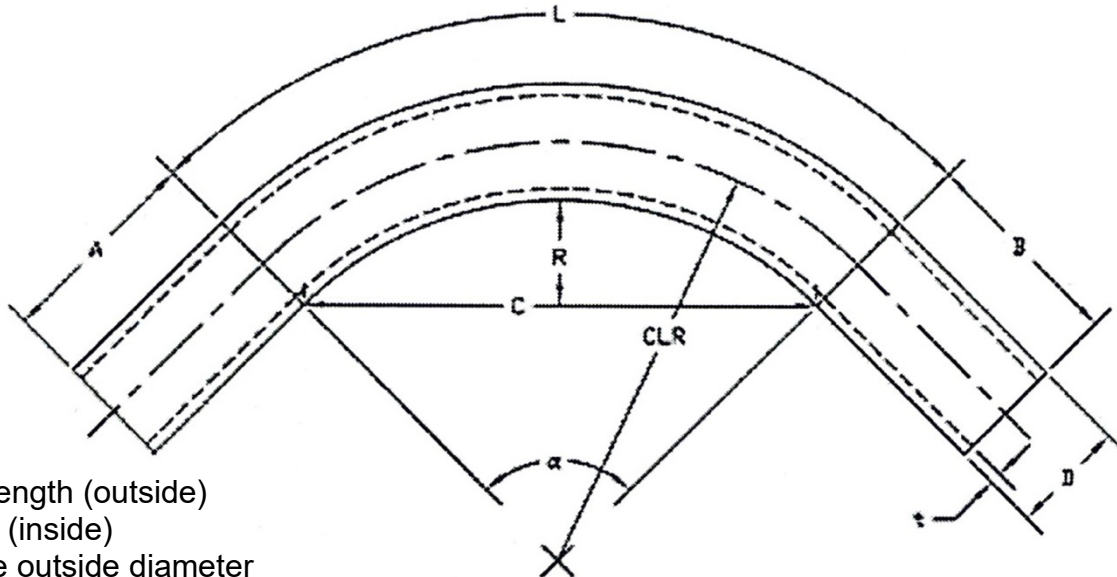
Example: $6.0 \text{ clr} \times 2 = 12$ $12 \times 3.14 = 37.699$ $37.699 / 360 = 0.1047''$ per degree
 $0.1047 \times 90 \text{ degrees} = 9.425''$ of material used for a 90 degree bend.

Once the arc lengths are determined you can begin layout of the material using Diagram #1 as a reference.

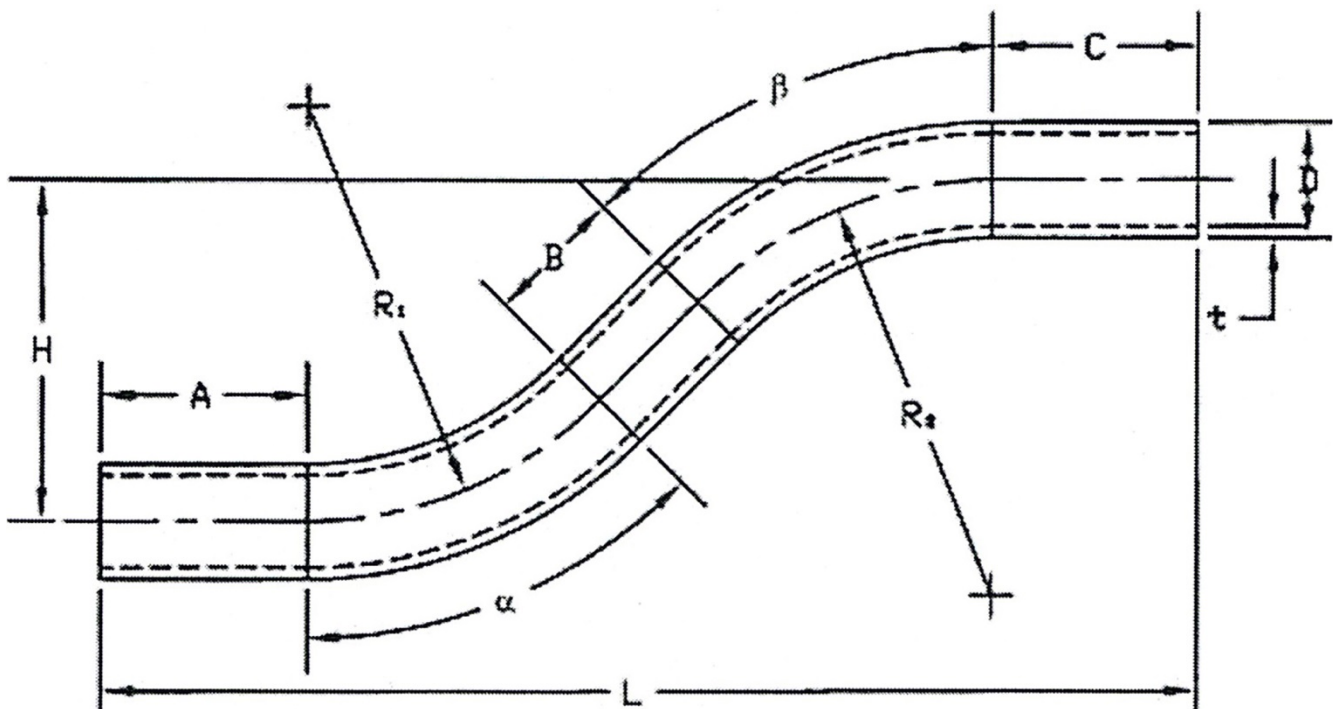
- Diagram #1 shows a simple part bent on the same plane in the same direction.
- Diagram #2 shows bending based off of a centerline in two directions.
- For symmetrical bends, centerline bending is easiest.
- For non-symmetrical bends, continuous one direction bending is best.
- Another way to layout material is to draw them in a 2D computer software program like Auto Cad. There are many free programs on the internet. In a 2D program you will draw the parts centerline only with corresponding clr's. Then you will be able to list individual segments of the bent part. This data can be directly entered into the control.
- Another program available is BEND-TECH which is a program specifically designed for tube bending and will give you all of the required data to make a part. This software is available from Baileigh Industrial. Contact your distributor for availability.
- Bending with a rotary draw bender requires determining the start of bend point which will line up with the "0" mark on the die. The portion of the tube toward the hook arm will be locked to the die, the portion toward the counter die is the draw side and will slide along the counter die and conform to the dies shape/radius.



PIPE AND TUBE BENDING DIAGRAMS



L = Arc length (outside)
 R = Rise (inside)
 D = Tube outside diameter
 t = Tube wall thickness



a = First bend arc angle
 b = Second bend arc angle
 A = First tangent
 B = Straight between bends
 C = Second tangent
 D = Tube outside diameter
 H = Height of offset
 L = Length of offset
 R_1 = First radius
 R_2 = Second radius
 t = Tube Wall Thickness



BENDING GLOSSARY

Arc Length	The length of material along the centerline of the tubing
Centerline Radius (CLR)	Distance in inches from the center of curvature to the centerline axis of the tube bending or pipe bending bends. Abbreviated as CLR. See Tube Bending and Pipe Bending Diagram
Degree	Angle in degrees to which the tube/pipe bends are formed (i.e. 45 degrees, 90 degrees, 180 degrees, etc.)
Easy Way (EW)	Bending of a rectangular tube with its short side in the plane of the tube or pipe bend
Hard Way (HW)	Bending of a rectangular tube with its long side in the plane of the tube or pipe bend
I.D.	Inside diameter of the tube or pipe bends
Minimum Tangent	The minimum straight on the end of pipe bends required by the bending machine to form the bend
Neutral Axis	That portion of the pipe or tube that is neither in compression or tension.
O.D.	Outside diameter in inches of the tube or pipe
Out of Plane	The deviation of the horizontal plane of a single pipe bend between its tangent points, based on the theoretical center-line of the pipe bend
Ovality	The distortion or flattening of pipe or tube from its normal, round shape caused by the pipe bending process
Springback	Amount of degrees material will return after bending pressure is released
Tangent	The straight portion of material on either side of arc of bending bends. See Tube Bending and Pipe Bending Diagrams.
Tangent Point	The point at which the bend starts or ends. See Tube Bending and Pipe Bending Diagrams.
Wall	The thickness in inches of tubular pipe bending material.
Wrinkles	Waving or corrugation of pipe bending bends in the inner radius.



BENDING SUGGESTIONS

Aluminum Bending

If bending aluminum, lubrication is very important, if the results are less than desirable with WD-40 other lubricants can be used such as:

- Johnson Paste Wax (seems to work the best)
- High Pressure grease
- Highly rich dish soap
- The bronze counter die must be polished and have no aluminum deposits or it will continue to pick up metal.
- If using RMD's standard counter die is not producing desired results, roller counter dies are also available.
- RMD has both steel rollers as well as plastic rollers. Plastic rollers are used primarily for polished aluminum. Steel rollers would be used for non-polished materials.
- Some aluminum will crack as it is being bent, 6061-T6 is very hard and may need to be annealed or ordered in the "T-0" condition. Aluminum will age harden so if possible try to get freshly run material.

Heavy Wall DOM tubing

If heavy wall materials are bent to a tight radius, they can tend to slip in the hook arm causing a poor bend result, below are some suggestions

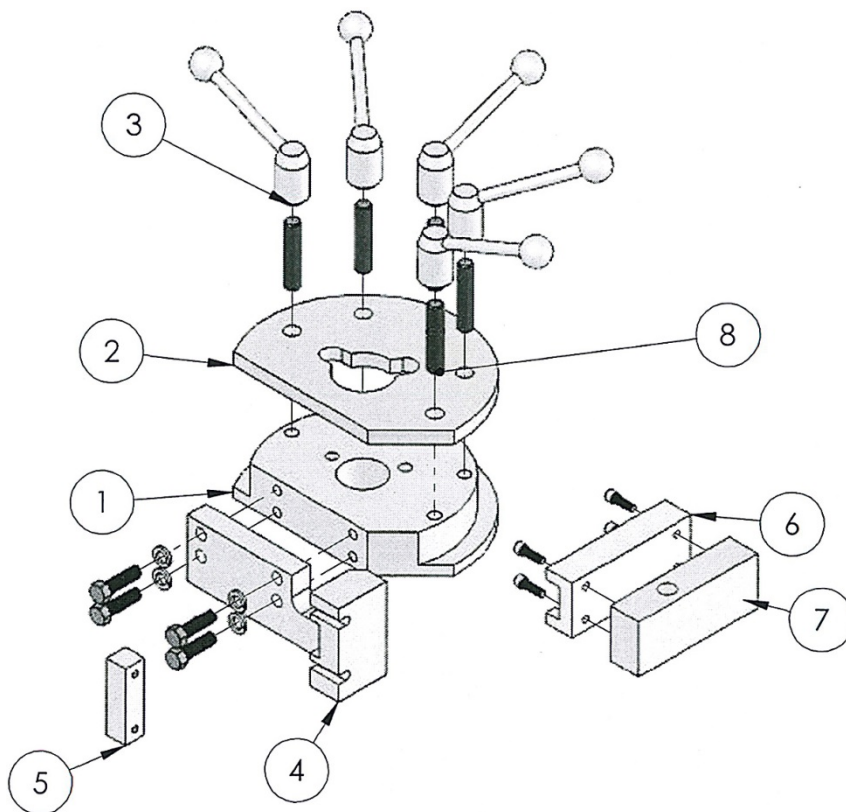
- Use a vise clamp on the outside of the hook arm to "lock" the material in place.
- Use a piece of two sided coarse emery cloth in between the hook arm and the material, this works very well.
- In only this application, high pressure grease applied to the DIE GROOVE also helps.
- RMD can make special clamps to hold material in place.



Bending With Square Dies

• Die Parts

- 1 Main Bending Die
- 2 Die Cap
- 3 Quick Release Handles
- 4 Hook-Arm
- 5 Hook-Arm Clamp
- 6 Plastic Slide
- 7 Slide Mount
- 8 Quick Release Studs



Square Tooling Setup

1. Install the bending die (1) on to the spindle. Be careful not to pinch your fingers as you lower the die on to the spindle. The die will only fit on the spindle one way. Bolt the die to the spindle using the holes in the die.
2. Install the plastic counter die assembly (6, 7) with the long end pointing away from the hook arm.
3. Snug up the cap clamps (3). Do not over tighten! Or they will be overly difficult to loosen after the bend is complete. Note: tighten clamps without material in the die. The clamps are lift and turn, so you can position them anywhere. This allows the handles to clear the counter-die mount during bending.
4. Insert the material in to the hook arm (4) and pull in to the die. It may be a tight fit. Continue to pull until the material is fully seated in the die's groove.
5. Lube the counter die and the material that will slide along the counter die. Bring the plastic counter die assembly up to the material, leaving about 1/8" to 1/4" gap. (Note: on some thinner material it helps to keep the counter die approx. 1" away from the material)



IMPORTANT: Do not lube the bending die surfaces. This will increase the possibility for slippage. Make sure all the die cap clamp handles (3) are inside the die diameter. They could catch the counter die mounting assembly and break off.



6. If the material slips during the bending operation, install the hook arm clamp (5). Do not use it unless you have to.
7. Activate the bender and bend to the desired angle.
8. To remove the material, open the counter die and return bender to the "home position". Using a soft mallet, gently tap the cap clamps open and the material will spring out of the die (1). Remove the material and re-snug the cap clamps.
9. Install the next piece of material to be bent and repeat these steps.

Large Size Square

When bending larger than 1.5" (38.1mm) thinner wall square tubing, the counter die position seems to work better between 1/2" and 1" (12.7-25.4mm) farther away from the die. This seems to reduce side wall distortion and inner wrinkling. Although this suggestion is to help on large size, the same steps can be used for any square, if trying to achieve better results. If the square material slips in the hook arm, use the supplied clamp and bolts to hold in place.

RMD offer crush bend dies to form a concave crease on the inside of square bends to reduce the possibility of wrinkling.



LUBRICATION AND MAINTENANCE



WARNING: Make sure the electrical disconnect is OFF before working on the machine.

Maintenance should be performed on a regular basis by qualified personnel.

Always follow proper safety precautions when working on or around any machinery.

- Check daily for any unsafe conditions and fix immediately.
- Check that all nuts and bolts are properly tightened.
- On a weekly basis clean the machine and the area around it.
- Lubricate threaded components and sliding devices.
- Apply rust inhibitive lubricant to all non-painted surfaces.

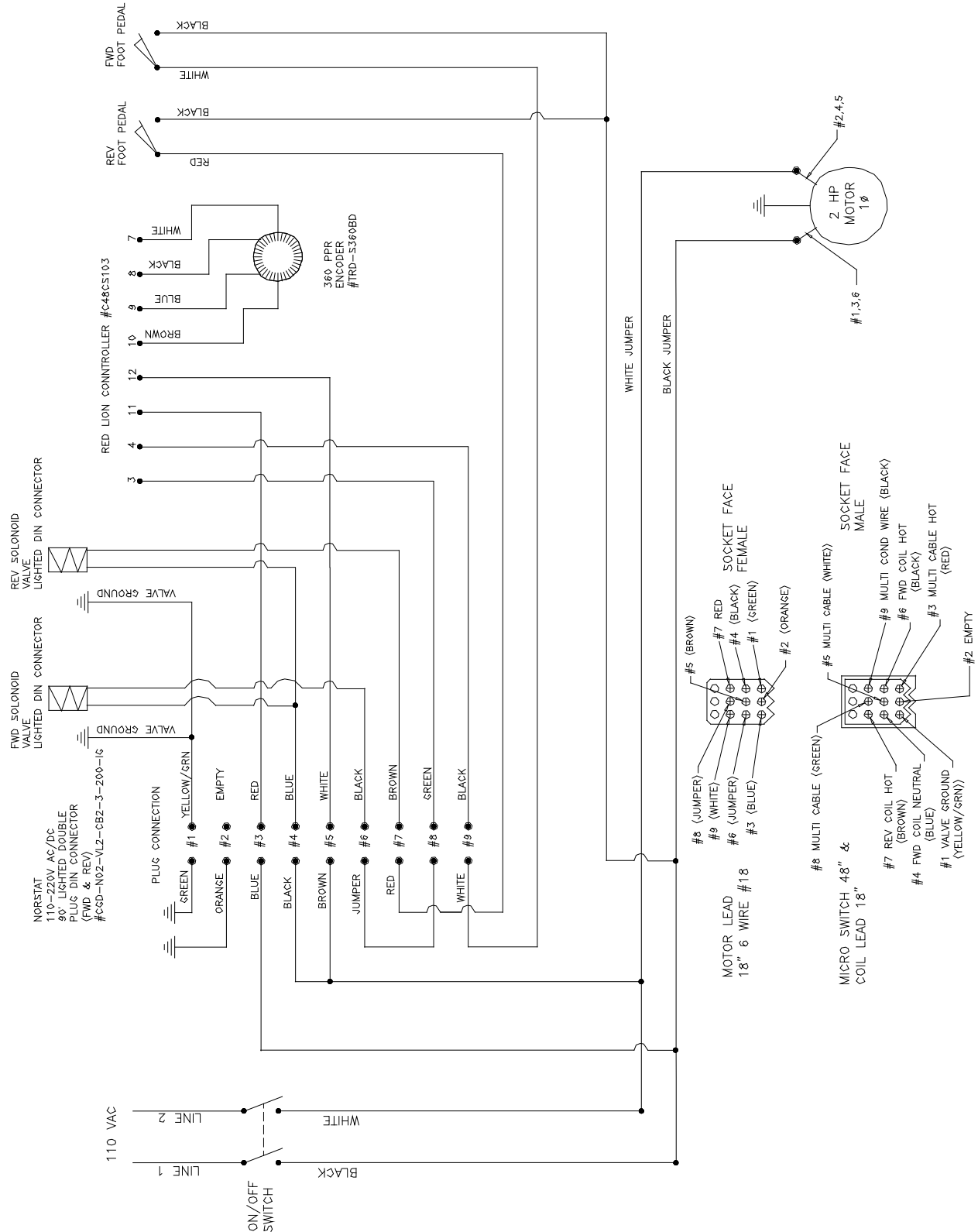


Note: *Proper maintenance can increase the life expectancy of your machine.*

- The fluid level in the power unit's reservoir should be checked monthly. If the level is below 1/2 full, fill to the top with AW-46 hydraulic fluid. Hydraulic fluid and the filter should be changed when the filter gauge reads "Change Filter".
- Check periodically for leaks. If a leak is detected, consult your service engineer.
- There are four grease zerks on the machine, at the main spindle pivots. Grease these zerks every month with only two pumps from a standard grease gun.
- Check for any loose or worn parts
- If hoses or fittings are replaced, they must be rated for 4000psi (275 bars, 282 kg/cm).

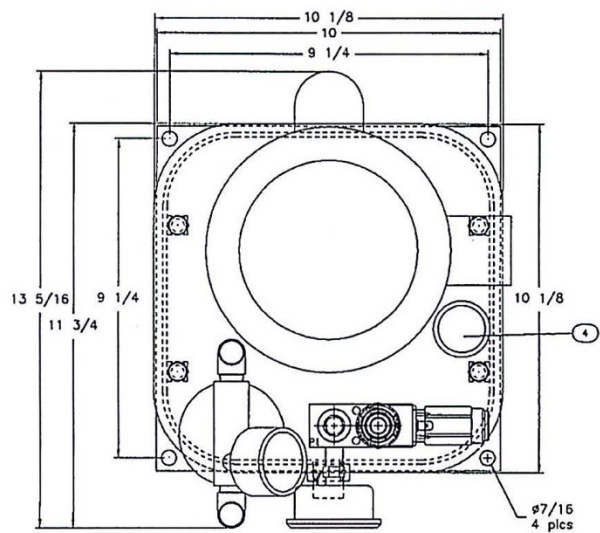
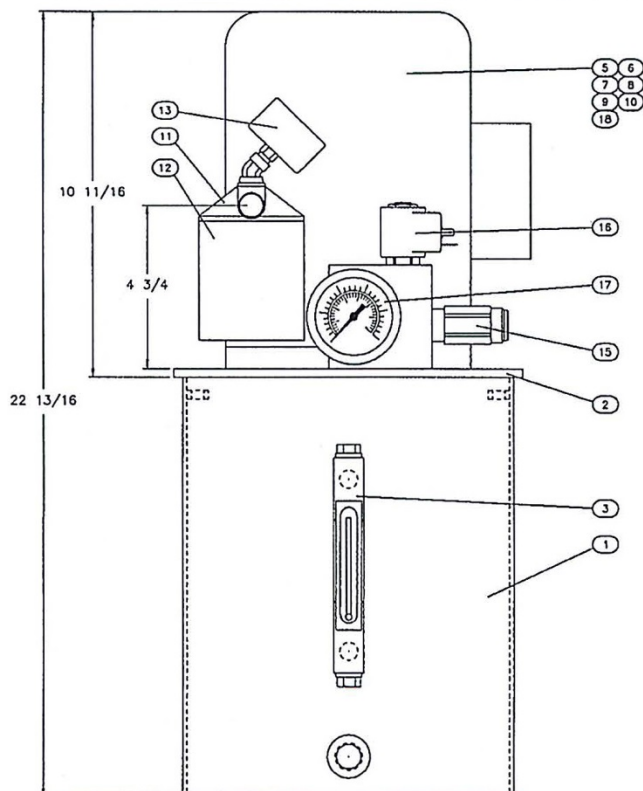
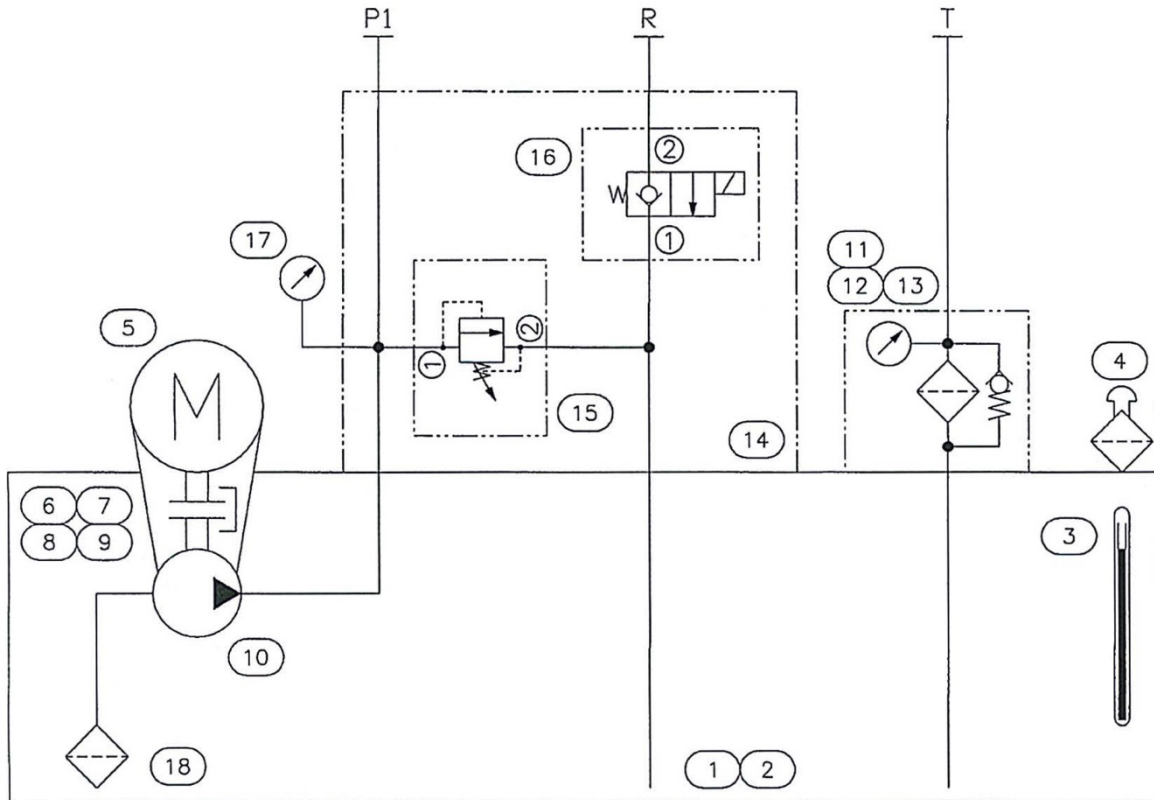


ELECTRICAL SCHEMATIC





HYDRAULIC DIAGRAM






TROUBLESHOOTING



WARNING: Make sure the electrical disconnect is OFF before working on the machine.

Problem	Solution
Cylinders not retracting all the way or not in sequence	Do the dry run sequence as outlined in section 8 of the manual under operation
Machine doesn't move forward or moves forward slowly and does not build up pressure	<p>Check that the solenoid valve has its wires connected. To Check it's functionality extend the cylinder all the way, let the machine deadhead and build up pressure approximately 2000 (Psi). At that point rotate the autostop dial the detent position and the pressure should drop to "0" Psi.</p>  <p>Solenoid switch</p>
Machine doesn't bend at pressure (2000 Psi)	If trying to bend material and the machine builds up pressure and stalls this usually means: The material is too thick, the material has too high of a yield strength, or the material is over the machines capacity.
Material slips in the hook arm	Too much lube on material and is transferring to the bend die clean the bend die with degreaser.
	The counter die should be lubed only
	The material may need to be clamped
	Wrong material for the die set
Spindle drive pins are damaged	If the bend dies are not bolted down properly the drive pins will get damaged. Replace drive pins.
Poor Bend Results	Check proper tooling for material IE Pipe Vs Tube. Green for pipe, Blue for tube, Red for metric and Gray for square or rectangle tubing. See Appendix C for pipe sizing chart
	Wall thickness is too thin



TABLES, CHARTS, & DIAGRAMS

Table 1 Standard Pipe Sizes and Schedules

PIPE SIZES	O.D.	Pipe Schedules and Wall Thickness					
		5	10	40	80	160	XX STRONG
1/8	0.405	0.400	0.050	0.068	0.095		
1/4	0.540	0.500	0.070	0.088	0.119		
3/8	0.675	0.500	0.070	0.091	0.126		
1/2	0.840	0.700	0.080	0.109	0.147	0.188	0.294
3/4	1.050	0.700	0.080	0.113	0.154	0.219	0.308
1	1.315	0.700	0.110	0.133	0.179	0.250	0.358
1-1/4	1.660	0.700	0.110	0.140	0.191	0.250	0.382
1-1/2	1.900	0.700	0.110	0.145	0.200	0.281	0.400
2	2.375	0.700	0.110	0.154	0.218	0.344	0.436
2-1/2	2.875	0.800	0.120	0.203	0.276	0.375	0.552

Table 2 Die Color Code Chart

Material	Color
Pipe	Green
Tube	Blue
Metric	Red
Square or Rectangle	Gray



Table 3 ARC LENGTH TABLE

EXAMPLE: Arc Length = Constant x Bend Radius. Example: 90deg bend with 6" clr

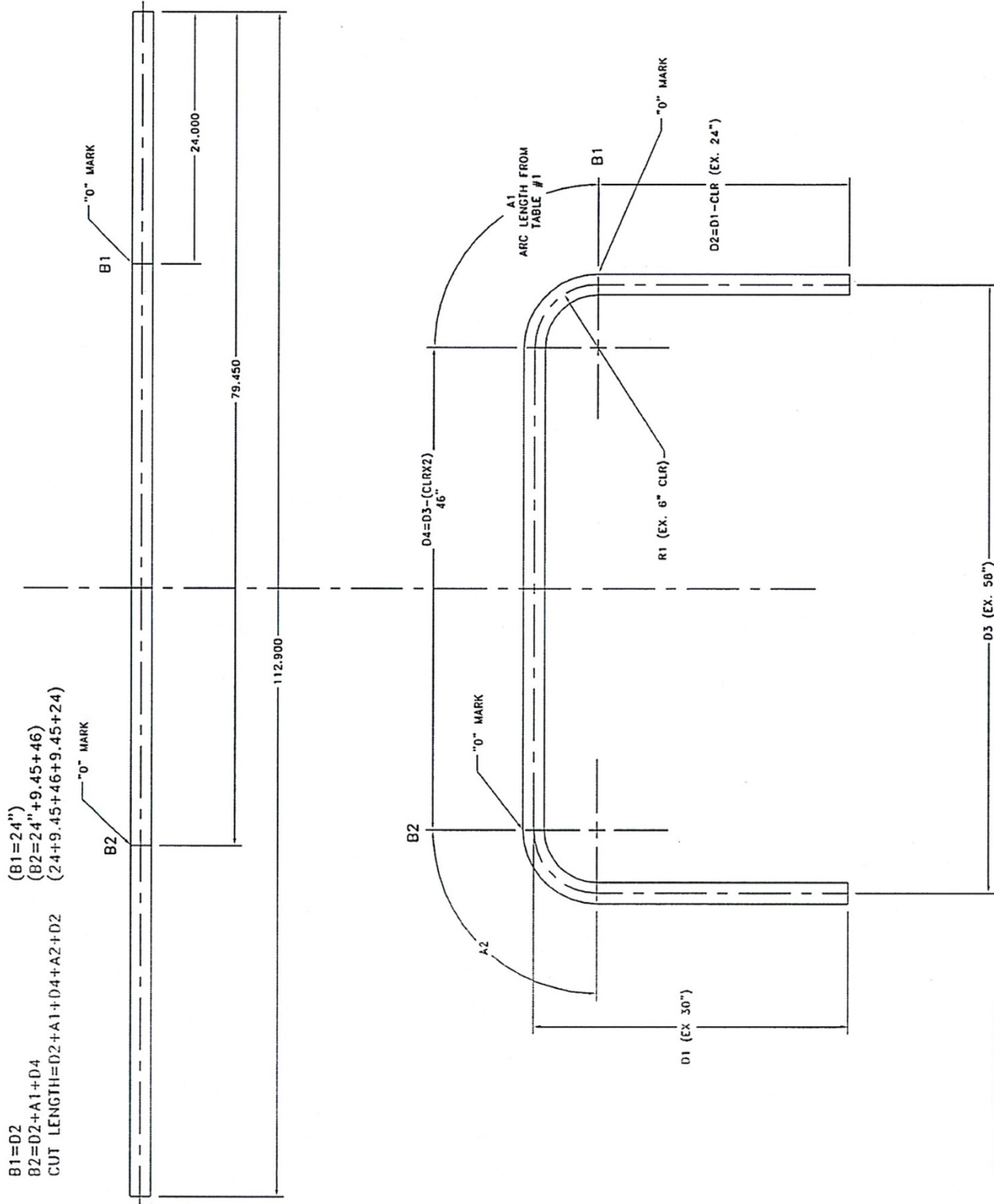
EXAMPLE: 1.575 (from table) x 6" (clr) = 9.45" (Arc Length)

For bends more than 90deg, Constants can be added together.

Degrees	Constant	Degrees	Constant	Degrees	Constant
1	0.0175	31	0.5410	61	1.0645
2	0.0349	32	0.5584	62	1.0819
3	0.0524	33	0.5759	63	1.0994
4	0.0698	34	0.5933	64	1.1168
5	0.0873	35	0.6108	65	1.1343
6	0.1047	36	0.6282	66	1.1517
7	0.1222	37	0.6457	67	1.1692
8	0.1396	38	0.6631	68	1.1866
9	0.1571	39	0.6806	69	1.2041
10	0.1745	40	0.6980	70	1.2215
11	0.1920	41	0.7155	71	1.2390
12	0.2094	42	0.7329	72	1.2564
13	0.2269	43	0.7504	73	1.2739
14	0.2443	44	0.7678	74	1.2913
15	0.2618	45	0.7853	75	1.3088
16	0.2792	46	0.8027	76	1.3262
17	0.2967	47	0.8202	77	1.3437
18	0.3141	48	0.8376	78	1.3611
19	0.3316	49	0.8551	79	1.3786
20	0.3490	50	0.8725	80	1.3960
21	0.3665	51	0.8900	81	1.4135
22	0.3839	52	0.9074	82	1.4309
23	0.4014	53	0.9249	83	1.4484
24	0.4188	54	0.9423	84	1.4658
25	0.4363	55	0.9598	85	1.4833
26	0.4537	56	0.9772	86	1.5007
27	0.4712	57	0.9947	87	1.5182
28	0.4886	58	1.0121	88	1.5356
29	0.5061	59	1.0296	89	1.5531
30	0.5235	60	1.0470	90	1.5705



Diagram 1



CONTINUOUS LAYOUT **DIAGRAM #1**



Diagram2

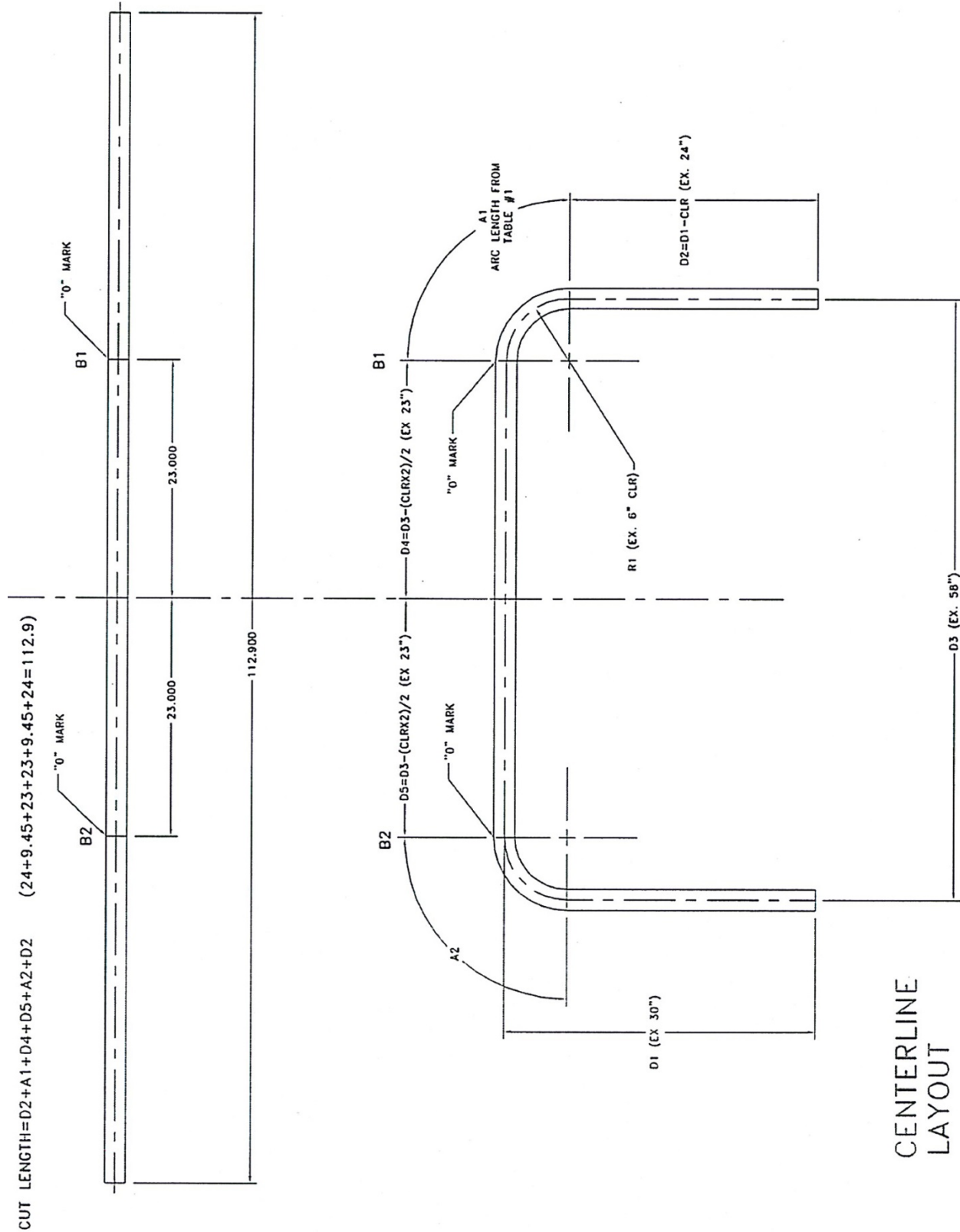
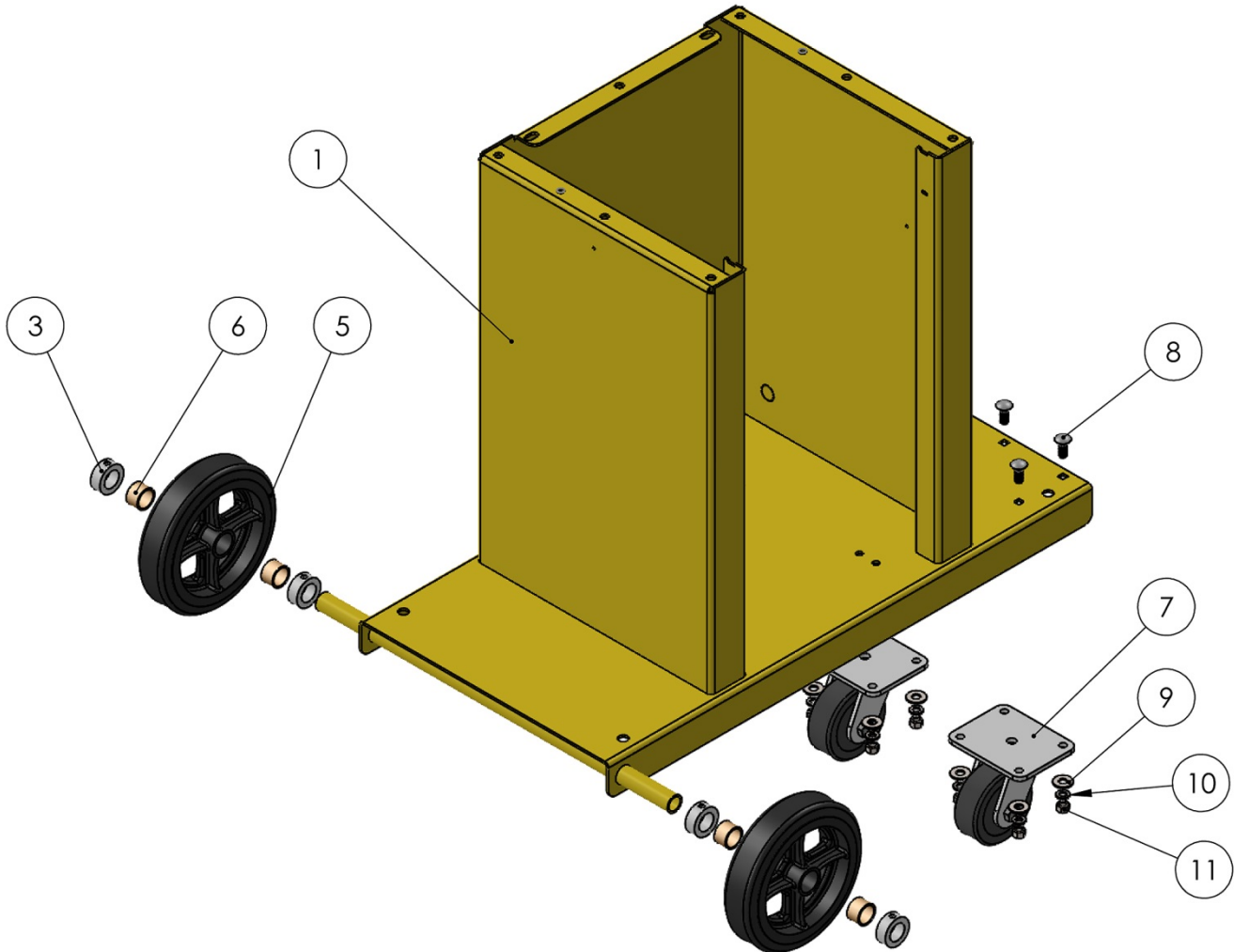


DIAGRAM #2



PARTS DIAGRAM

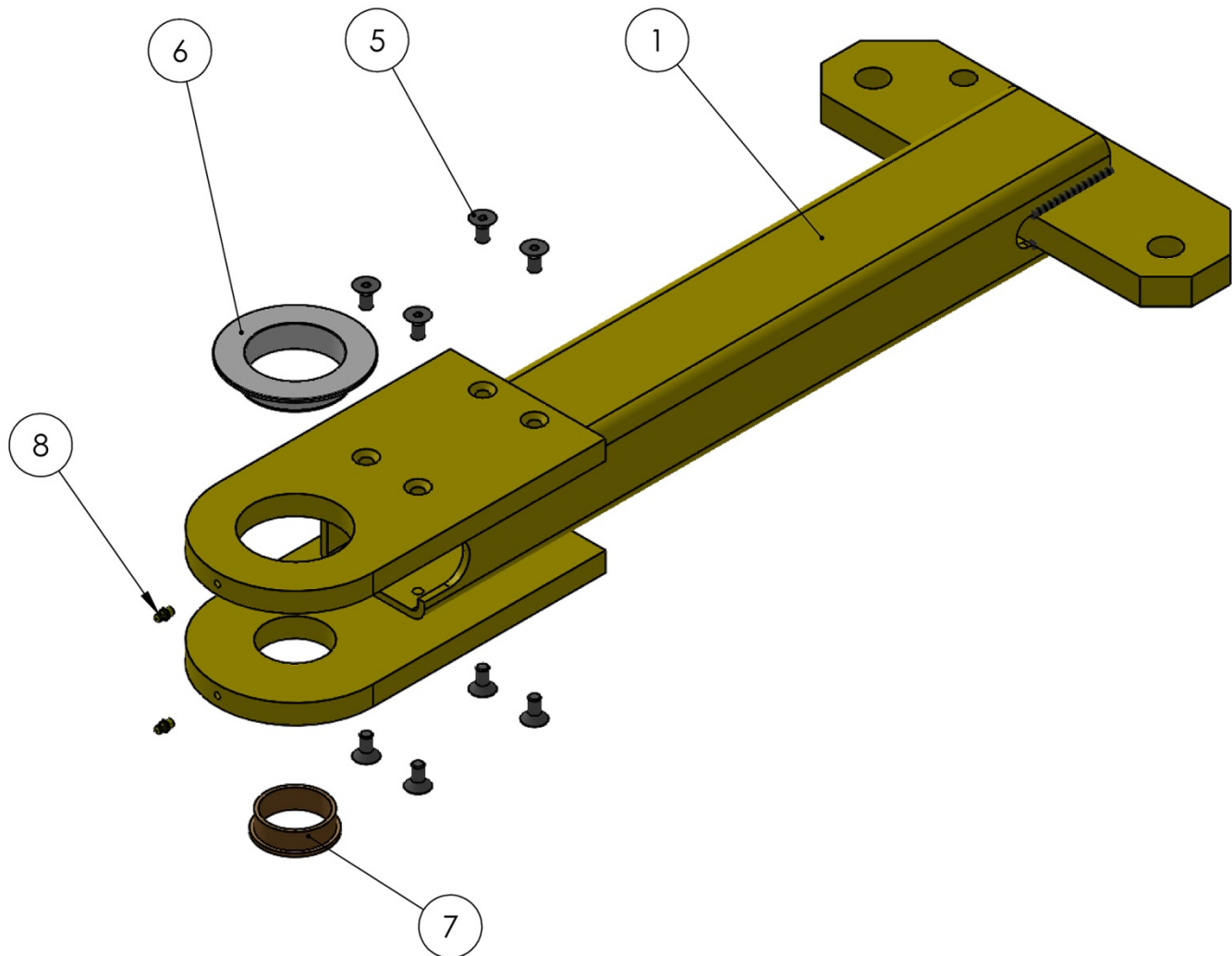
Base Assembly Parts Diagram and List



Item	Part Number	Description	Qty.
1	M150-5A014	Upright, Base	1
3	PP-0035	1" Set Screw Collar	4
5	PP-0064	8" Rubber Wheel	2
6	PP-0043	1.0"ID x 1.1875"OD x 0.75" Lg Bushing	4
7	PP-0048	4.0" Inch Caster	2
8	Imperial	3/8-16 x 1 Carriage Bolt	8
9	Imperial	3/8 Flatwasher	8
10	Imperial	3/8 Lockwasher	8
11	Imperial	3/8-16 Hex Nut	8



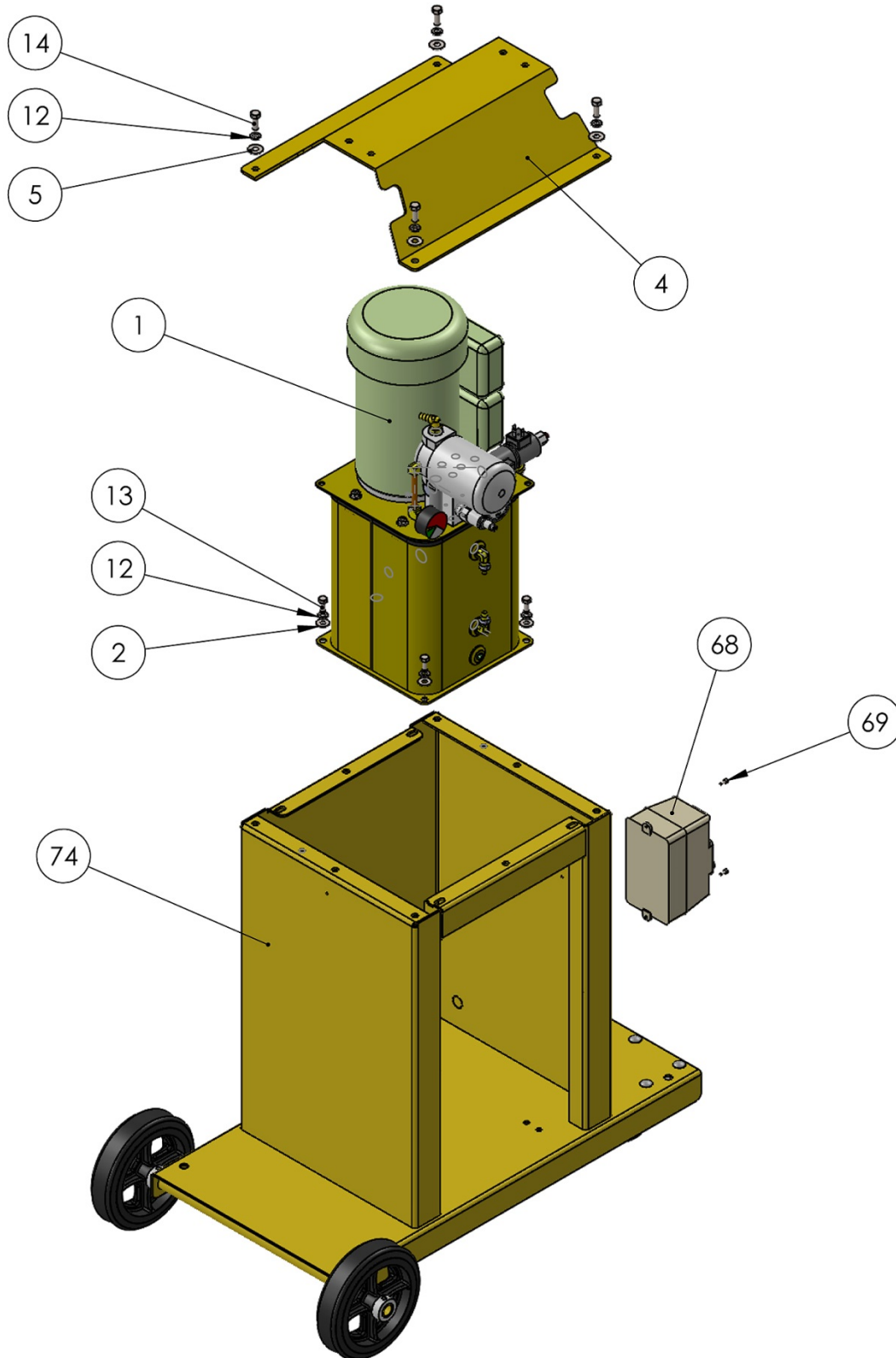
Main Tube Assembly Parts Diagram and List



Item	Part Number	Description	Qty.
1	M150-6A013	Main Tube	1
5	Imperial	3/8-16 X .75 FHCS	8
6	M150-7A015	Flanged Sleeve Bushing	1
7	PP-0294	Flanged Sleeve Bearing	1
8	.25-28 Grease Zerk	Straight Grease Zerk	2

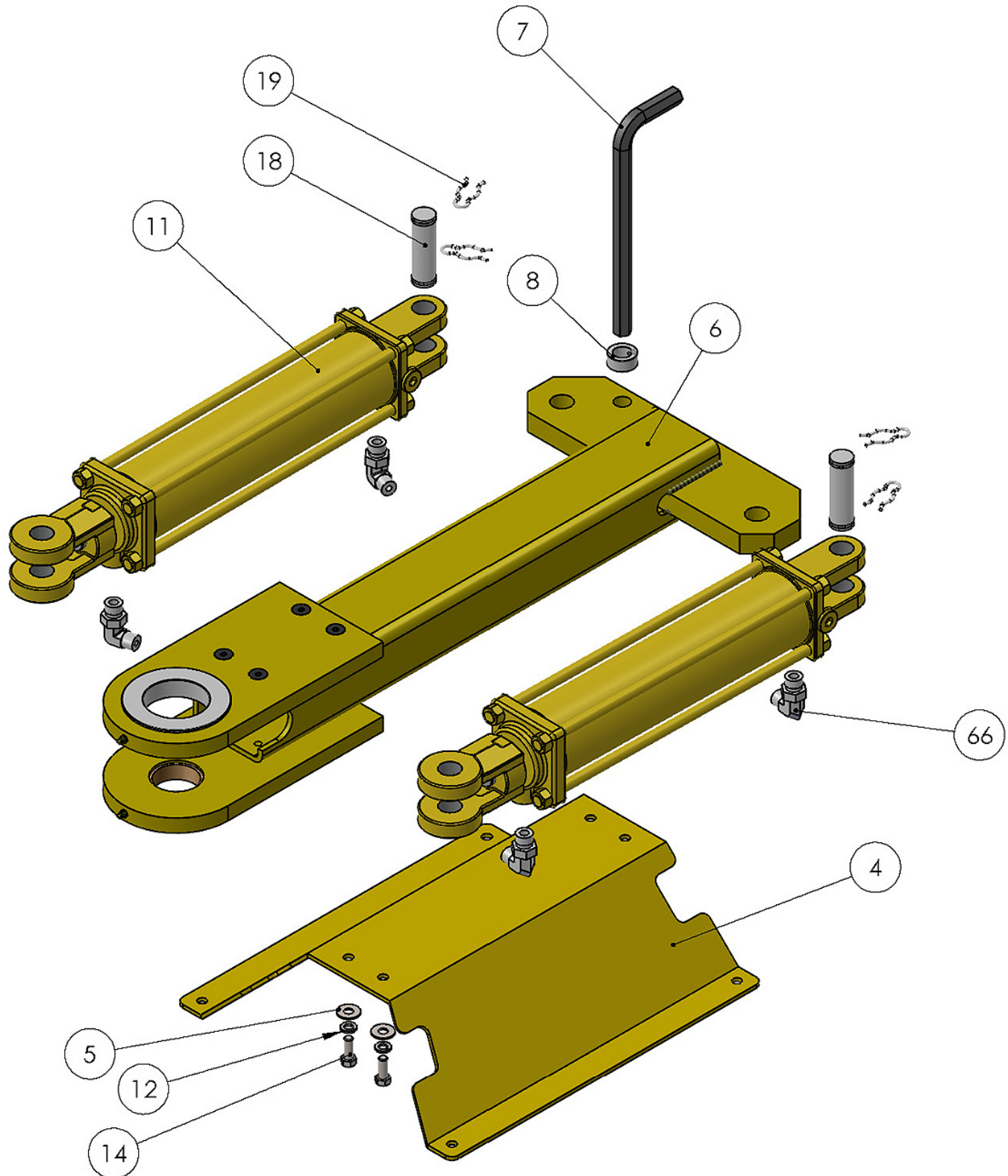


Base and Power Unit Parts Diagram



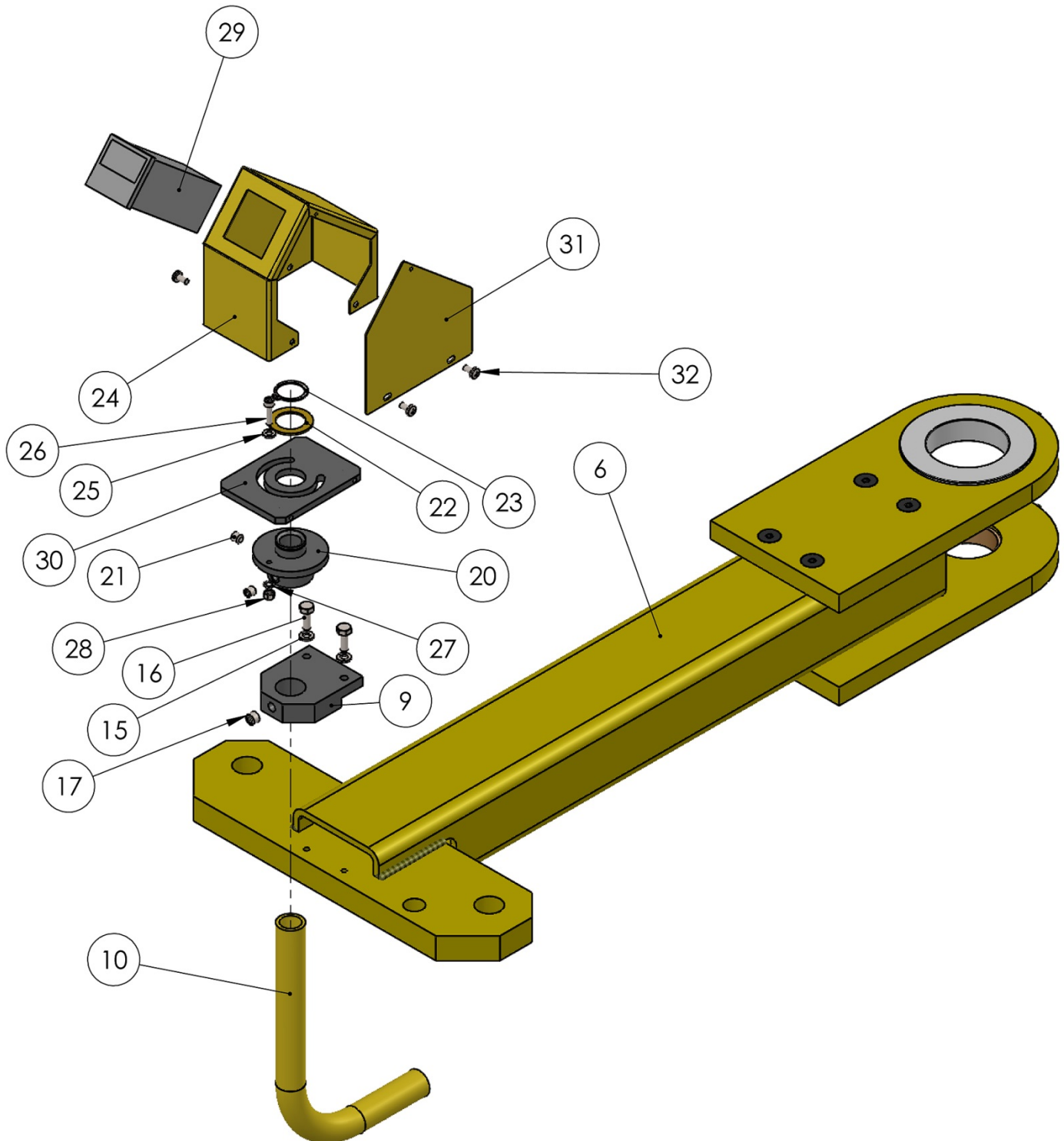


Cylinder Assembly Parts Diagram



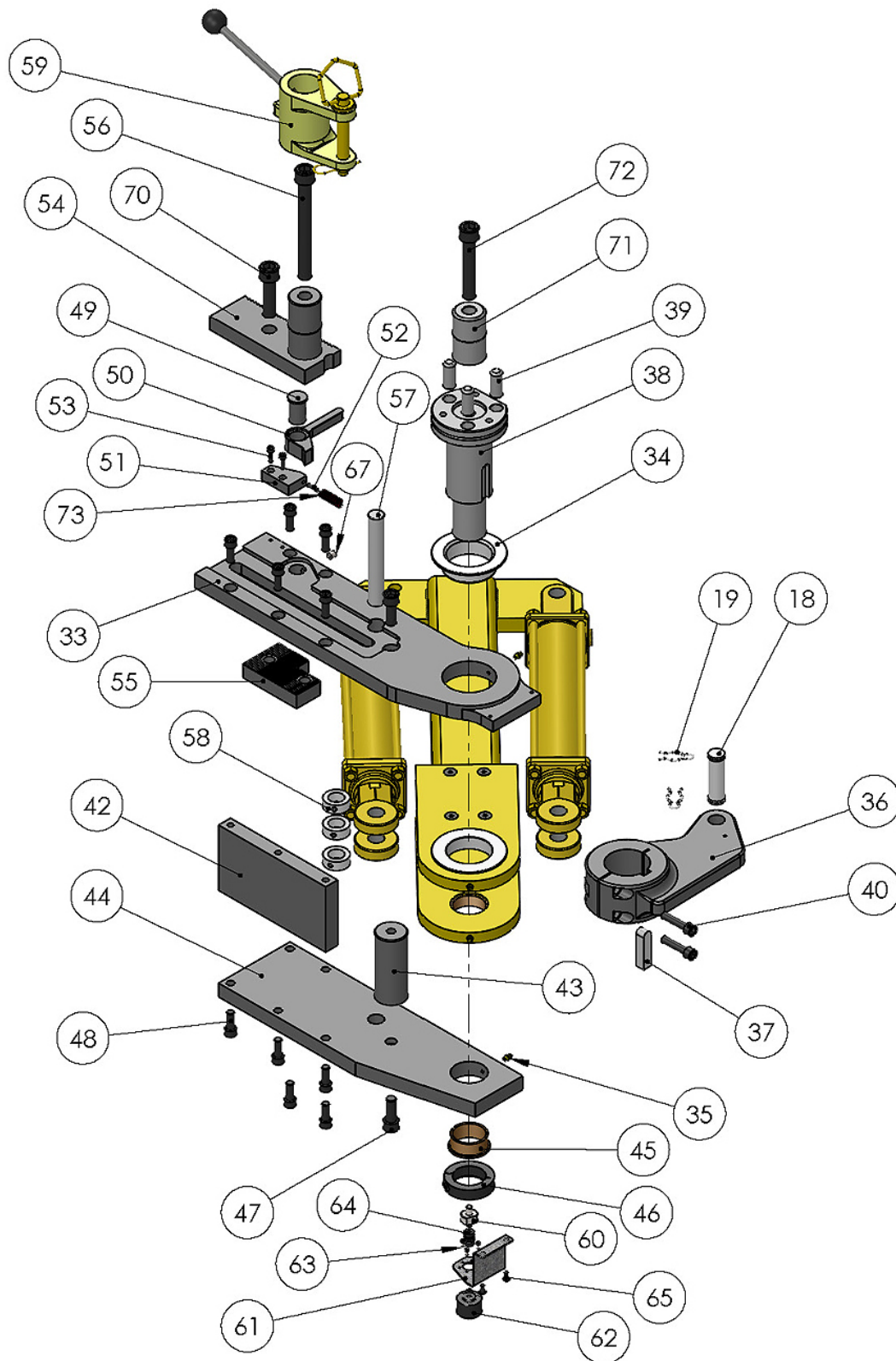


Controller Housing Assembly Parts Diagram





Swing Arm Assembly Parts Diagram





Parts List

Item	Part Number	Description	Qty.
1	ASSYMBLY	M175 POWERUNIT ASSEMBLY	1
2	Imperial	5/16 FLATWASHER	4
3	M150-6A035	CROSS BAR	1
4	M175-6A016	RISER	1
5	Imperial	3/8 FLATWASHER	8
6	M150-5A006	MAIN TUBE ASSEMBLY	1
7	PP-1430	17MM HEX KEY	1
8	PP-1494	20 MM SET SCREW COLLAR	1
9	ME-M175-6A060	TUBE MOUNT (METRIC)	1
10	M175-7A007	PIVOT POST	1
11	PP-0403	3 x 12 HYDRAULIC CYLINDER	2
12	Imperial	3/8 LOCKWASHER	20
13	Imperial	5/16-18 x .75 HHCS	4
14	Imperial	3/8-16 x 1 HHCS	8
15	Imperial	1/4 LOCKWASHER	2
16	Imperial	1/4-20 x .75 HHCS	2
17	M10 x 1.5 x 8	SET SCREW	1
18	PP-0403-J	PIN	3
19	PP-0403-K	HAIRCLIP	6
20	ME-M175-7A008	SWIVEL HUB (METRIC)	1
21	M8 x 1.25 x 8	SET SCREW	2
22	PP-0935	1.0 ID x 1.5 OD x .0625 THK	1
23	Imperial	1" EXT. RETAINING RING	1
24	M175-6A058	ENCLOSURE FOR DEEP CONTROL	1
25	Imperial	5MM FLAT WASHER	1
26	M5 x 0.8 x 20	SHCS	1
27	Imperial	1/4 EXT. TOOTH LOCKWASHER	1
28	Imperial	M5 x 0.8 HEX NUT	1
29	PP-1293	RED LION CONTROLLER	1
30	ME-M175-6A056	PIVOT BASE (METRIC)	1
31	M175-6A059	BOX COVER	1
32	M5 x 0.8 x 10	PPMS	4
33	ME-M175-6A011	TOP PIVOT BAR (METRIC)	1



Item	Part Number	Description	Qty.
34	M150-7A014	TOP BUSHING	1
35	.25-28 GREASE ZERK	STRAIGHT GREASE ZERK	2
36	ME-M150-5A005	TORQUE ARM (METRIC)	1
37	M150-6A019	5/8 DRIVE KEY	1
38	ME-M175-7A005	SPINDLE	1
39	PP-1071	3/4" DOWEL PIN	3
40	M12 x 1.75 x 50	SHCS	2
41	ME-M175-6A004	TIE BAR (SHORT METRIC)	1
42	ME-M175-6A008	TIE BAR (LONG METRIC)	1
43	ME-M150-7A011	SPACER SHAFT (METRIC)	1
44	ME-M175-6A012	LOWER PIVOT PLATE (METRIC)	1
45	PP-0295	FLANGED SLEEVE BEARING	1
46	PP-0293	2.0 SPLIT CLAMP COLLAR	1
47	M16 x 2.0 x 40	SHCS	2
48	M12 x 1.75 x 30	SHCS	10
49	M175-7A002	PIVOT PIN	1
50	M175-6A015	RATCHET	1
51	ME-M175-6A013	SPRING STOP (METRIC)	1
52	M6 x 1.0 x 20	SET SCREW	1
53	M6 x 1.0 x 20	SHCS	2
54	ME-M175-5A001	RATCHET QUICK RELEASE ASS'Y (METRIC)	1
55	ME-M175-6A009	SLIDE LOCK KEY (METRIC)	1
56	M20 x 2.5 x 180	SHCS	1
57	M175-7A004	CYLINDER PIN (LONG)	1
58	PP-0035	1" SET SCREW COLLAR	7
59	M150-5A001	GOLD QUICK RELEASE	1
60	M175-7A006	ENCODER ADAPTER	1
61	M175-6A051	ENCODER BRACKET	1
62	PP-1256	ENCODER	1
63	Imperial	M3 x 0.5 x 8 SHCS	3
64	PP-1257	ENCODER COUPLING	1
65	M6 x 1.0 x 12	BUTTON HEAD	2
66	PP-0853	ELBOW	4
67	M10 x 1.5 x 12	SET SCREW	1



Item	Part Number	Description	Qty.
68	PP-1294	EUROPEAN ON/OFF SWITCH	1
69	M4 x 0.7 x 10	SHCS	2
70	M20 x 2.5 x 70	SHCS	1
71	ME-M300-7A003	CENTER PIN	1
72	M20 x 2.5 x 110	SHCS	1
73	PP-1186	.5 x 1.5 SPRING	1



NOTES



NOTES



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WARNING

General Machinery Safety Instructions

Machinery House
requires you to read this entire Manual before using this machine.

- 1. Read the entire Manual before starting machinery.** Machinery may cause serious injury if not correctly used.
- 2. Always use correct hearing protection when operating machinery.** Machinery noise may cause permanent hearing damage.
- 3. Machinery must never be used when tired, or under the influence of drugs or alcohol.** When running machinery you must be alert at all times.
- 4. Wear correct Clothing.** At all times remove all loose clothing, necklaces, rings, jewelry, etc. Long hair must be contained in a hair net. Non-slip protective footwear must be worn.
- 5. Always wear correct respirators around fumes or dust when operating machinery.** Machinery fumes & dust can cause serious respiratory illness. Dust extractors must be used where applicable.
- 6. Always wear correct safety glasses.** When machining you must use the correct eye protection to prevent injuring your eyes.
- 7. Keep work clean and make sure you have good lighting.** Cluttered and dark shadows may cause accidents.
- 8. Personnel must be properly trained or well supervised when operating machinery.** Make sure you have clear and safe understanding of the machine you are operating.
- 9. Keep children and visitors away.** Make sure children and visitors are at a safe distance for you work area.
- 10. Keep your workshop childproof.** Use padlocks, Turn off master power switches and remove start switch keys.
- 11. Never leave machine unattended.** Turn power off and wait till machine has come to a complete stop before leaving the machine unattended.
- 12. Make a safe working environment.** Do not use machine in a damp, wet area, or where flammable or noxious fumes may exist.
- 13. Disconnect main power before service machine.** Make sure power switch is in the off position before re-connecting.
- 14. Use correct amperage extension cords.** Undersized extension cords overheat and lose power. Replace extension cords if they become damaged.
- 15. Keep machine well maintained.** Keep blades sharp and clean for best and safest performance. Follow instructions when lubricating and changing accessories.
- 16. Keep machine well guarded.** Make sure guards on machine are in place and are all working correctly.
- 17. Do not overreach.** Keep proper footing and balance at all times.
- 18. Secure workpiece.** Use clamps or a vice to hold the workpiece where practical. Keeping the workpiece secure will free up your hand to operate the machine and will protect hand from injury.
- 19. Check machine over before operating.** Check machine for damaged parts, loose bolts, Keys and wrenches left on machine and any other conditions that may effect the machines operation. Repair and replace damaged parts.
- 20. Use recommended accessories.** Refer to instruction manual or ask correct service officer when using accessories. The use of improper accessories may cause the risk of injury.
- 21. Do not force machinery.** Work at the speed and capacity at which the machine or accessory was designed.
- 22. Use correct lifting practice.** Always use the correct lifting methods when using machinery. Incorrect lifting methods can cause serious injury.
- 23. Lock mobile bases.** Make sure any mobile bases are locked before using machine.
- 24. Allergic reactions.** Certain metal shavings and cutting fluids may cause an allergic reaction in people and animals, especially when cutting as the fumes can be inhaled. Make sure you know what type of metal and cutting fluid you will be exposed to and how to avoid contamination.
- 25. Call for help.** If at any time you experience difficulties, stop the machine and call you nearest branch service department for help.



WARNING

Elec/Mech Pipe/Tube Bender Safety Instructions

Machinery House
requires you to read this entire Manual before using this machine.

- 1. Maintenance.** Make sure the Pipe/Tube Bender is turned off and disconnect from the main power supply and make sure all moving parts have come to a complete stop before any inspection, adjustment or maintenance is carried out.
- 2. Pipe Bender Condition.** Pipe/Tube Bender must be maintained for a proper working condition. Never operate a Pipe/Tube Bender that has damaged or worn parts. Scheduled routine maintenance should be performed on a scheduled basis. Check frame, rollers, springs & formers for cracks or damage. Replace if necessary.
- 3. Former Condition.** Never operate a Pipe/Tube Bender with damaged or badly worn Formers. Replace if required.
- 4. Hand Hazard.** Keep hands away from the Pipe/Tube Bender, under any circumstances, while the machine is in operation mode. Serious injury can occur.
- 5. Gloves & Glasses.** Always wear leather gloves and approved safety glasses when using this machine.
- 6. Work area hazards.** Keep the area around the Pipe/Tube Bender clean from oil, tools, objects & chips. Pay attention to other persons in the area and know what is going on around the area to ensure unintended accidents.
- 7. Guards.** Do not operate Pipe/Tube Bender without the correct guards in place. Necessary guards protect you from injuries by worm-type gearbox and other gears. The only other area which needs to be carefully monitored during use is the rotational area of the formers.
- 8. Understand the machines controls.** Make sure you understand the use and operation of all controls.
- 9. Overloading Pipe/Tube Bender.** Do not over load the machine by using material which exceeds the rated capacity.
- 10. Avoiding Entanglement.** Pipe/Tube Bender guards must be used at all times. Tie up long hair and use the correct hair nets to avoid any entanglement with the Pipe/Tube Benders moving parts.
- 11. Trained Operator.** This machine must be operated by authorized and trained personnel.
- 12. Power outage.** In the event of a power failure during use of the machine, turn off all switches to avoid possible sudden start up once power is restored.
- 13. Warning Labels.** Take note of any warning labels on the machine and do not remove them.
- 14. Material Hazard.** Do not bend plastics or other objects that could shatter. Serious injury can occur.
- 15. Stopping the Former.** Do not stop or slow the former with your hand or workpiece. Allow the machine to stop on its own.
- 16. Secure Pipe/Tube Bender.** Make sure you bolt the machine down so it is secure when in operation.
- 17. Pinching.** Prevent pinching by releasing pressure on the workpiece when not in use.
- 18. Emergency stop.** Use the emergency stop button in case of any emergency.
- 19. Hearing protection and hazards.** Always wear hearing protection as noise generated from machine and workpiece can cause permanent hearing loss over time.
- 20. Call for help.** If at any time you experience difficulties, stop the machine and call your nearest branch service department for help.

PLANT SAFETY PROGRAM

NEW MACHINERY HAZARD IDENTIFICATION, ASSESSMENT & CONTROL

Electric/Mechanical Pipe/Tube Benders

Developed in Co-operation Between A.W.I.S.A and Australia Chamber of Manufactures

This program is based upon the Safe Work Australia, Code of Practice - Managing Risks of Plant in the Workplace (WHSA 2011 No10)

Item No.	Hazard Identification	Hazard Assessment	Risk Control Strategies (Recommended for Purchase / Buyer / User)
B	CRUSHING	HIGH	Do not exceed maximum capacity. Check equipment for damage prior to use. Wear safety boots. Never put any part of your body between moving formers and material. Always support material properly.
C	CUTTING, STABBING OR PUNCTURING	MEDIUM	Use equipment in the correct manner as to avoid parts being ejected out under pressure.
E	STRIKING	MEDIUM	Use equipment in the correct manner as to avoid parts being ejected out under pressure. Ensure correct formers are used for the correct job.
H	ELECTRICAL	MEDIUM	All electrical enclosures should only be opened with a tool that is not to be kept with the machine.
			Machine should be installed & checked by a Licensed Electrician.
O	OTHER HAZARDS, NOISE.	LOW	Wear hearing protection as required.
Plant Safety Program to be read in conjunction with manufactures instructions			



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Authorised and signed by:

Safety officer:

Manager:

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