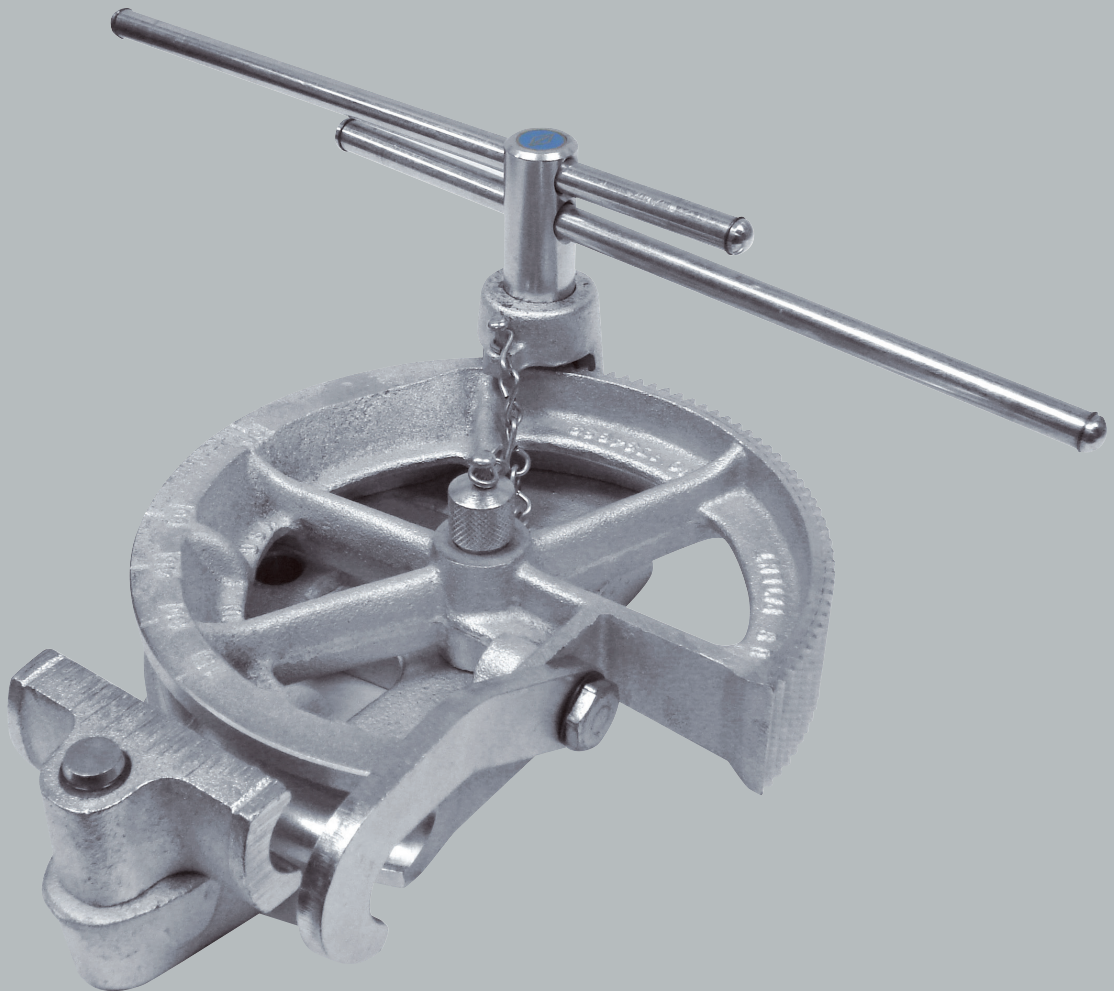


270-F Series

Gear-type tube bender

INSTRUCTIONS OF USE



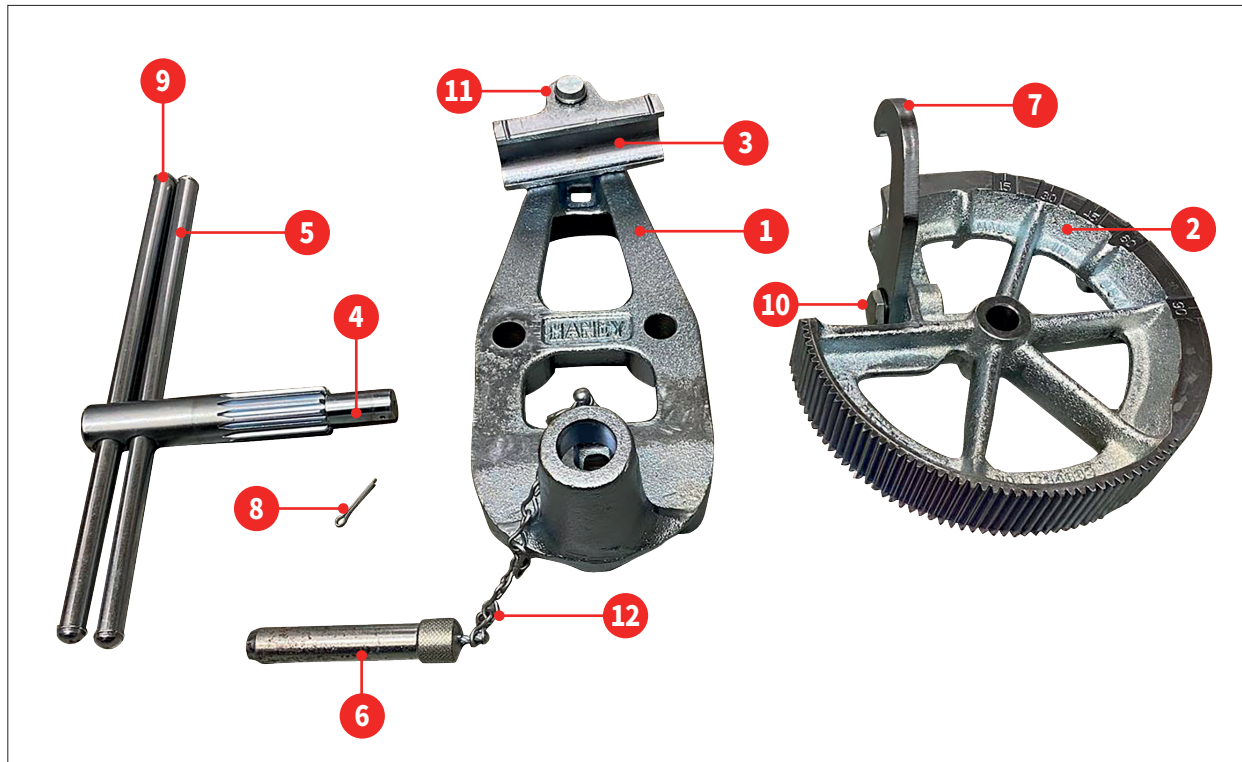
Imperial[®]

DEPENDABLE UNDER PRESSURE[™]

APPLICATION

For bending soft and half-hard copper, aluminium brass, steel and other tubing and pipe which had been tempered and is suitable for bending.

PARTS



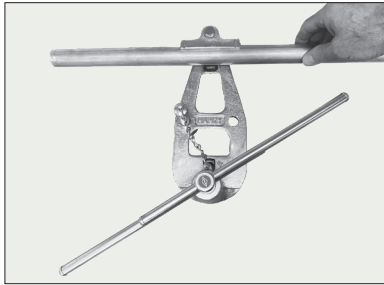
- | | | |
|-------------------------|----------------|-------------------|
| 1. Gear bender body | 5. Handle | 9. Spring ring |
| 2. Geared forming wheel | 6. Fulcrum pin | 10. Shoulder Bolt |
| 3. Shoe | 7. Hook | 11. Spring ring |
| 4. Splined shaft | 8. Split pin | 12. Chain |

FEATURES

For 3/8" to 1-1/8" O.D. tubing.

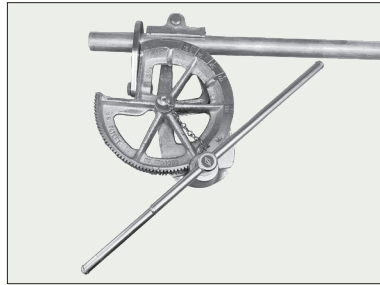
- For all bending work
- Spur-gear type with 10-to-1 ratio for easy bending of tempered tubing
- Floating shoe aligns tube perfectly on calibrated forming wheel
- Pull-pin on wheel speeds repositioning for bends over 90°
- Portable
- **For use on a fixed or portable work bench and vice**
NB: If not fixed to a bench or vice, bender or pipe must be fixed.

INSTRUCTIONS

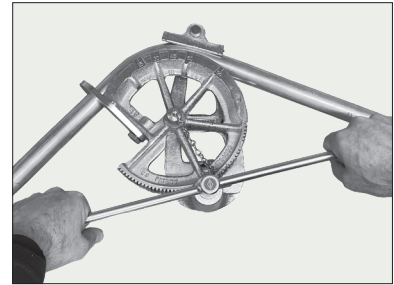


For making right hand bends, hold tube across shoe face.

For making left hand bends, turn forming wheel over with hook point face up and hold in place with centre pin in right hole. Bender body handle will be closest to you, and shoe farthest away. Turn handle counter-clockwise.

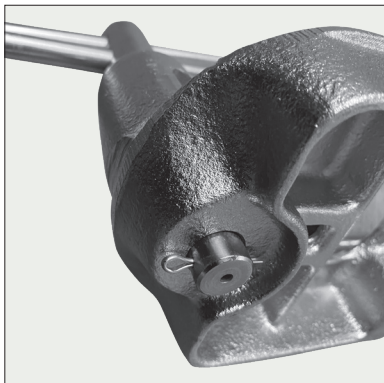


Attach forming wheel with hook point facing down and chained centre pin inserted into left hole. Bender body handle will be closest to you, and shoe farthest away. Drop hook in place over tubing.



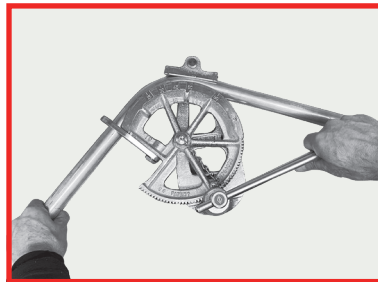
Turn handle clockwise until desired degree of bend is obtained. Handle may be extended to full width to give maximum leverage. To remove bent tubing, pull out centre pin, thus releasing forming wheel and tubing.

IMPORTANT:
Always use two hands!



After inserting splined shaft, use split pin to secure in place. Failure to secure splined shaft may result in premature failure.

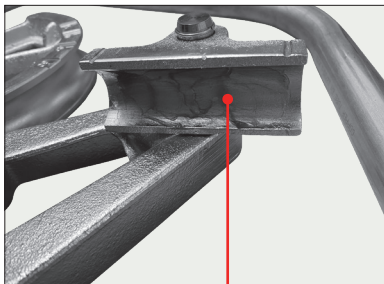
IMPORTANT!!



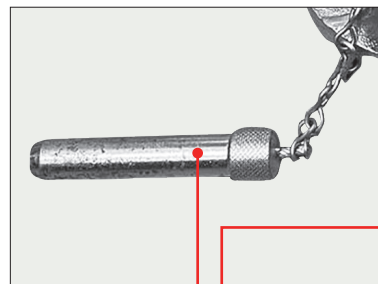
NEVER HOLD PIPE AND HANDLE IN ONE HAND!



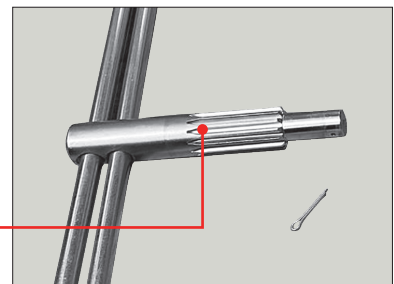
Secure pipe in place with hook.



Before use always lubricate with grease or oil the following components:



- Shoe
- Fulcrum Pin
- Splined shaft



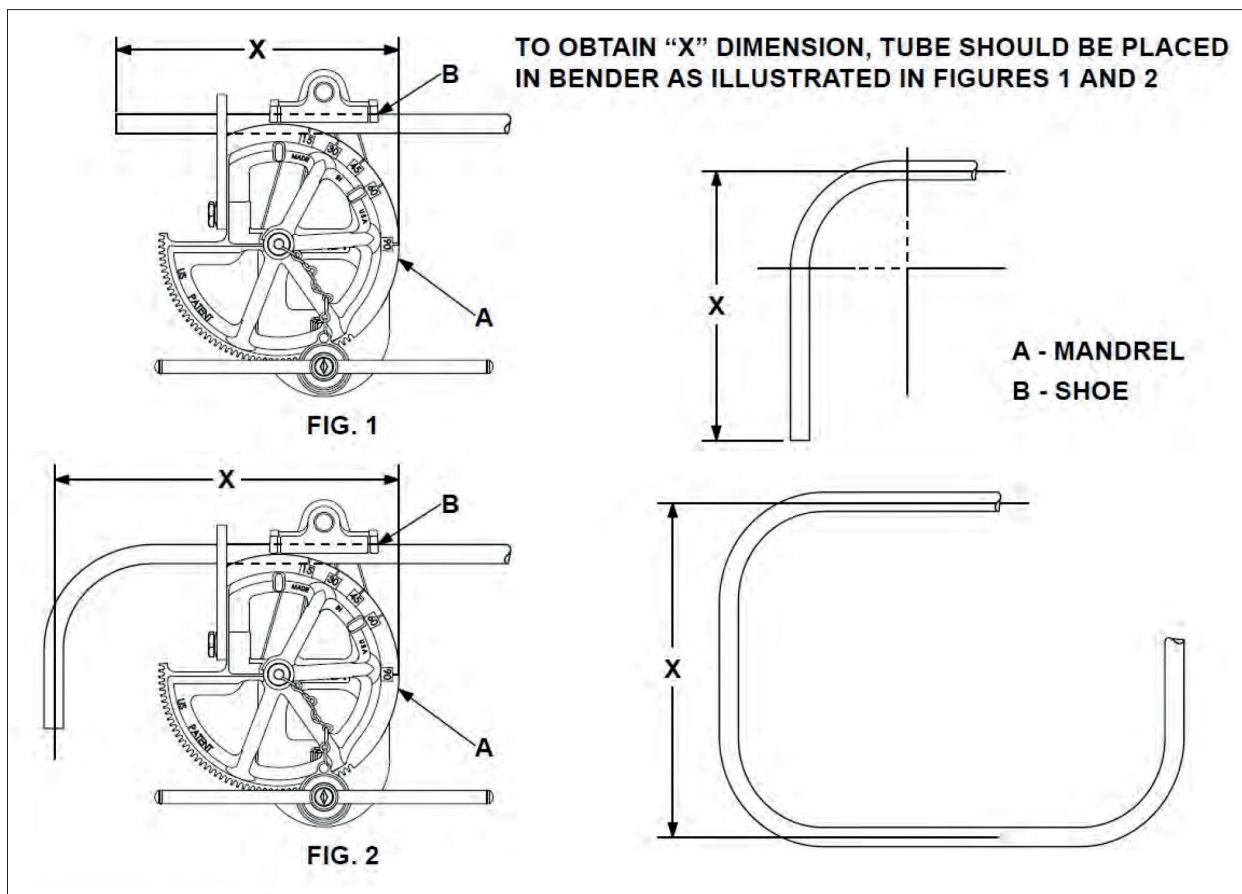
Failure to lubricate could result in premature failure and will not be covered under the product warranty .

BENDING RADII

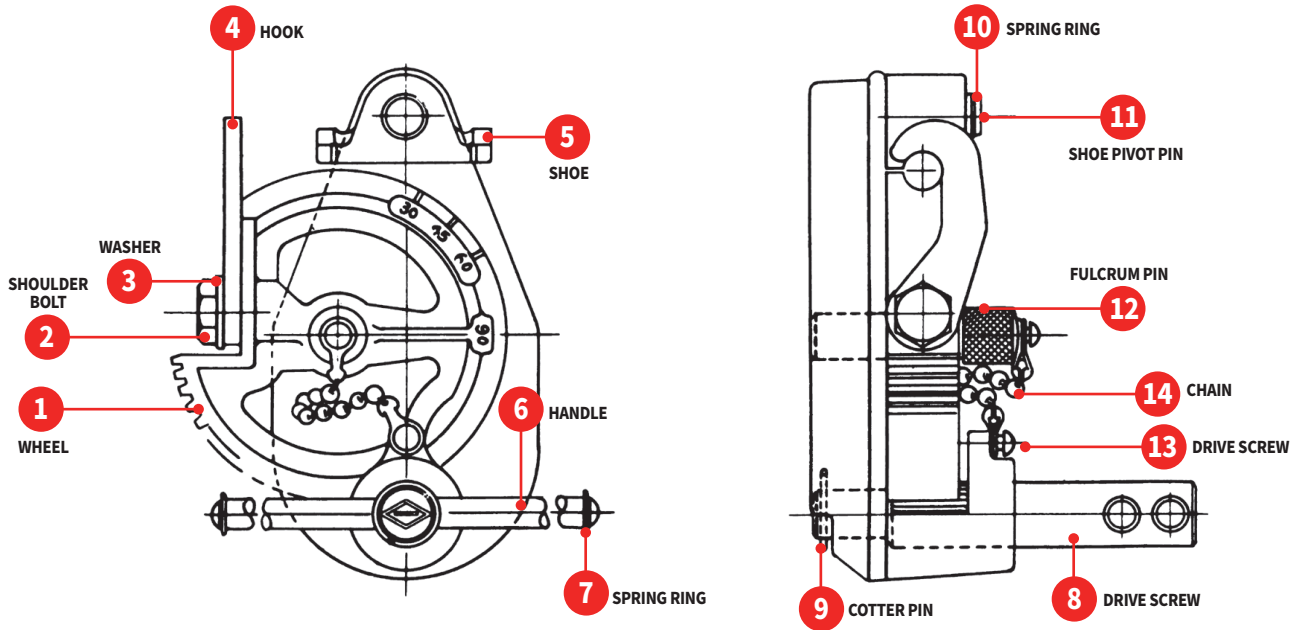
Part No	O.D. of tube	Nominal tube size	Bending radius to centre of tube	Minimum return or coil bend from centre to centre of tubing
270-F-06	3/8"	1/4"	1-3/4"	4-1/2"
270-F-08	1/2"	3/8"	2-1/2"	6"
270-F-10	5/8"	1/2"	3"	7-1/2"
270-F-12	3/4"	5/8"	4"	9-1/2"
270-F-14	7/8"	3/4"	4"	9-1/2"
270-F-16	1"	7/8"	4"	9-1/2"
270-F-18	1-1/8"	1"	4"	9-1/2"

GUIDE FOR MAKING DIMENSIONAL BENDS

WITH IMPERIAL UNIVERSAL GEAR-TYPE TUBE BENDERS



REPLACEMENT PARTS



TUBE BENDER	Size (in.)	PART NO. 1	PART NO. 2	PART NO. 3	PART NO. 4	PART NO. 5	PART NO. 6	PART NO. 7	PART NO. 8	PART NO. 9	PART NO. 10	PART NO. 11	PART NO. 12	PART NO. 13	PART NO. 14
270-F-12	3/4	S62305	S62294	S62298	S62307	S62306	S62292	S62297	S62291	S62255	S62296	S62295	S62835	S62836	S62837
270-F-14	7/8	S62302	S62294	S62298	S62304	S62303	S62292	S62297	S62291	S62255	S62296	S62295	S62835	S62836	S62837
270-F-16	1	S62299	S62294	S62298	S62301	S62300	S62292	S62297	S62291	S62255	S62296	S62295	S62835	S62836	S62837
270-F-18	1-1/8	S62287	S62294	S62298	S62290	S62289	S62292	S62297	S62291	S62255	S62296	S62295	S62835	S62836	S62837

NB: IF BENCH OR VICE NOT AVAILABLE, USER MUST SECURE BENDER TO PREVENT DAMAGE TO GEARS

FLOOR OPTION



WALL OPTION

