

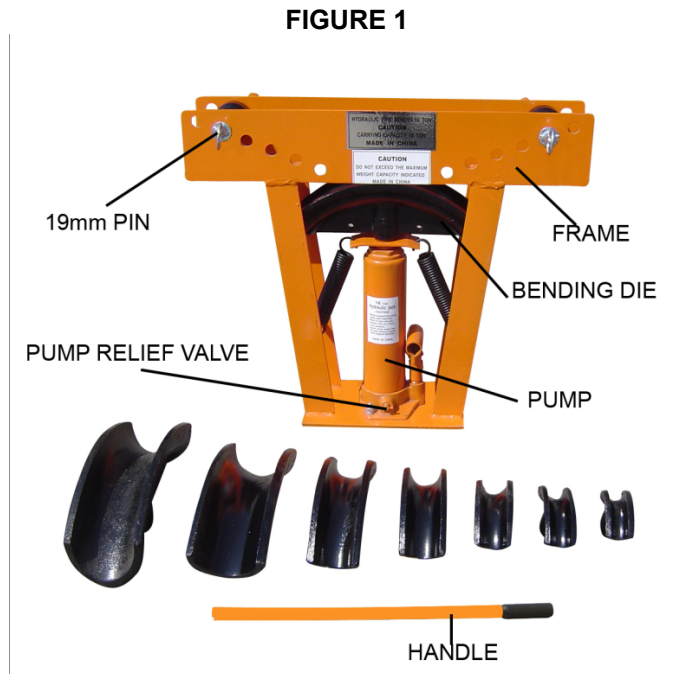
Installation Instructions for 81520K 16 Ton Hydraulic Pipe Bender

SAVE THIS MANUAL FOR FUTURE REFERENCE

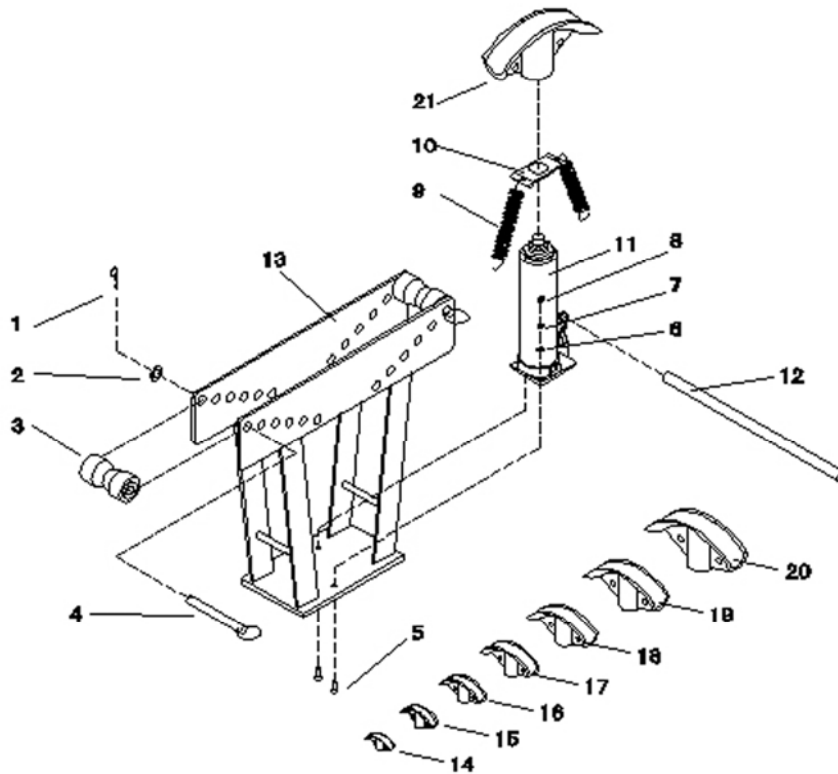
Your new 16 TON PIPE BENDER has been engineered and manufactured by our company with high standards for dependability, ease of operation and operator safety. Please pay close attention to the rules for safe operation, warnings and cautions. If you use your machine properly and only for what it is intended, you will enjoy years of safe and reliable service.

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.

1. Place the pipe bender on a solid, level floor or workbench. NOTE: if a workbench is selected, use shop clamps to keep the pipe bender from rocking.
2. Each bending die is stamped with a size on the front (for example: 3/4", 1", 1-1/2"etc) match the size on the bending die with the size of the pipe that you wish to bend.
3. Place the bending die onto the bottle jack as shown in figure 1.



4. Depending on the size pipe and the desired results, you may need to move the ROLLERS (part3). Use the following instructions to move the ROLLERS:
 - a. Remove both "R" PINS (part1)
 - b. One at a time, remove a 19mm PIN (part 4) and move the ROLLER (part 3) to the desired location (hole) in the FRAME (part 13)
 - c. Fully slide the 19mm PIN (part 4) through the holes in the FRAME and ROLLER.
 - d. Secure the 19mm PIN (part 4) by inserting a "R" PINS (part 1) through the 19mm PIN (part 4), as it was when you removed it.
5. Repeat steps B, C and D for the other roller.
6. Using the slotted end of the HANDLE (part 12), tighten (turn clockwise) the PUMP relief valve.
7. Insert the HANDLE into the PUMP, and move it up and down to raise the PUMP and bend the pipe.
8. When the pipe has been bent to the desired angle, remove the HANDLE from the PUMP and loosen (turn counter clockwise) the PUMP relief valve. This will release the pipe from the pipe bender and allow you to carefully remove it.



PART	DESCRIPTION	QTY
1	~ R ~ Pin	2
2	ø20 Washer	2
3	Roller	2
4	ø19 Pin	2
5	Bolt M8X30	2
6	ø8 Washer	2
7	ø8 Spring Washer	2
8	M8 Nut	2
9	Spring	2
10	Plate	1

PART	DESCRIPTION	QTY
11	Pump	1
12	Handle	1
13	Frame	1
14	1/2" Bending Die	1
15	3/4" Bending Die	1
16	1" Bending Die	1
17	1 1/4" Bending Die	1
18	1 1/2" Bending Die	1
19	2" Bending Die	1
20	2 1/2" Bending Die	1
21	3" Bending Die	1

GENERAL SAFETY RULES

WARNING: When using the tool basic safety precautions should always be followed to reduce the risk of personal injury and damage to equipment!

- **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 lit.
- **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 them out of the 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 safer 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 get caught in moving parts. Protective, electrically non conductive clothing 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 over reach.** 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 parts that appear 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.
- **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.

WARNING: the warnings, cautions, and instructions discussed in this instruction manual cannot 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.



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