



SWADESIR INTERNATIONAL PTY LTD, 6 STRONG AVE, THOMASTOWN, VIC. 3074 PH 03-9460 3822 FAX 03-9460 3855



Operating Instructions for Swadesir 15B Hydraulic Pipe Bending Machine

1. Screw bending frame to power unit.
2. Select appropriate former to suit size of pipe being bent.
3. Position stops in correct holes marked on bending frame relative to pipe size being bent.
4. Position former on end of ram and place pipe between former and stops.
5. Release filler/breather cap on barrel of machine half a turn to allow air to enter reservoir.
6. Operate unit by closing return valve at the side of pumping head and operating the pump handle until former comes into contact with pipe. Make sure that pipe former and ram are squarely aligned.
7. Continue pumping until desired angle of bend is obtained.
8. Release return valve, which will allow the ram to retract for removal of the bend from the machine. Do not unscrew release valve more than is necessary to retract ram.

Special Notes

Important: Damage to the machine can be caused by incorrect alignment of pipe and former, or the use of wrong holes relative to the pipe size being bent.

When bending pipe with a series of bends close to each other, it is essential that the pipe being bent is square to the ram.

When topping up or refilling oil reservoir, make sure that no particles or dirt, dust, or other matters enters with oil. Fill oil reservoir to 6 mm below bottom of filler cap.

Recommended oil is Mobil D.T.E Light, Castrol Hyspin 32 or equivalent. Ensure correct grade of oil is used. Correct oil is available from Swadesir International Pty Ltd.

Tighten filler cap after bending operations are completed.

Trouble Shooting Chart

Trouble	Cause
Will not pump or extend ram.	<ul style="list-style-type: none">• Return Valve Open• Filter Clogged• Pump piston spring broken• Inlet valve not seating• Pressure check valve not seating
Ram movement but no power	<ul style="list-style-type: none">• Release Valve open• Ram vee packing faulty• Pressure check valve not seating
Ram will not turn properly	<ul style="list-style-type: none">• Bent or damaged ram
Oil leakage at the return	<ul style="list-style-type: none">• Faulty seal on return or bleeder valve
Oil Leakage at ram bearing	<ul style="list-style-type: none">• Front seals damaged

**Standard Formers Supplied with the 15B
'Cathedral Form' for Cold Rolled Pipe**

Former Size	Pipe OD	Part No	Centre Line Radius
10mm NB (3/8"NB)	17.2 mm	15B-32G	70mm (2 3/4")
15mm NB (1/2" NB)	21.3 mm	15B-32F	85mm (3 1/4")
20mm NB (3/4" NB)	26.9 mm	15B-32E	85mm (3 1/4")
25mm NB (1" NB)	33.7 mm	15B-32D	100mm (4")
32mm NB (1 1/4" NB)	42.4 mm	15B-32C	135mm (5 1/4")
40mm NB (1 1/2" NB)	48.3 mm	15B-32B	170mm (6 5/8")
50mm NB (2" NB)	60.3 mm	15B-32A	200mm (8")

Optional Formers (Available at additional cost)

Formers for Hot Rolled NB Pipe

Former Size	Pipe OD	Part No	Centre Line Radius
10mm NB (3/8"NB)	17.2 mm	15B-32OCG	70mm (2 3/4")
15mm NB (1/2" NB)	21.3 mm	15B-32OCF	85mm (3 1/4")
20mm NB (3/4" NB)	26.9 mm	15B-32OCE	85mm (3 1/4")
25mm NB (1" NB)	33.7 mm	15B-32OCD	100mm (4")
32mm NB (1 1/4" NB)	42.4 mm	15B-32OCC	135mm (5 1/4")
40mm NB (1 1/2" NB)	48.3 mm	15B-32OCB	170mm (6 5/8")
50mm NB (2" NB)	60.3 mm	15B-32OCA	200mm (8")

Formers for Heavy Wall Hydraulic Tube

Former Size	Part No	Centre Line Radius
12.7mm OD	15B-32GCG	70mm (2 3/4")
19mm OD	15B-32GCE	85mm (3 1/4")
25.4mm OD	15B-32CGD	85mm (3 1/4")
31.8mm OD	15B-32GCC	100mm (4")
38.1mm OD	15B-32GCB	135mm (5 1/4")
50.8mm OD	15B-32GCA	170mm (6 5/8")

Optional Attachments and Accessories Available

**Bender Stand, Part No.
15B-ST**



**Flat Bar Bender
Attachment
Part Number 15B-BBA**



**Tube Bending
Attachment
Part Number 15B-TA
(Tooling must be
ordered separately)**



Warranty

Swadesir International Pty. Ltd.

Congratulations and thank you for purchasing a quality Swade-Sir product. All Swade-Sir products are warranted against defects in material and workmanship for a period of twelve months from the date of purchase.

Swadesir International Pty. Ltd. is expressly limited to the original purchaser of the product. Service under warranty is provided only upon proof of purchase & within the warranty period.

Swadesir International Pty. Ltd. warranty does not cover products that have been abused, used incorrectly, tampered with, accidentally damaged, worn out, heated, neglected, ground or repaired by an unauthorized repairer or altered in any way. This warranty will become invalid if product or parts are used for any purpose than what they were designed.

No representatives or agents of Swadesir International Pty. Ltd. have the authority to bind Swadesir International to any warranty concerns or matters except the authorities of Swadesir International Pty. Ltd.

Swadesir International Pty. Ltd. will not be held liable for and warranty decisions that have not been made by the authorities of Swadesir International Pty. Ltd.

For determination of warranty consideration, return the product or part to Swadesir International Pty. Ltd. 6 Strong Avenue Thomastown. Victoria, 3074 Australia, freight prepaid including handling and return freight.

If the product or part manufactured by Swadesir International Pty. Ltd. is deemed to be faulty in materials or workmanship. Swadesir International Pty. Ltd. will determine, at their discretion to either replace or repair the defective product or part and return it on completion via the best means of transportation at their discretion. However, this warranty does not include freight costs to or from Swadesir International Pty. Ltd.

Customer Support Number

Phone 03-9460 3822

Fax 03-9460 3855

Swadesir International Pty. Ltd.

6 Strong Avenue

Thomastown Victoria. 3074.



SWADESIR INTERNATIONAL PTY LTD, 6 STRONG AVE, THOMASTOWN, VIC. 3074 PH 03-9460 3822 FAX 03-9460 3855

Product Warranty Registration

(Please complete, photocopy and return to above address within 20 days from purchase to validate warranty)

Model Number **15B** Serial Number _____ Purchase Date _____

Company Name _____

Contact Name _____

Address _____

City _____ State _____

Postcode _____

Phone _____ Fax _____

Email address _____

Distributor Name _____

Tick here.....if you wish us to send a current Swadesir Product Catalogue

www.swadesir.com.au

email: infosupport@swadesir.com.au