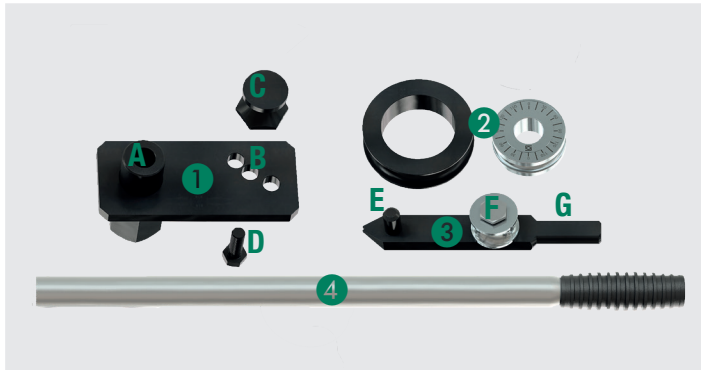


Components



Bending rollers

Outer Diameter	Metric	Inch	Radius	Minimum Wall Thickness
6/8mm (1/4"/5/16")	●	●	33mm	< 1,5mm
10mm (3/8")	●			1,5mm
12mm	●			1,5mm
1/2"		●	40mm	2,0mm
14mm	●			1,5mm
15mm	●			1,5mm
16mm (5/8")	●	●	48mm	1,5mm
18mm	●			2,0mm
3/4"		●		2,0mm
20mm	●			2,0mm
22mm (7/8")	●	●		2,0mm

Scope of delivery

- 1 Vice base plate
- 2 Bending rollers (8 no., 6 no. with the 'imperial' (inch) model)
- 3 Bending lever with counter-roller
- 4 Bending lever extension

Order repair parts at:

www.stauff.com/en/tub-ma/repairparts



Selection and set-up

1. Tension the vice base plate **1**: there are six different positions available.
2. Select the size of the bending roller **2** required.
3. Place the bending roller on the pin **A** of the base plate **1**. If using tubes with a diameter of 18, 20 and 22 mm or 3/4" - 7/8", first place a smaller roller, e.g. with a diameter of 10 / 3/8" onto the pin.
4. The screw **D** is used to position the holding roller **C** in one of the three holes **B**. This should be close to the bending roller with smaller diameters and further away with larger diameters.

Instructions for use

STAUFF manual tube and pipe benders are ideal for bending standard steel ST37/ST57 and stainless steel hydraulic tubes. A scale lasered onto the bending rollers enhances the accuracy of the required bending angle. The holding roller, which can be individually set to 3 stages, in conjunction with the 8 bending rollers (6 included in the 'imperial' (inch) model), provides precise and optimum bending quality. Check the outside diameter and wall thickness of the tube to be bent.

Bending process

1. Place the tube between the holding roller **C** and the bending roller **2**.
2. Fit the bending lever **3** by inserting the pin **E** of bending lever into the pin **A** of the vice base plate. The compression roller **F** of the bending lever and the bending roller **2** need to be on both sides of the tube.
3. The bending lever is gently pressed against the tube and the bending roller **2** is turned until the scale show zero.
4. The bending lever extension **4** is pressed onto the rod **G** of the bending lever
5. To bend the tube, turn the lever clockwise until the required angle appears on the scale of the bending roller.