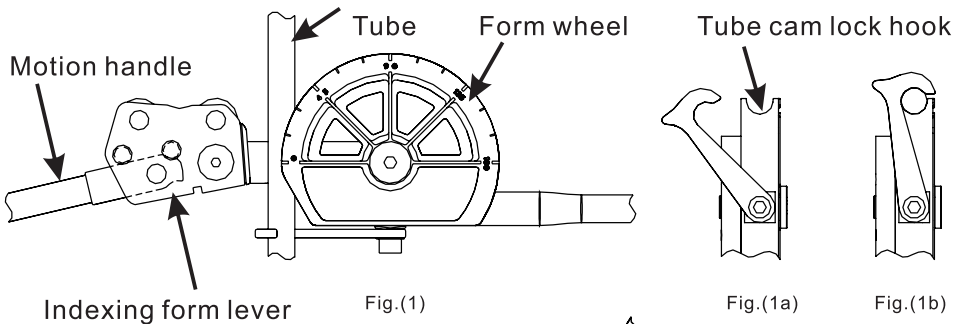


Tube Bender Operating Manual

1. Raise the Indexing form lever as shown in Fig.(1)
2. Make sure the Tube Cam locking hook is away from the Form wheel groove area(See Fig.(1a)). Position the tube in groove as shown in Fig.(1)
3. Lock the tube with the Hook as shown in Fig.(1b).
4. Lower the Indexing form lever from Fig.(1) to Fig.(2), the 90° start position. This is accomplished When the upper wheel of the Indexing form lever is aligned with 0° degree mark as showed on the Degree indicator.



Indexing form lever

Fig.(1)

Fig.(1a)

Fig.(1b)

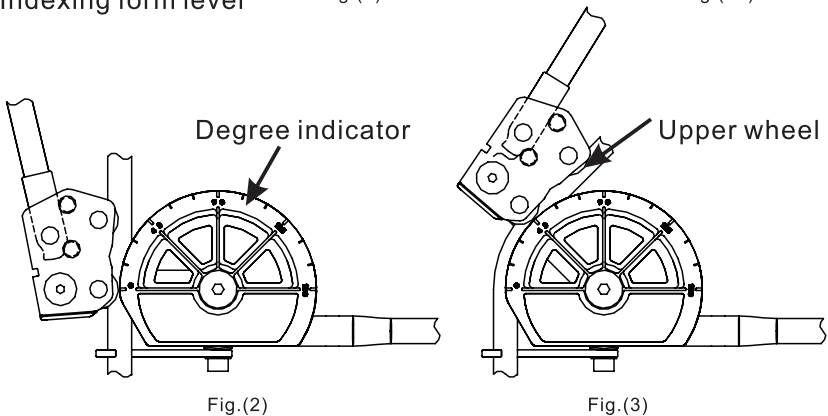


Fig.(2)

Fig.(3)

Tube Bender Operating Manual

- 1.If you want to obtain a bend angle less than or equal to 90° , just pull the Indexing form lever steadily around the form wheel to a certain degree you needed, which is accomplished when the upper wheel of the indexing form lever aligns with the degree graduation line as showed on the Degree indicator. The Graduation line showed is the desired bend angle of the tube. (See Fig.(3))
- 2.If you want to obtain a bend angle more than 90° , pull the Indexing form lever down to approximately 90° , While maintaining the Indexing form lever position with your fingers and raise the Motion handle separately to approximately 90° .(See Fig.(4)) Lift the Motion handle slightly and press into the Indexing form to snap on.(See Fig.(5)) Then continue pulling the Motion handle steadily downward to a desired bend angle. The degree graduation line aligned with the upper wheel of Indexing form lever is the final bend angle of the tube you needed. (See Fig.(6))

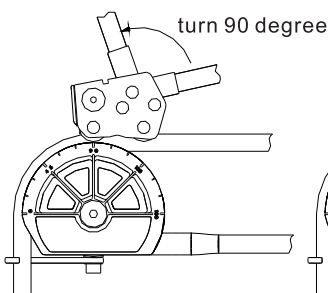


Fig.(4)

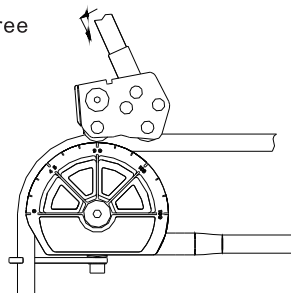


Fig.(5)

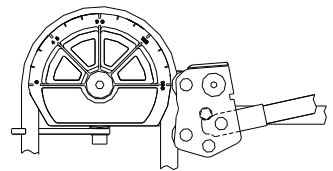


Fig.(6)

Specification

Type	VBT-3	VBT-4	VBT-5
Tube Dia. (inch)	5/8"	3/4"	7/8"
Tube Dia. (mm)	16mm	19mm	22mm
Bend radius	2-1/4"	3"	3-1/4"
Suited Tube	All soft metallic tube, Sheet copper tube, and Annealing hard tube		
Desired Bend angle	0~180°		