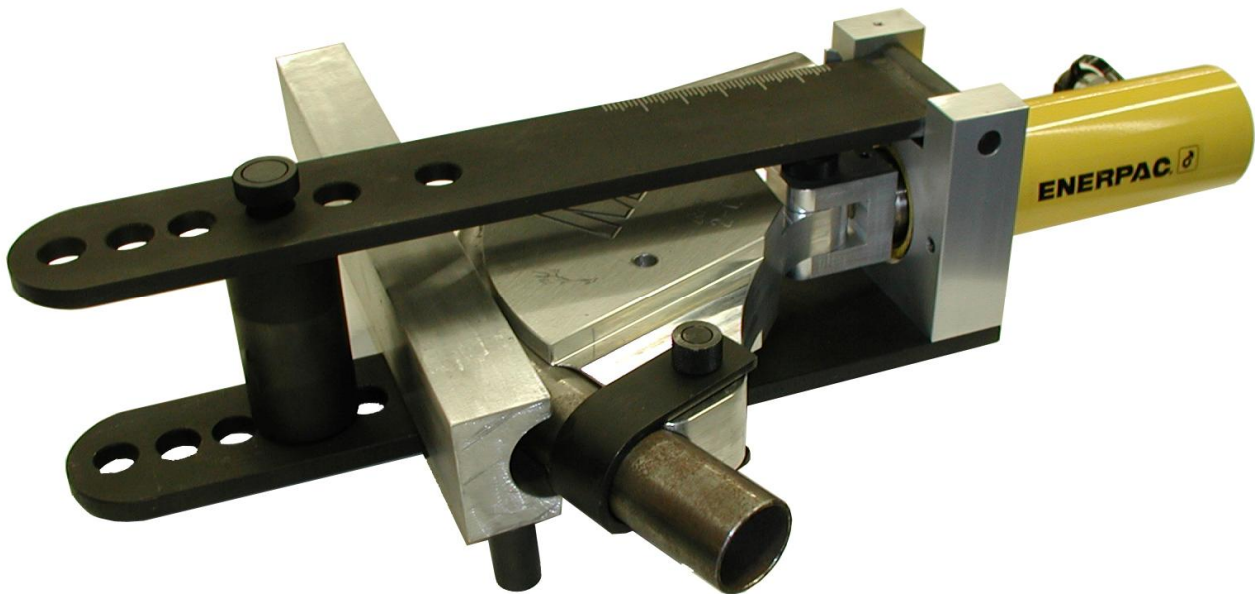


MB MITTLER BROS. MACHINE & TOOL

Hydraulic Tubing Bender Manual



1-877-VAN-SANT
www.trick-tools.com

SAFETY

The purpose of the safety section of this manual is to inform operators and maintenance personnel of the precautions to be taken while operating or servicing the machine. The following are a few basic guidelines to follow, but as with any type of machinery good judgment and a safe attitude should be applied at all times.

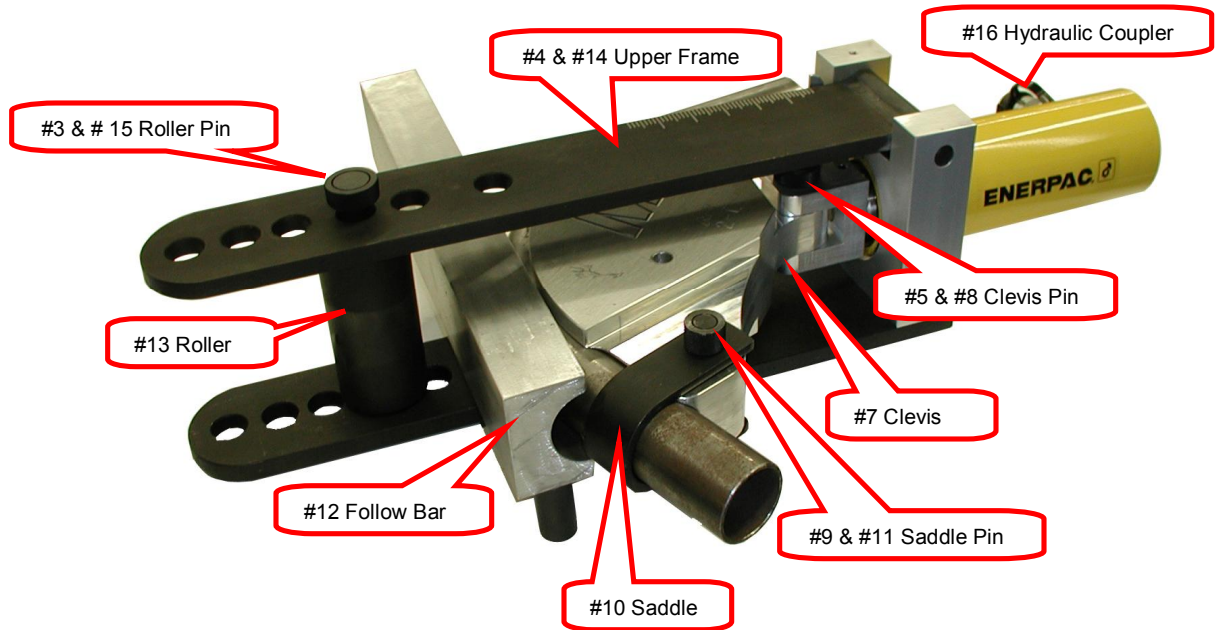
1. Always disconnect power, lock-out and tag-out machine per OSHA regulations before attempting to service this machine.
2. Always wear safety glasses or other approved eye protection while operating or servicing the machine.
3. Keep all body parts and any foreign objects away from moving parts. Do not reach into the machine without first disconnecting all power sources.
4. Do not attempt to override any safety device on the machine.
5. Do not operate the machine if it has been damaged or is not operating properly.
6. Do not wear jewelry (watches, rings, necklaces, etc.), or loose fitting clothing while operating or servicing the machine.
7. The machine should only be operated or serviced by properly trained, authorized personnel.
8. Replacement parts should have the same specification and operation as the original parts on the machine.
9. Before starting the machine be sure it is set up properly.
10. The machine and work area should be kept neat and clean.
11. Do not operate or service any machine while under the influence of drugs or alcohol.

NOTE: THESE SAFETY RULES ARE FOR YOUR BENEFIT TO HELP PREVENT INJURY TO YOURSELF AND/OR YOUR CO-WORKERS. REVIEW ALL SETUP AND OPERATING PROCEDURES, WHETHER COVERED OR NOT, IN THIS MANUAL TO HELP INSURE SAFE OPERATION OF THE MACHINE.

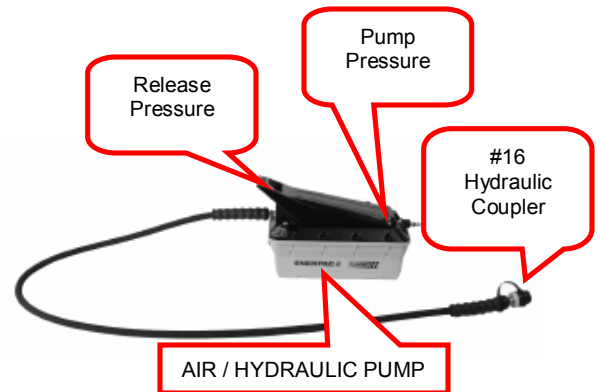
1-877-VAN-SANT

www.trick-tools.com

MACHINE SETUP



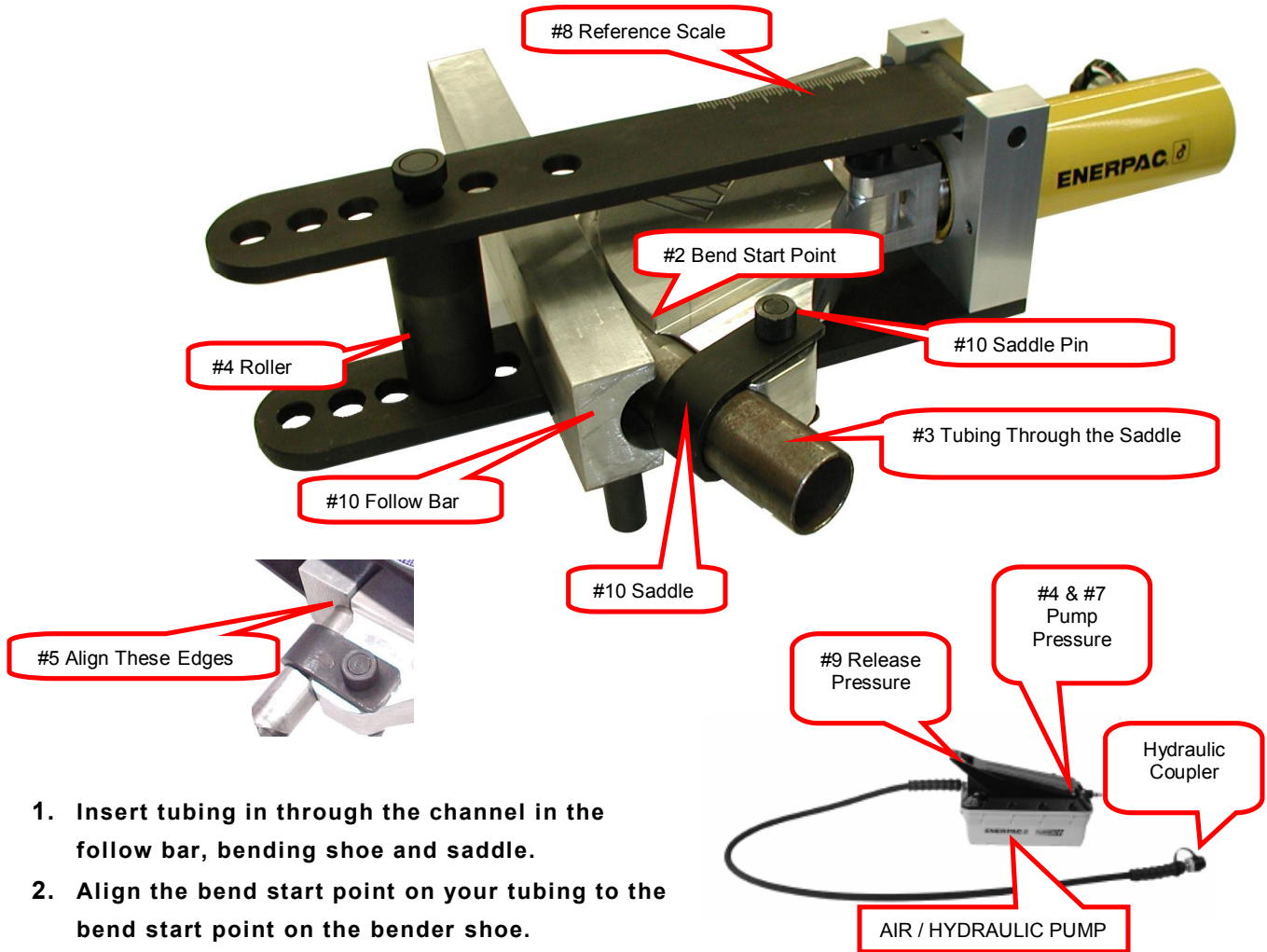
1. Remove machine from packaging.
2. Place machine on table or floor.
3. Remove roller pin.
4. Rotate upper frame out of the way.
5. Remove clevis pin.
6. Remove bender shoe from packaging.
7. Insert shoe into clevis as shown.
8. Insert clevis pin.
9. Remove saddle pin from saddle.
10. Place saddle on to shoe as shown.
11. Insert saddle pin into saddle and through the shoe.
12. Place follow bar on to machine as shown.
13. Slide roller up as close as you can to the follow bar and still be able to insert the roller pin through the frame.
14. Close the upper frame.
15. Insert roller pin.
16. Hook hydraulic coupler to hydraulic unit and supply air / power.
17. Machine is now ready for use.



1-877-VAN-SANT

www.trick-tools.com

OPERATION



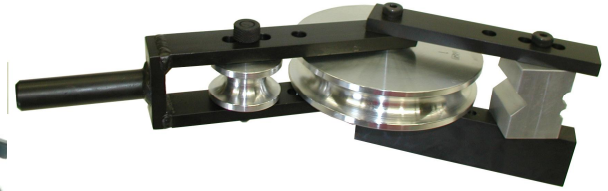
1. Insert tubing in through the channel in the follow bar, bending shoe and saddle.
2. Align the bend start point on your tubing to the bend start point on the bender shoe.
3. Make sure that tubing is sticking all the way through the saddle.
4. Press the foot pedal on the hydraulic pump, using short bursts until the bending shoe and follow bar are close to the roller.
5. Align the front edge of the follow bar with the bend start point of the bending shoe.
6. Check your tubing to make sure that your tubing start point is still aligned with the bend start point.
7. Now make your bend by pressing down on the foot pedal on the hydraulic unit until the desired angle is reached.
8. You may find it necessary to bend tubing past your desired angle a few degrees to account for tubing spring back. (For production bending take note of which mark on the reference scale the pointer is aligned with, then you can bend the next pieces to that mark)
9. Once the desired angle is reached, press on the top of the foot pedal on the hydraulic pump to release the pressure.
10. Remove the saddle pin, saddle and follow bar.
11. Repeat these steps with each additional bend.

1-877-VAN-SANT

www.trick-tools.com



Ultimate Tubing Notcher



180° Hand Tubing Bender



Power Bead Rollers



180° Hydraulic Tubing Bender



Bench Press

1-877-VAN-SANT

www.trick-tools.com