

Instructions for EO hand- bending equip- ment

- For on-site piping jobs
- Not for mass production



BAV06/12KPLX

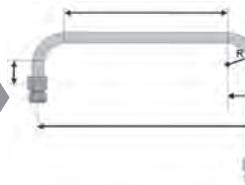


BV6/18KPLX

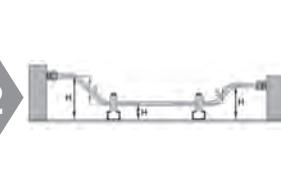


BV20/25KPLX

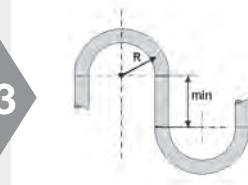
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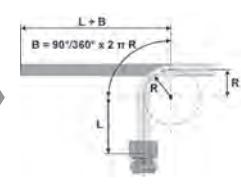
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3



4



⚠ Think the whole process through and plan each individual step before starting

⚠ First bend and then cut ends to length

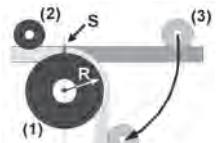
- Gather all dimensions like minimum straight lengths, extra length for flaring, bending radius, tube lengths for bows, etc.

- Consider steps
- Plan for clamping

- Check bending equipment specifications for limitations

- Start with first elbow
- Leave tube-end longer if in doubt

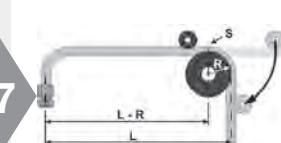
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6



7



8



⚠ Mark start of bend on tube (S)

- Adjust tube between bending roll (1), clamping roll (2) and pressure roll (3)
- Bend tube by pulling lever

- Check bend angle
- Correct angle if necessary
- Gather all dimensions for next bending operation

⚠ Mark start of bend on tube

- Continue bending
- Check and correct each result before starting next bend

- After the last bend, check tube for angles and dimensions
- Now cut both tube-ends to correct length
- Make sure that tube fits without tension