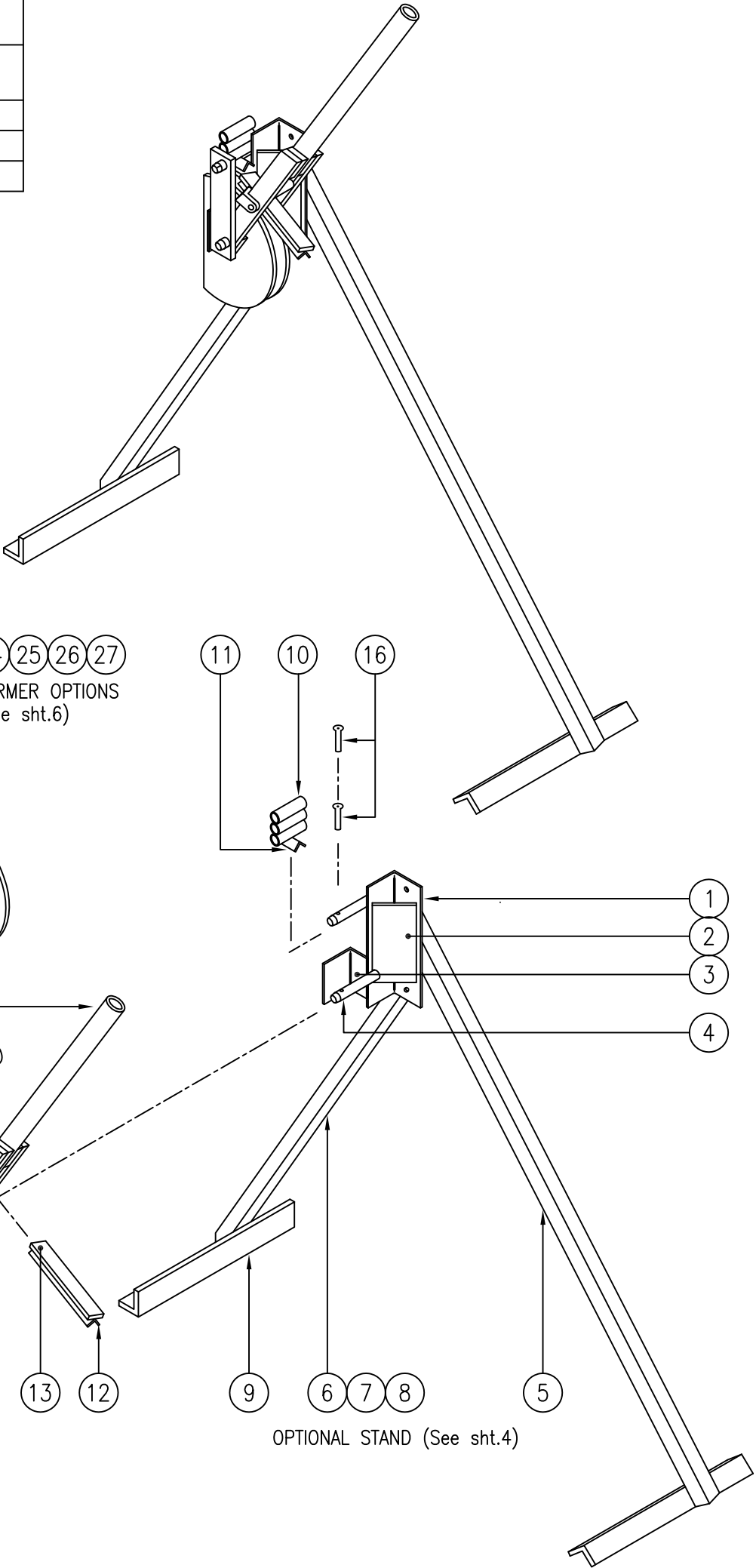


ApT PIPE BENDING MACHINE	
TITLE: ASSEMBLY	
SCALE: NOT TO SCALE	
DRAWN: ABATEC	PAGE: 1 of 6
CAD No: APT-02-1	



No.	DESCRIPTION	QUANTITY	DIMENSIONS
1	FRAME	1	80 x 80 ANGLE IRON x 300
2	STIFFENER	1	90 x 6 x 200
3	FORMER STOP	1	80 x 80 ANGLE IRON x 100
4	MAIN PIN	2	ø20 x 180
5	MAIN LEG	2	40 x 40 ANGLE IRON x 1350
6	SUPPORT LEG	1	40 x 40 ANGLE IRON x 1040
7	LEG PIVOT	1	M10 BOLT x 30
8	LOCKNUT	2	M10 NUT
9	FOOT	2	40 x 40 ANGLE IRON x 400
10	STOP TUBE	3	ø21 MIN. BORE THICK-WALL x 80
11	STOP ANGLE	1	20 x 20 ANGLE IRON x 50
12	GUIDE ANGLE	1	20 x 20 ANGLE IRON x 200
13	GUIDE BASE	1	40 x 10 x 200
14	ROLLER PIN	1	ø12 x 100
15	PIN HANDLE	1	40 x 40 ANGLE IRON x 20
16	LOCKING PIN	3	ø5 x 50 SPLIT PIN OR NAIL
17	ROLLER	1	ø35 (ø12 BORE) x 60
18	HANDLE	1	ø35 TUBE x 620
19	HANDLE ARM	2	40 x 10 x 400
20	HANDLE SPACER	2	40 x 16 x 100
21	FORMER SPACER	2	40 x 10 x 40
22	PIN LINK	1	40 x 10 x 220
23	FORMER BASE		
24	FORMER SIDE		
25	SPACER TUBE		
26	BOLTS		
27	NUTS		

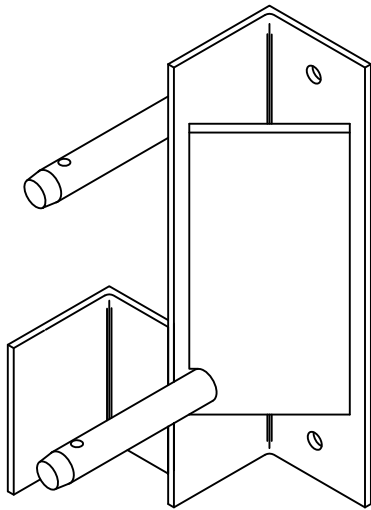
OPTIONAL:
MACHINE MAY BE
BENCH MOUNTED

PIPE DIAMETER-P	ø15	ø20	ø25	ø32
MIN. BEND RADIUS-R	60	90	120	120
FORMER SIDE RADIUS-F	73	105	138	145
SPACER LENGTH-L	8.5	6	3.5	0
BOLT HOLE RADIUS-H	45	75	105	
BOLT SPACING-B	50	70	65	
BOLTS	5 M10 x 40	5 M10 x 45	7 M10 x 50	
LAMINATE FORMER STEEL SHEETS (1mm THICK)	2 x ø67 2 x ø64 2 x ø62 4 x ø61 5 x ø60	2 x ø100 2 x ø96 2 x ø94 2 x ø93 2 x ø92 4 x ø91 6 x ø90	2 x ø132 2 x ø127 2 x ø126 2 x ø124 2 x ø123 4 x ø122 4 x ø121 7 x ø120	
STEEL FORMER BASE LENGTH BEFORE BENDING (5mm THICK)	307	389	480	

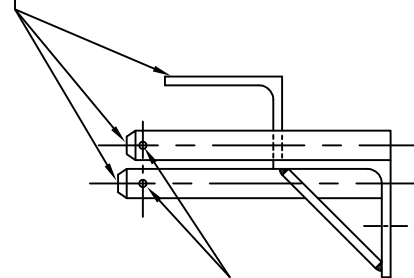
EXACT MATERIAL
REQUIREMENTS DEPEND
ON FORMER DESIGN
SELECTED. SEE OPPOSITE
FOR DETAILS.

Apt PIPE BENDING MACHINE	
TITLE: PARTS LIST AND FORMER DETAILS	
SCALE:	
DRAWN: ABATEC	PAGE: 2 of 6
CAD No: APT-02-2	

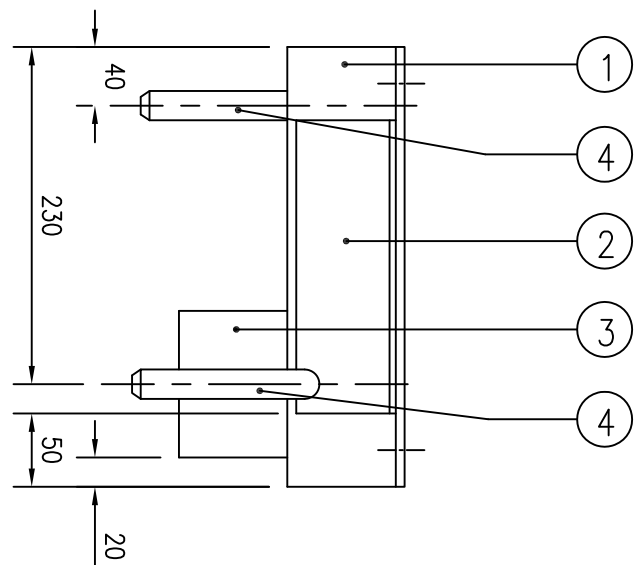
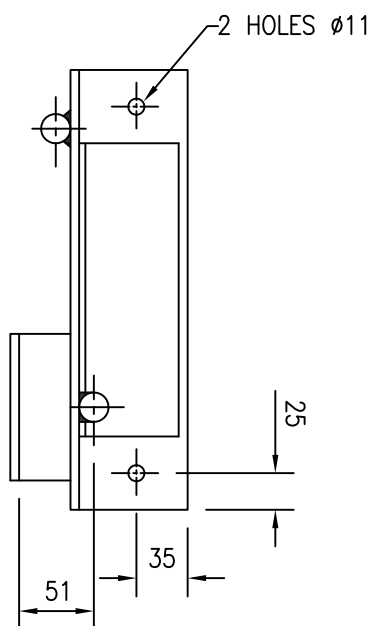
ApT PIPE BENDING MACHINE	
TITLE: FRAME SUB-ASSEMBLY	
SCALE: 1:5	
DRAWN: ABATEC	PAGE: 3 of 6
CAD No: APT-02-3	



ENSURE BOTH PINS AND
FORMER STOP ARE PARALLEL.



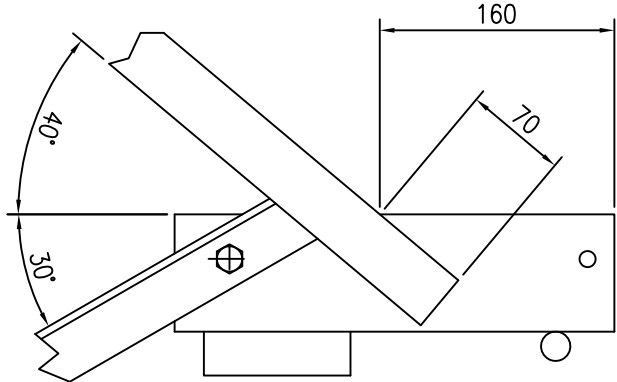
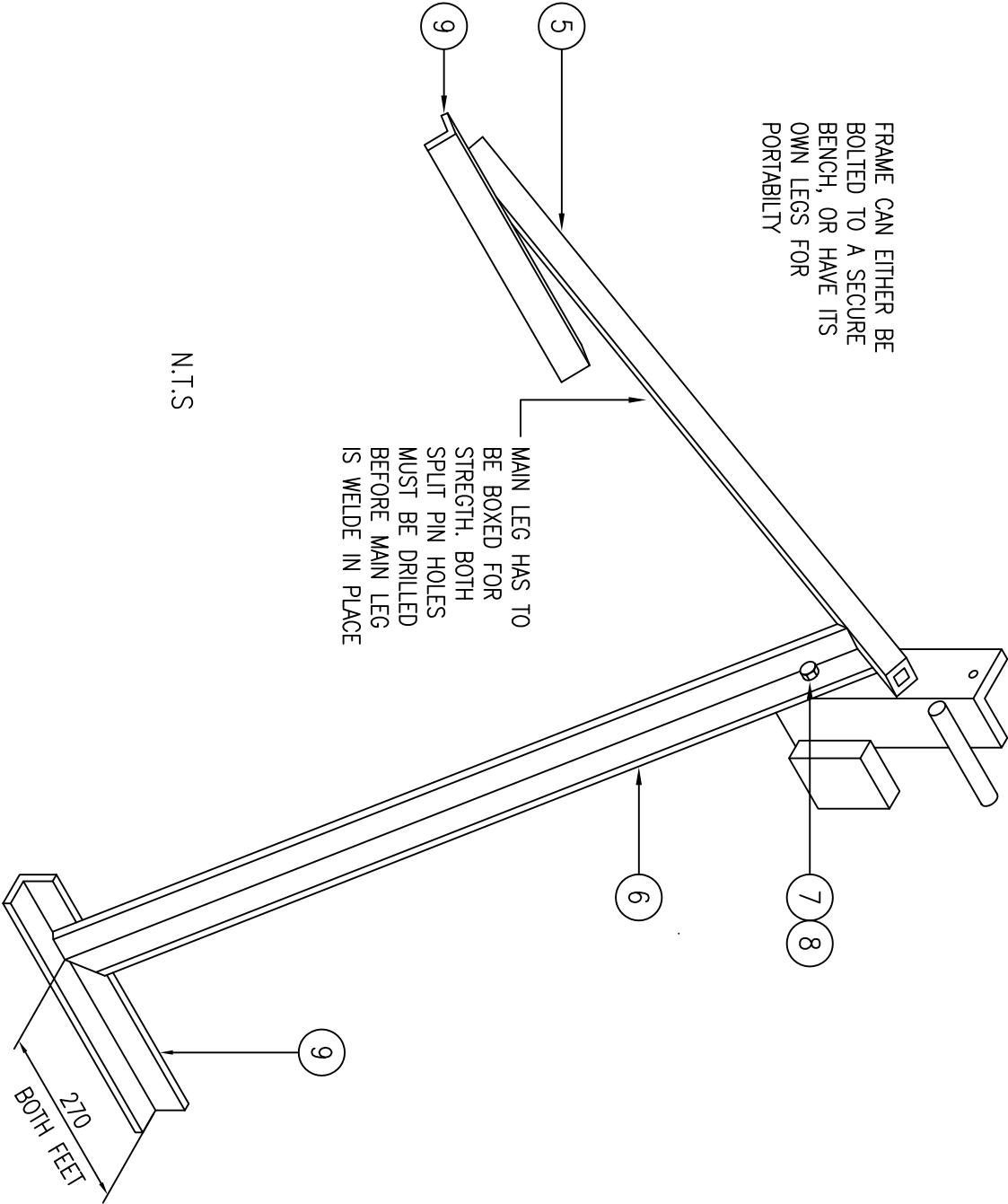
HOLES FOR SPLIT PINS
NEED TO BE DRILLED
AFTER ASSEMBLY TO
ENSURE HANDLE AND
PIPE STOP ARE A
SNUG FIT.



FRAME CAN EITHER BE BOLTED TO A SECURE BENCH, OR HAVE ITS OWN LEGS FOR PORTABILITY

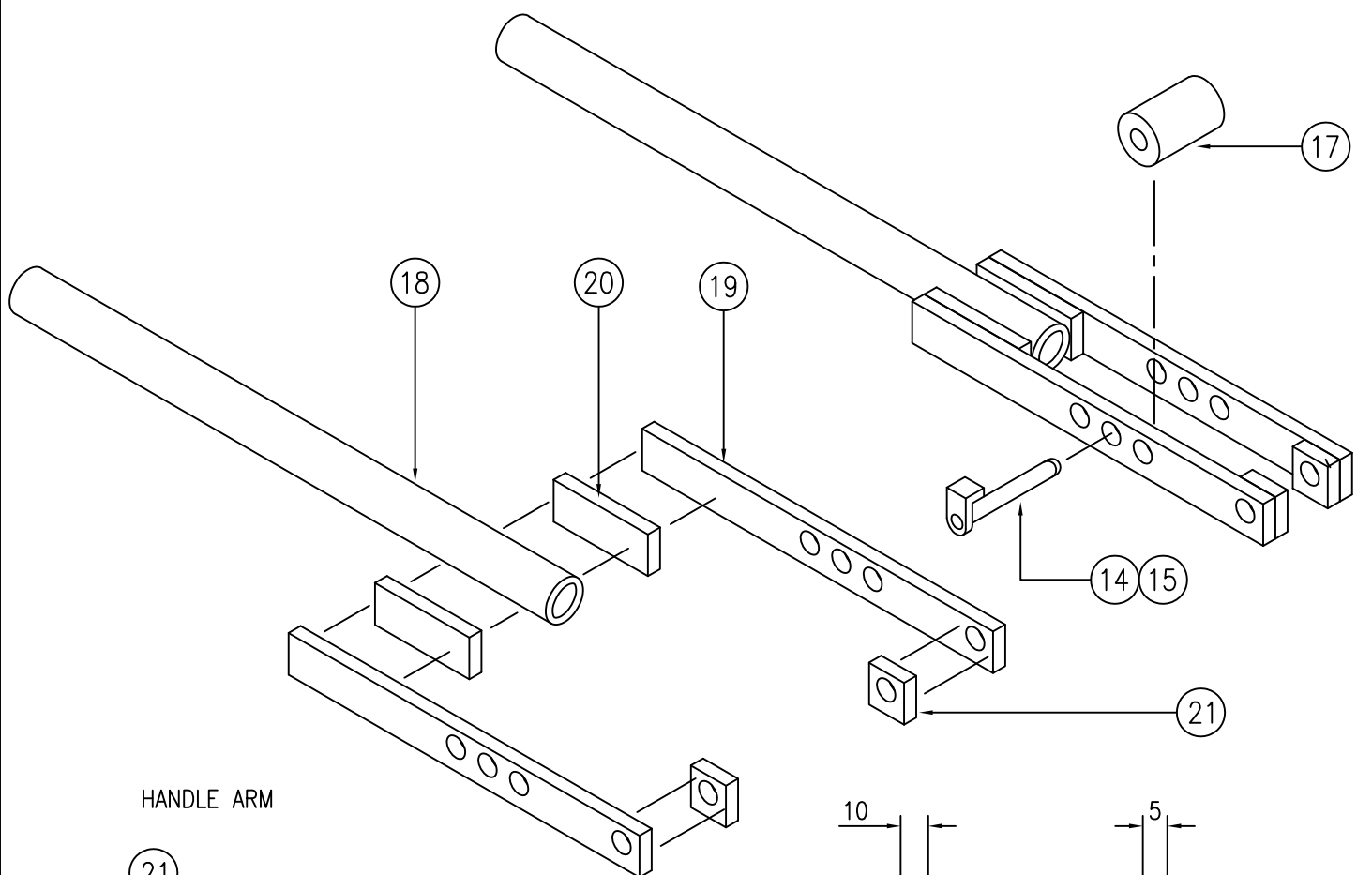
MAIN LEG HAS TO BE BOXED FOR STRENGTH. BOTH SPLIT PIN HOLES MUST BE DRILLED BEFORE MAIN LEG IS WELDED IN PLACE

N.T.S

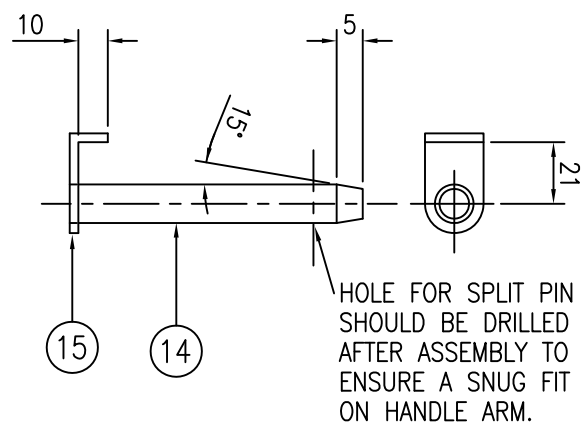
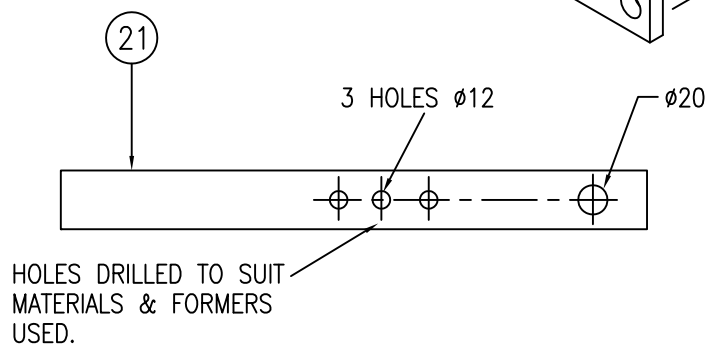


BOTH ENDS OF SUPPORT LEG NEED TO BE ANGLED BEFORE ASSEMBLY.

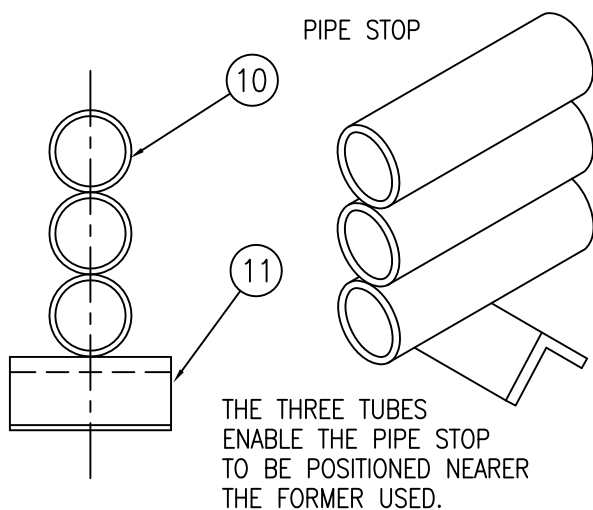
PIPE BENDING MACHINE	
TITLE: OPTIONAL STAND SUB-ASSEMBLY	
SCALE: 1:5 & 1:10	
DRAWN: ABATEC	PAGE: 4 of 6
CAD No: APT-02-4	



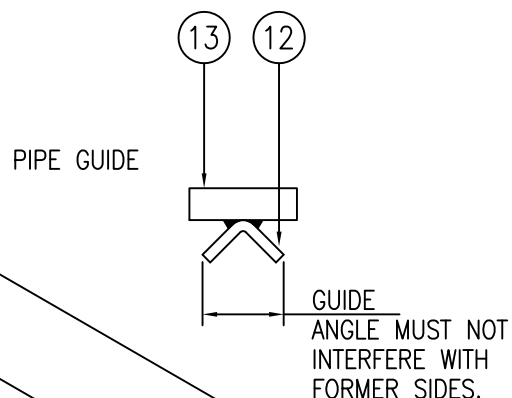
HANDLE ARM



ROLLER PIN



PIPE STOP

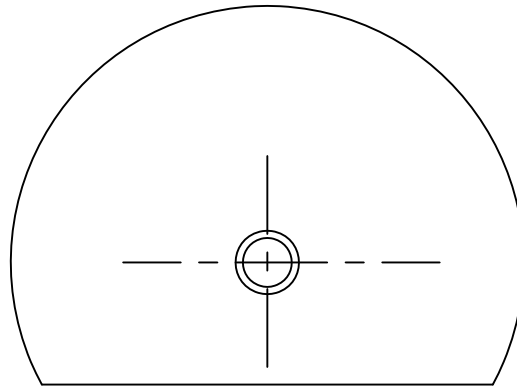
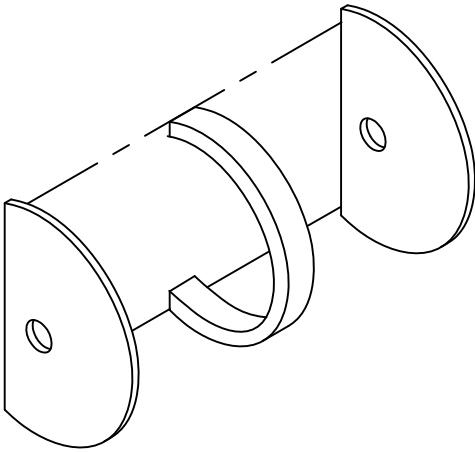


PIPE GUIDE

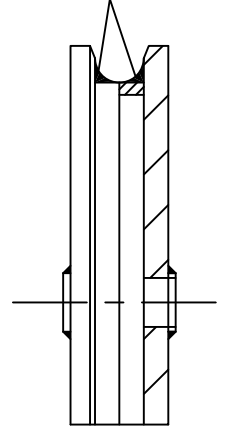
THE PIPE GUIDE SPREADS THE FORCE FROM THE ROLLER OVER THE PIPE TO HELP PREVENT DEFORMATION.

ApT PIPE BENDING MACHINE	
TITLE: HANDLE, ROLLER PIN, PIPE STOP & PIPE GUIDE SUB ASSEMBLIES	
SCALE: NOT TO SCALE	
DRAWN: ABATEC	PAGE: 5 of 6
CAD No: APT-02-5	

STEEL FORMER (WELDED CONSTRUCTION)



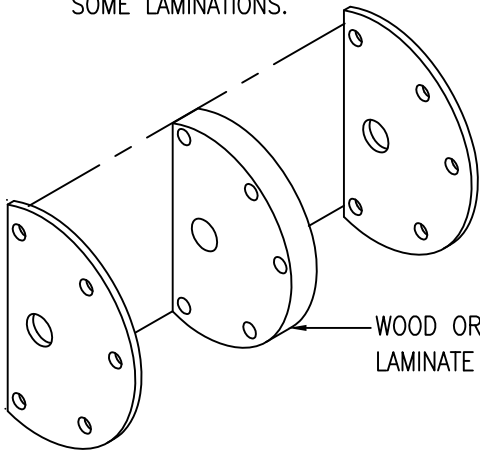
FILE WELDS TO SMOOTH RADIUS.



IF WOOD OF THE CORRECT THICKNESS IS UNAVAILABLE, A THINNER WOOD CAN BE USED FOR THE FORMER BASE AND STEEL SHIMS USED EITHER SIDE TO MAKE UP THE CORRECT THICKNESS.

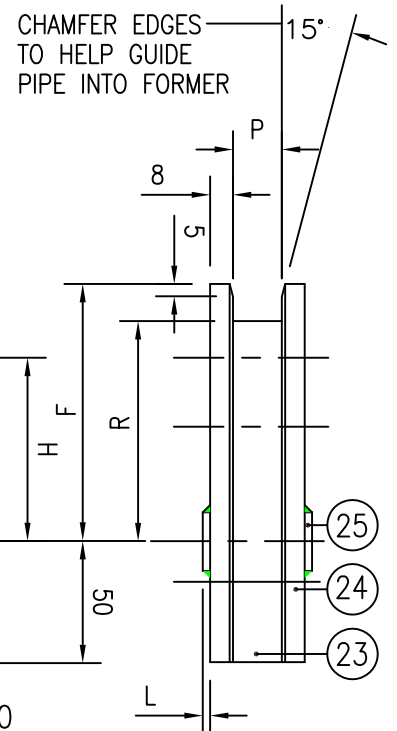
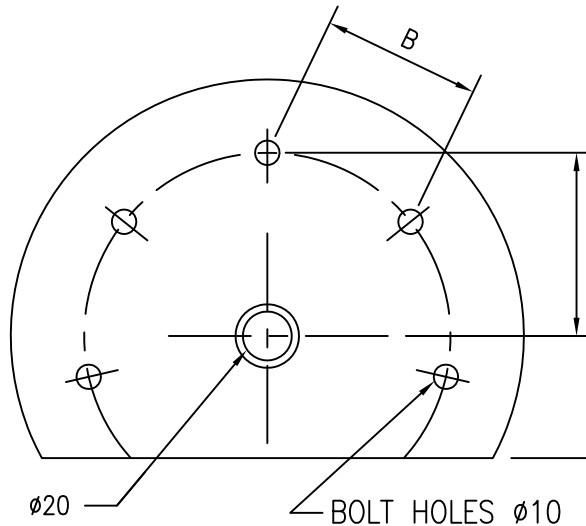
BOTH WOOD AND LAMINATE FORMERS ARE BOLTED TOGETHER FOR EASY REPLACEMENT OF WORN PARTS.

SMALLER DIAMETER PIPE CAN BE BENT BY REMOVING SOME LAMINATIONS.



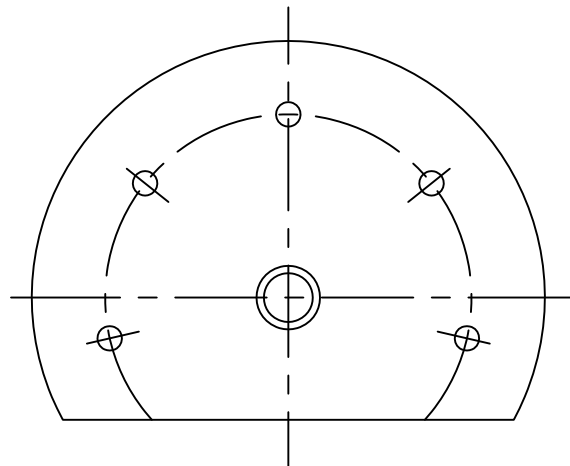
WOOD OR LAMINATE

WOOD FORMER (BOLTED CONSTRUCTION)

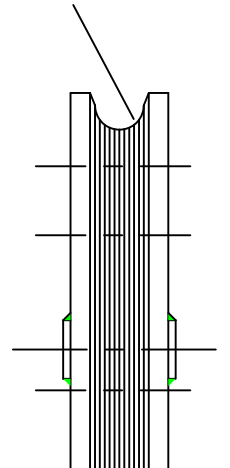


FOR SPECIFIC DIMENSIONS OF ALL FORMERS SEE PARTS LIST (PAGE 2)

LAMINATED FORMER (BOLTED CONSTRUCTION)



FILE LAMINATIONS TO SMOOTH RADIUS



ApT PIPE BENDING MACHINE	
TITLE: FORMER SUB-ASSEMBLY OPTIONS	
SCALE: 1:3	
DRAWN: ABATEC	PAGE: 6 of 6
CAD No: APT-02-6	