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VEVOR SWG-1

VEVOR Manual Pipe Bender 10T SWG-1 User Manual

Model: SWG-1

1. Safety Instructions

Read and understand all safety warnings and instructions before operating this pipe bender. Failure to follow these instructions may result in serious injury or property damage.

- Always wear appropriate personal protective equipment (PPE), including safety glasses, gloves, and sturdy footwear.
- Ensure the pipe bender is placed on a stable, level surface before operation.
- Do not exceed the maximum bending capacity of 10 tons or the specified pipe thickness and diameter.
- Keep hands and fingers clear of moving parts and the bending area during operation.
- Inspect the tool for any damage or wear before each use. Do not operate if damaged.
- Keep children and unauthorized personnel away from the work area.
- Use only VEVOR approved replacement parts and accessories.
- Release hydraulic pressure slowly and carefully after bending.

2. Product Overview

The VEVOR Manual Pipe Bender 10T, Model SWG-1, is a hydraulic tool designed for bending pipes made from various materials up to a 90-degree angle. It is suitable for use in construction, automotive, mining, and shipbuilding industries. The robust ductile cast iron dies ensure superior strength and durability.



Figure 2.1: The VEVOR Manual Pipe Bender 10T, Model SWG-1, shown from various perspectives, highlighting its compact design and sturdy construction.



Figure 2.2: An angled view of the pipe bender, showcasing the hydraulic pump handle and the bending frame.

3. Included Components

The following items are included in your VEVOR Manual Pipe Bender 10T package:

- Complete Pipe Bender Kit (main unit with hydraulic cylinder and frame)
- Bending Dies (various sizes)
- Wrench
- Gloves
- English Manual



Figure 3.1: The set of bending dies, wrench, and other small tools included with the pipe bender.

4. Specifications

Specification	Value
Model	SWG-1
Output	10 tons
Stroke	170 mm (7 inches)
Outer Pipe Diameter Range	13-34 mm (0.5-1.3 inches)
Die Sizes (Outer Diameter)	6.35 mm (1/4"), 7.9 mm (5/16"), 9.5 mm (3/8"), 12.7 mm (1/2"), 19 mm (3/4")
Pipe Wall Thickness	2-5 mm (0.07-0.19 inches)
Weight	23 kg (50.7 lbs)
Dimensions (L x W x H)	49 x 24.5 x 14.5 cm (19.2 x 9.6 x 5.7 inches)
Material	Ductile Cast Iron (Dies), Steel (Frame)



Figure 4.1: The pipe bender with key dimensions indicated, showing its overall size for planning workspace.

5. Setup

Follow these steps to set up your VEVOR Manual Pipe Bender:

1. **Unpack Components:** Carefully remove all components from the packaging. Verify that all included components listed in Section 3 are present.
2. **Assemble the Frame:** Attach the support legs to the main frame of the pipe bender. Ensure all bolts are securely tightened.
3. **Install the Hydraulic Unit:** Position the hydraulic cylinder and pump assembly onto the frame. Secure it using the provided fasteners.
4. **Select and Install Dies:** Choose the appropriate bending dies for the pipe diameter you intend to bend. The dies are made of ductile cast iron for durability. Insert the selected dies into their designated slots on the bending frame.
5. **Check Oil Level:** Before first use, check the hydraulic oil level. If necessary, add hydraulic oil (ISO VG 32 or equivalent) to the reservoir.

6. **Bleed Air (if necessary):** If the hydraulic system feels spongy or unresponsive, open the release valve slightly and pump the handle a few times to bleed any trapped air. Close the release valve before operation.



Figure 5.1: The main components of the pipe bender laid out, illustrating how the hydraulic unit connects to the bending frame and support legs.



Figure 5.2: A close-up side view of the hydraulic cylinder and the bending mechanism, showing the piston and the connection points for the dies.

6. Operating Instructions

Follow these steps for safe and effective pipe bending:

1. **Prepare the Pipe:** Ensure the pipe is clean, free of burrs, and cut to the desired length. Mark the bending point on the pipe.
2. **Select Dies:** Choose the correct bending dies for your pipe's outer diameter. The dies are marked with their respective sizes.
3. **Position the Pipe:** Place the pipe into the bending dies, aligning the marked bending point with the center of the main bending die. Ensure the pipe is seated firmly.
4. **Close Release Valve:** Ensure the hydraulic release valve (typically a knob or lever) is fully closed by turning it clockwise.
5. **Initiate Bend:** Slowly pump the hydraulic handle. The piston will extend, applying pressure to the pipe and causing it to bend. Observe the bend angle carefully.
6. **Monitor Bend Angle:** The pipe bender features adjustable step columns that can be set to control the bending angle. Stop pumping when the desired angle (up to 90 degrees) is achieved.
7. **Release Pressure:** Once the bend is complete, slowly open the hydraulic release valve by turning it counter-clockwise. This will retract the piston and release the pipe.
8. **Remove Pipe:** Carefully remove the bent pipe from the dies.



Figure 6.1: A close-up view of the bending die, showing the markings for different pipe sizes (e.g., 1/4", 5/16", 3/8", 1/2", 3/4", 1"). These markings assist in selecting the correct die for the pipe diameter.

7. Maintenance

Regular maintenance ensures the longevity and optimal performance of your pipe bender:

- **Cleaning:** After each use, clean the pipe bender, especially the dies and hydraulic cylinder, to remove any dirt, debris, or metal shavings.
- **Lubrication:** Periodically lubricate all moving parts and pivot points with a light machine oil.
- **Hydraulic Oil:** Check the hydraulic oil level regularly. If the oil appears dirty or discolored, replace it with fresh hydraulic oil (ISO VG 32 or equivalent). Refer to the manual for specific oil change procedures.
- **Storage:** Store the pipe bender in a clean, dry environment when not in use. Retract the hydraulic piston fully before storage.
- **Inspection:** Regularly inspect the frame, dies, and hydraulic system for any signs of wear, cracks, or damage. Replace worn or damaged parts immediately.

8. Troubleshooting

Refer to the following table for common issues and their solutions:

Problem	Possible Cause	Solution

Problem	Possible Cause	Solution
Hydraulic piston does not extend or extends slowly.	Low hydraulic oil level; Air in hydraulic system; Release valve open.	Check and refill hydraulic oil; Bleed air from the system; Ensure release valve is fully closed.
Piston retracts too quickly or does not hold pressure.	Release valve not fully closed; Internal hydraulic leak.	Ensure release valve is fully closed; Contact VEVOR support for repair.
Pipe slips during bending.	Incorrect die size; Pipe surface is oily or dirty.	Use correct die for pipe diameter; Clean pipe surface thoroughly.
Uneven or distorted bend.	Pipe not properly seated; Incorrect die selection; Pipe material too thin or thick.	Ensure pipe is centered and seated; Verify die size; Check pipe thickness against specifications.

9. Warranty & Support

For warranty information, technical support, or to order replacement parts, please contact VEVOR customer service. Keep your purchase receipt and product model number (SWG-1) handy for faster service.

Visit the official VEVOR website for the most up-to-date support resources and contact information:www.vevor.com

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