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> [WilTec Manual Bench Tube Bender Instruction Manual - Model 62534](#)

WilTec 62534

WilTec Manual Bench Tube Bender Instruction Manual

Model: 62534

1. INTRODUCTION

Thank you for choosing the WilTec Manual Bench Tube Bender. This tool is designed for precise and efficient bending of various pipe materials. Please read this manual thoroughly before operation to ensure safe and correct use, and to achieve optimal results.

This manual provides essential information on product components, setup, operation, maintenance, and troubleshooting. Keep this manual for future reference.

2. SAFETY INSTRUCTIONS

- Always wear appropriate personal protective equipment (PPE), including safety glasses and gloves, during operation.
- Ensure the tube bender is securely mounted or placed on a stable surface before use.
- Do not exceed the maximum bending capacity or pipe diameter specified for this tool.
- Inspect the tool and dies for any damage or wear before each use. Do not use if damaged.
- Keep hands and fingers clear of moving parts during the bending process.
- Store the tool and accessories in the provided case in a dry, secure place, out of reach of children.
- This tool is intended for bending soft copper, aluminum, and plastic pipes. Do not attempt to bend hardened steel or other unsuitable materials.

3. PACKAGE CONTENTS

The WilTec Manual Bench Tube Bender package includes:

- 1x Manual Tube Bender Unit
- Multiple Bending Dies (for 14mm, 16mm, 17mm, 20mm, 25mm, 32mm pipes)
- 1x Robust Plastic Storage Case

4. PRODUCT COMPONENTS

Familiarize yourself with the main components of the tube bender:

CINTRAGE DE TUBES FACILE



Image 4.1: Labeled components of the WiTec Manual Bench Tube Bender. Key parts include the fixing bar, pin axis, bending piece, push bar, manual lever, handle, butterfly nut, and extension spring.

- **Fixing Bar:** Holds the pipe securely during bending.
- **Pin Axis:** Connects the fixing bar to the main unit.
- **Bending Piece (Die):** The interchangeable part that forms the bend.
- **Push Bar:** Applies pressure to the bending piece.
- **Manual Lever:** Used to actuate the bending mechanism.
- **Handle:** Provides grip for operation.
- **Butterfly Nut:** Secures the fixing bar.
- **Extension Spring:** Assists in the mechanism's return.

5. SETUP

The tube bender is designed for quick and easy assembly. Follow these steps to prepare the tool for use:

PORTABLE ET D'ASSEMBLAGE FACILE

PRÊTE AU FONCTIONNEMENT DANS 3 SIMPLES ÉTAPES



Image 5.1: Assembly steps for the WilTec Manual Bench Tube Bender.

1. **Step 1:** Select the appropriate bending die (bending piece) for your pipe diameter. Insert the die into the main unit.
2. **Step 2:** Attach the fixing bar (rail) to the main unit using the pin axes and secure it with the butterfly nuts. Ensure it is firmly in place.
3. **Step 3:** Actuate the manual lever to bring the bending piece to the initial position, ready to receive the pipe.

6. OPERATING INSTRUCTIONS

This manual tube bender allows for precise bends up to 90 degrees. It is suitable for soft copper, aluminum, and plastic pipes ranging from 14mm to 32mm in diameter.

AJUSTAGE DE L'ANGLE DE CINTRAGE

JUSQU'À 90° PAR UN SEUL CINTRAGE

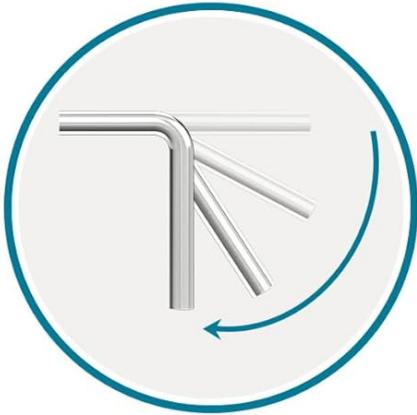


Image 6.1: Demonstrating the 90-degree bending capability.

1. **Prepare the Pipe:** Ensure the pipe is clean and free of debris. Mark the desired bending point on the pipe.
2. **Insert the Pipe:** Place the pipe between the selected bending die and the fixing bar. Align the marked bending point with the center of the bending die.
3. **Initiate Bend:** Firmly grip the handle and slowly actuate the manual lever. The ratchet mechanism will engage, gradually bending the pipe.
4. **Monitor Bend Angle:** Continuously observe the pipe's angle as you apply pressure. Stop when the desired angle is achieved (up to 90 degrees).
5. **Release Pipe:** Once the bend is complete, release the pressure on the lever. Carefully remove the bent pipe from the tool.

6.1. Selecting Bending Dies

The tool comes with various bending dies to accommodate different pipe diameters. Always use the correct die for your pipe size to prevent damage to the pipe or the tool.

DIFFÉRENTES PIÈCES PRESSE POUR CINTRAGE PRÉCIS



Image 6.2: Available bending dies with corresponding pipe diameters and bending radii.

Table 6.1: Bending Die Specifications

Pipe Diameter	Approximate Bending Radius
14 mm	95 mm
16 mm	110 mm
17 mm	120 mm
20 mm	135 mm
25 mm	170 mm
32 mm	185 mm

7. MAINTENANCE

Regular maintenance ensures the longevity and optimal performance of your tube bender.

- **Cleaning:** After each use, wipe down the tool and dies with a clean, dry cloth to remove any dust or residue.
- **Lubrication:** Periodically apply a light machine oil to the moving parts, such as the ratchet mechanism and pin axes, to ensure smooth operation.
- **Inspection:** Regularly check all components for signs of wear, damage, or loose fasteners. Tighten any loose screws or nuts. Replace worn or damaged dies immediately.
- **Storage:** Store the tube bender and all accessories in its robust plastic case in a dry, cool environment to prevent rust and damage.

8. TROUBLESHOOTING

If you encounter issues during operation, refer to the following troubleshooting guide:

Table 8.1: Troubleshooting Guide

Problem	Possible Cause	Solution
Pipe deforms or kinks during bending.	Incorrect die size; pipe material too hard; bending too fast.	Ensure correct die for pipe diameter. Verify pipe material is suitable. Bend slowly and steadily.
Bending mechanism is stiff or difficult to operate.	Lack of lubrication; dirt or debris in mechanism.	Clean and lubricate all moving parts.
Pipe slips during bending.	Pipe not securely placed; fixing bar loose.	Ensure pipe is firmly seated. Tighten butterfly nuts on fixing bar.
Inconsistent bend angle.	Improper alignment; uneven pressure.	Ensure pipe is correctly aligned with the die. Apply consistent pressure on the lever.

If the problem persists after attempting these solutions, please contact WilTec customer support.

9. SPECIFICATIONS

Refer to the following technical specifications for the WilTec Manual Bench Tube Bender:

DIMENSIONS DU PRODUIT

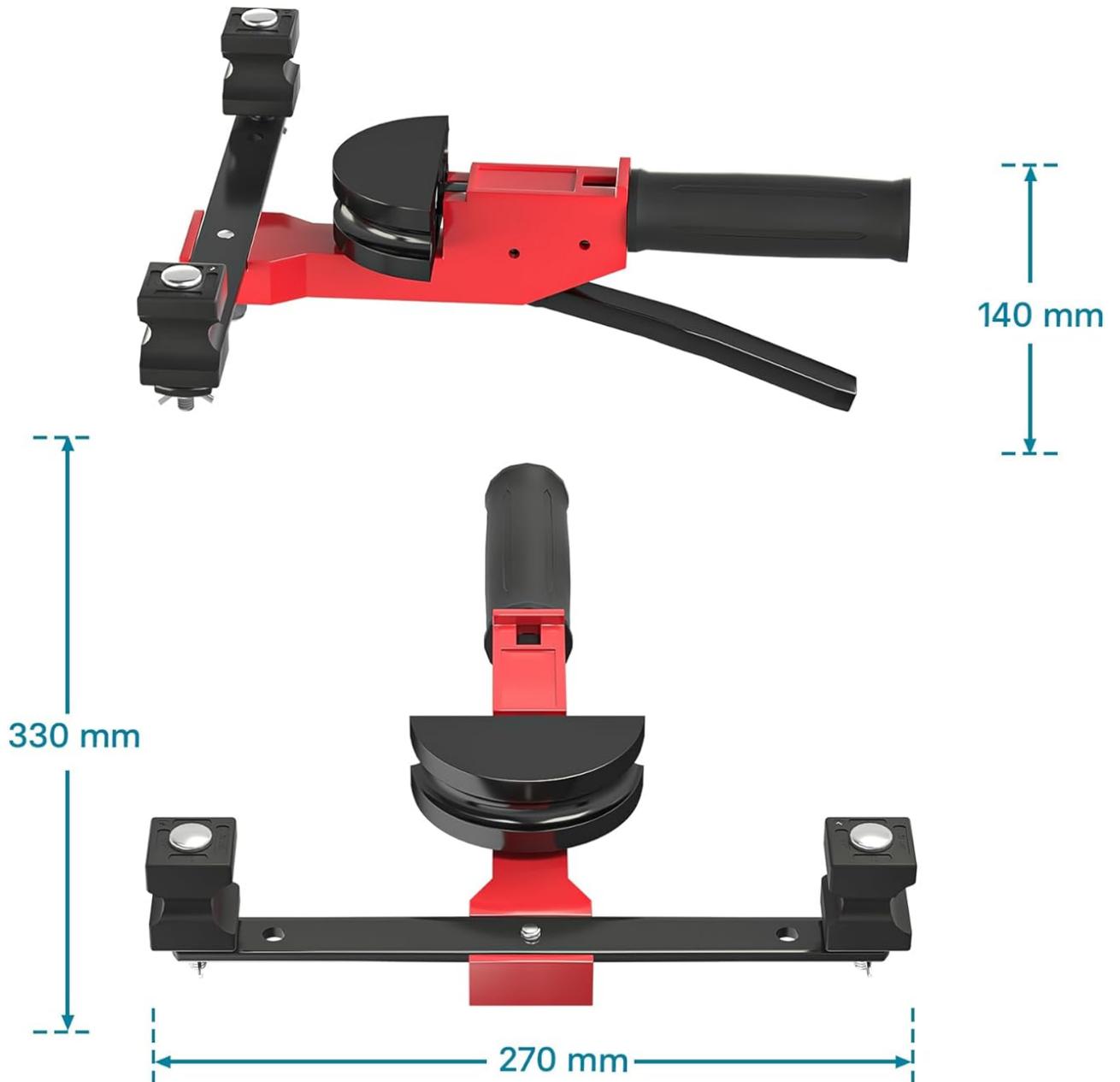


Image 9.1: Dimensions of the WilTec Manual Bench Tube Bender.

Table 9.1: Product Specifications

Feature	Detail
Manufacturer	WilTec
Model Number	62534
Pipe Diameter Range	14 mm to 32 mm
Maximum Bending Angle	90°
Compatible Materials	Soft Copper, Aluminum, Plastic (including coated tubes)
Item Weight	3.32 Kilograms

Feature	Detail
Package Dimensions	44.2 x 33.6 x 11 cm
Country of Origin	China

10. WARRANTY INFORMATION

WilTec products are manufactured to high-quality standards and are subject to strict quality controls. This product comes with a standard manufacturer's warranty against defects in materials and workmanship under normal use. The warranty period typically begins from the date of purchase. Please retain your proof of purchase for any warranty claims.

For specific warranty terms and conditions, or to initiate a warranty claim, please refer to the documentation included with your purchase or visit the official WilTec website.

11. SUPPORT

For technical assistance, spare parts, or any questions regarding the operation or maintenance of your WilTec Manual Bench Tube Bender, please contact WilTec customer support.

- **Online Support:** Visit the official WilTec website for FAQs, product information, and contact forms.
- **Email Support:** Refer to your product packaging or the WilTec website for the appropriate customer service email address.
- **Phone Support:** Contact numbers for customer service can be found on the official WilTec website.

When contacting support, please have your product model number (62534) and proof of purchase readily available.