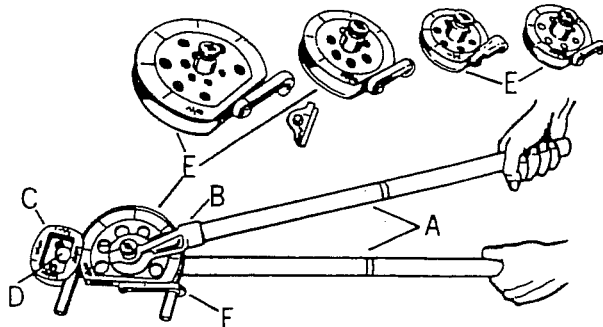


260FHA
6pgs

INSTRUCTIONS FOR OPERATING Nos. 260-FHA, 350-FHA, 360-FHA, 361-FHA, 362-FHA, 363-FHA and 365-FHA BENDING TOOLS

U.S. Pat. Nos. 2,171,907; 2,887,917; RE 24,449
CONFORMS TO FEDERAL SPEC. GGG-B-191a, 3-1-63, Type III, Class I.

(Where bender includes 1/4" and 5/16" O.D. sizes, see instructions for
operating on reverse side of this sheet.)



For Bending annealed copper, aluminum, steel, stainless steel and hard copper
tubing (including types K, L and ACR) of bending temper.

Note: Type M tubing is not recommended for bending.

Bends can be made to any angle up to 180° return bend with these benders. The illustration shows position of bender after completing a 180° bend.

To insure easy operation, it is important to lubricate surface of forming block "C" before starting bend.

Screw handles "A," with extensions, into base of bender and top operating piece "B." Fasten the forming block "C" to base of bender by means of knurled head screw "D" so that side of block marked for size of tubing to be bent faces handle. Turn screw down snugly. If it not necessary that it be absolutely tight. For 3/8" and 1/2" tubing, screw should be inserted in hole in block that is next to side of block to be used. For 5/8" and 3/4" tubing, screw should be inserted in hole next to the 3/4" mark.

Note that some models have single or double faced forming blocks instead of 4 faced block described above. Procedure in all cases is similar to that described.

Place tubing in groove of forming block and slide forming wheel "E" of proper size up to the block until pin in forming wheel drops into hole in base. Rotate forming wheel so that hook "F" can be dropped over tube to right of block.

Place operating handle in most convenient position with pins of top operating piece engaging holes of forming wheel. Proceed to make the bend.

Bend need not be made in one continuous sweep of handle. Top operating piece can be lifted and rotated during the course of the bend so that pins will engage other holes in order to maintain the most convenient position for easy operation throughout the bend.

After completing bend, back up forming wheel slightly to release tension on tube and pull up pin holding forming wheel. This releases forming wheel and frees tubing.

(OVER)

IMPORTANT

Apply lubricant regularly to surface
of forming shoe and all other places
where rubbing action occurs.

◆ Imperial • Niles, IL 60714

INSTRUCTIONS FOR OPERATING

1/4" and 5/16" O.D. Sizes of No. 260-FHA and 350-FHA BENDING TOOL

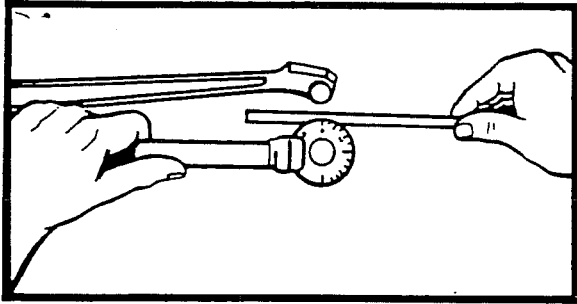


Fig. 1—When placing tube in bender, raise the right handle of bender as far as it will go so that it rests in a horizontal position as shown. Raise the clip and drop the tube in the space between the handle slide block and the bending form.

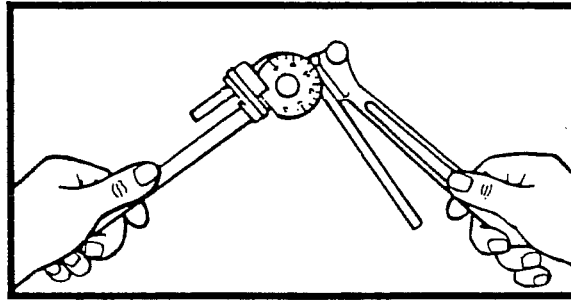


Fig. 3—Proceed to bend desired angle.

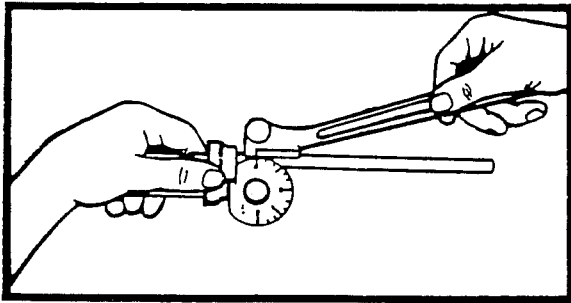


Fig. 2—Drop clip over tube and turn handle slide bar about its pin and press to the right as shown. Note that zero mark on bending form will coincide with mark on slide bar.

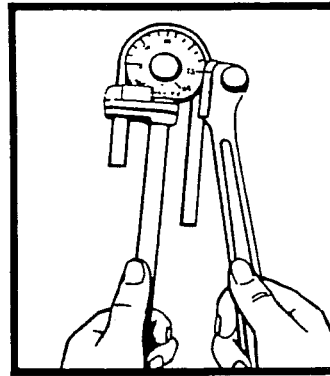


Fig. 4—Bends to any angle up to 180° may readily be made with this IMPERIAL tube bender.

To remove the bent tube from bender, lift the handle slide bar back to its horizontal position shown in Fig. 1 and raise the clip. Tube is then free and can readily be removed from bender.

NOTE: Occasionally placing a drop of oil on the pins and bending shoe will assure a smoother working tool.

IMPERIAL

Form 10,554-EE 684A P000034

(OVER)

PRINTED IN U.S.A.

IMPORTANT

Apply lubricant regularly to surface of forming shoe and all other places where rubbing action occurs.

◆ Imperial • Niles, IL 60714

P0000001

MADE AND PRINTED IN THE U.S.A.

GUIDE FOR MAKING DIMENSIONAL BENDS

WITH IMPERIAL TUBE BENDERS 260-FH, 350-FH, 360-FH, 364-FH
 $\frac{5}{8}$ " , $\frac{3}{4}$ " AND $\frac{7}{8}$ " O.D. , 361-FH, 362-FH, 363-FH AND 365-FH.

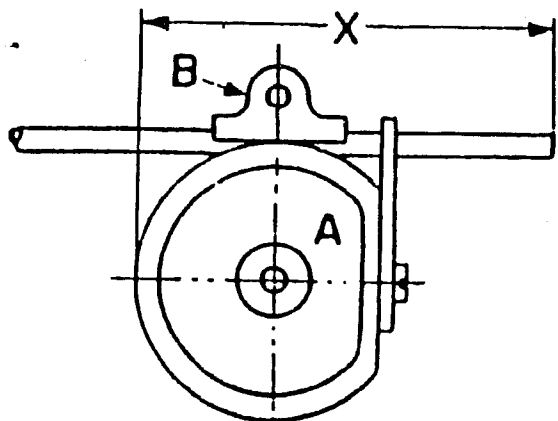
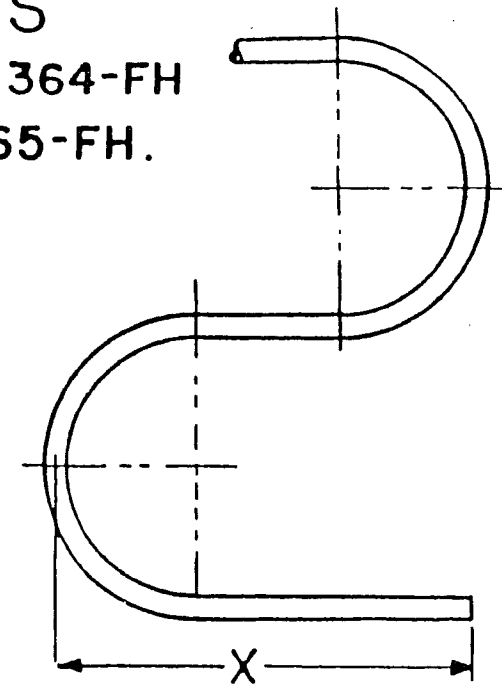
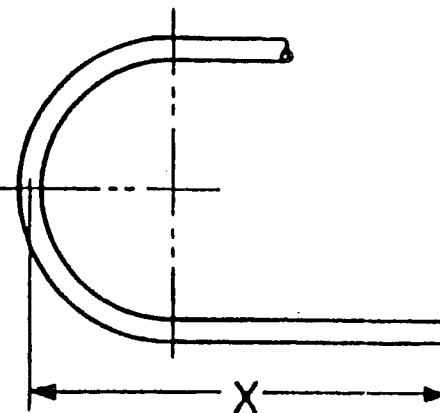
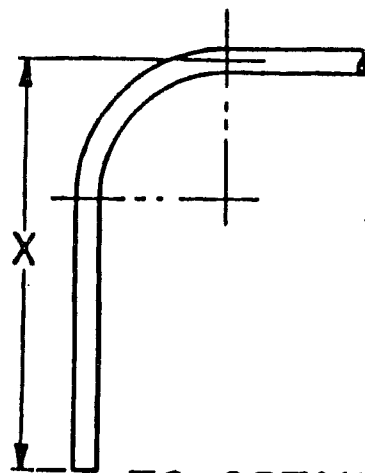


FIG. 1

A-MANDREL
B-SHOE



TO OBTAIN "X" DIMENSION, TUBE SHOULD BE PLACED IN BENDER AS ILLUSTRATED IN FIGURES 1 AND 2

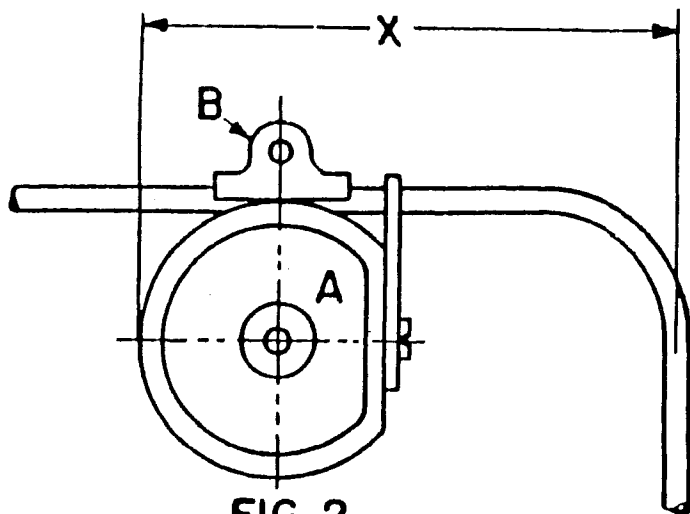
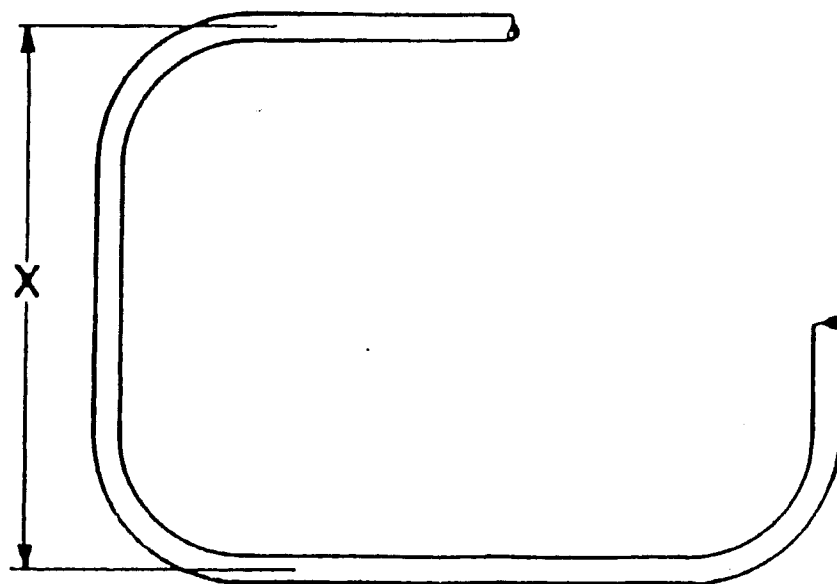
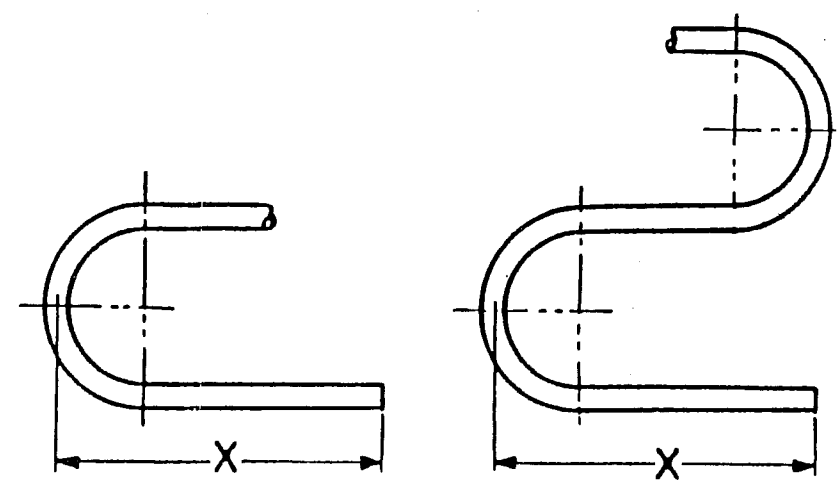
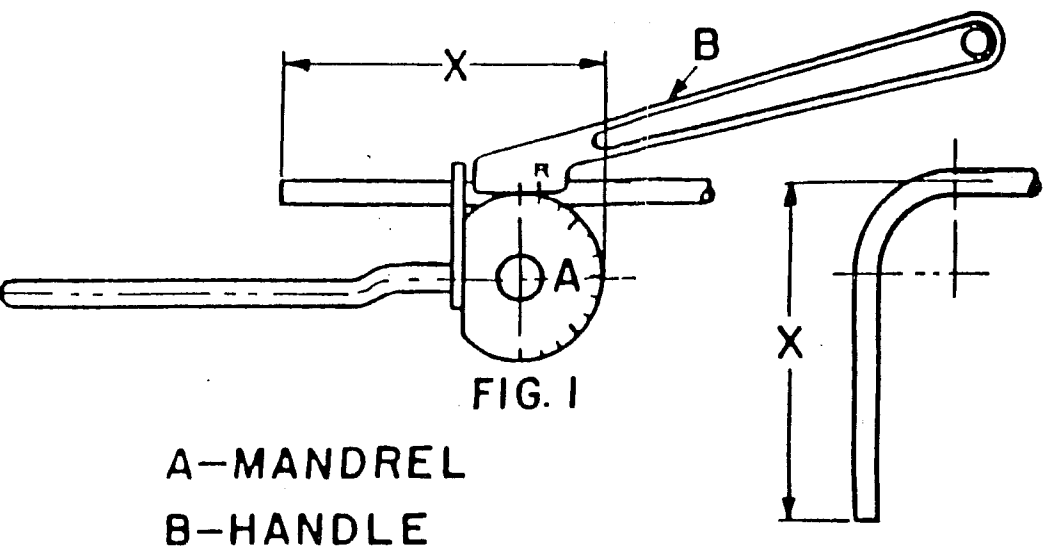


FIG. 2



GUIDE FOR MAKING DIMENSIONAL BENDS
 WITH IMPERIAL BLUE DOT TUBE BENDERS $\frac{3}{16}$, $\frac{1}{4}$, $\frac{5}{16}$, $\frac{3}{8}$ O.D.



TO OBTAIN "X" DIMENSION, TUBE SHOULD BE PLACED
 IN BENDER AS ILLUSTRATED IN FIGURES 1 AND 2

