

# INSTRUCTIONS FOR OPERATING IMPERIAL NO. 364FHA AND 364FHAM LEVER TYPE TUBE BENDERS

US.PAT. Nos. 2,887,917 and 3,685,335

This bender can be used for bending steel, stainless steel, copper, aluminum and other metal tubing of bending temper. Extremely thin walled and/or hard temper tubing should be avoided. (Type M tubing is not recommended for bending.)

## BENDER SETUP

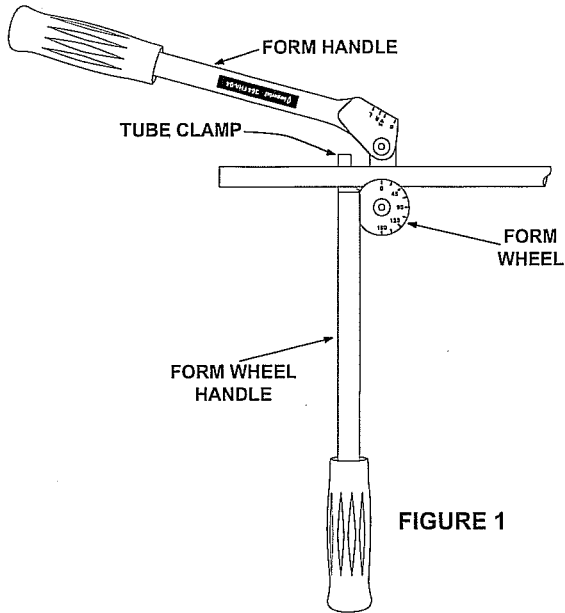


FIGURE 1

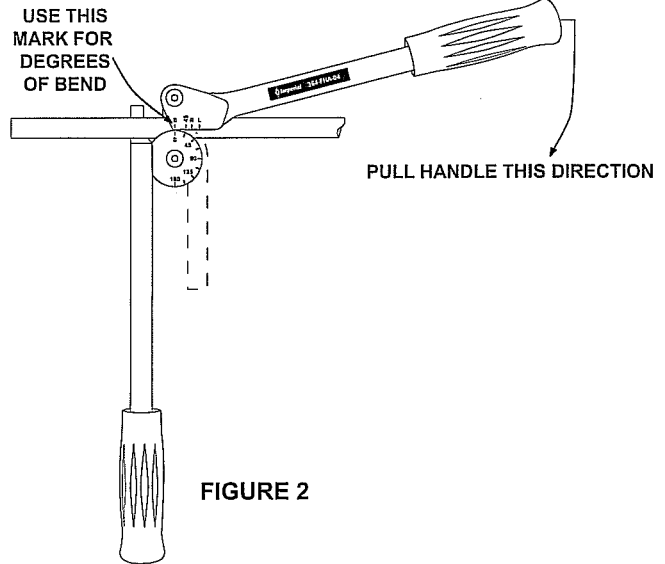


FIGURE 2

1. Raise form handle. (Fig. 1)
2. Position tubing in groove as shown. Also be sure that the tube is engaged with the tube clamp.
3. Lower the form handle to position shown. (Fig. 2)

4. Then pull lever handle in direction of arrow until the desired bend angle is obtained.
5. Degree of bend is indicated by mark on form handle and shown in Fig. 2. Bends up to 180° can be made in one sweep of the handle.

## 90° Bends

1. Measure from end of tube (first bend) and place mark on tubing.
2. Position tube in bender as shown in Fig. 3. If the end from which you measured is left of the tube clamp, the measured mark should be directly over graduation "L" located on the right side of the form lever and shown in Fig. 3.

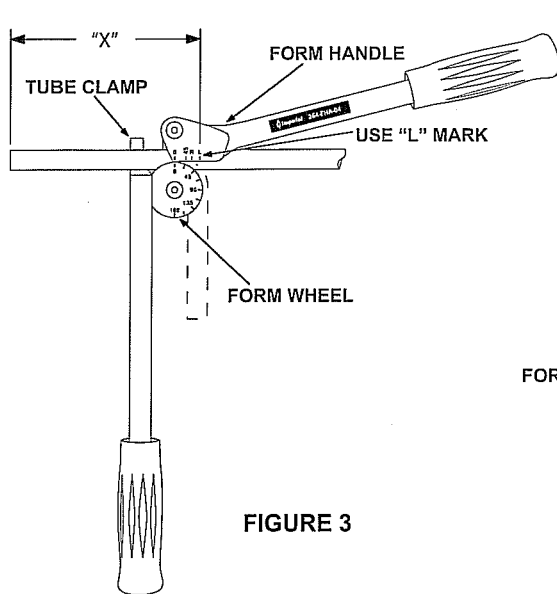


FIGURE 3

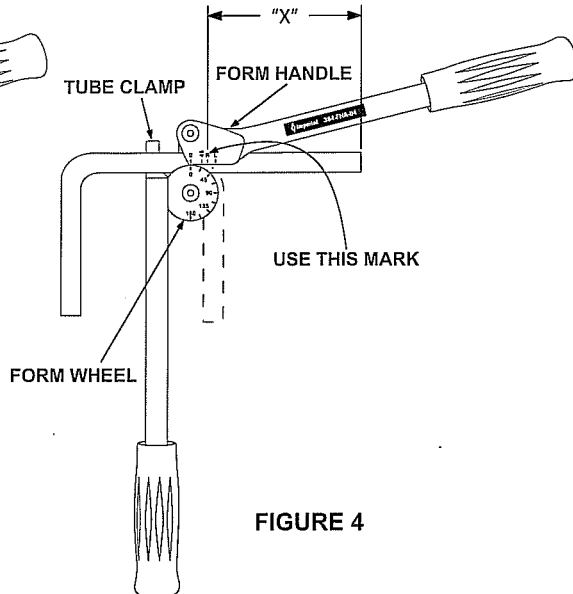


FIGURE 4

3. If the end from which you measured is placed to the right of the tube clamp, set the mark on the tube directly over graduation "R" located on the form lever and shown in Fig. 4. With a steady motion, pull form handle around until the "0" mark on form handle is directly opposite the 90° mark on form wheel.
4. If more than one bend is required (Fig. 5), measure from the center line of the first bend leg and mark per drawing dimension. Proceed with bend as described in Step 2.

## Single 45° Bends

A single 45° bend may be made by measuring from end of tube to where bend is to be located and placing a mark at this point. Place tube in bender so that the mark on tube is located directly in line with the "45" graduation on form handle shown in Fig. 6.