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1 - Kit

The pipe bending machines OB85/S and OB/KIT are sold in a plastic kit.

1.2 Storing

The kits must be kept in a dry place without dust.

2 – Machine's description

2.0 Function's description

The OB85/S is a manual, portable and light bending machine.

The pump helps to bend and flanging big diameters with the lowest effort. With the technical solutions used, we can consider this machine unique in its category.

2.1 Technical characteristics

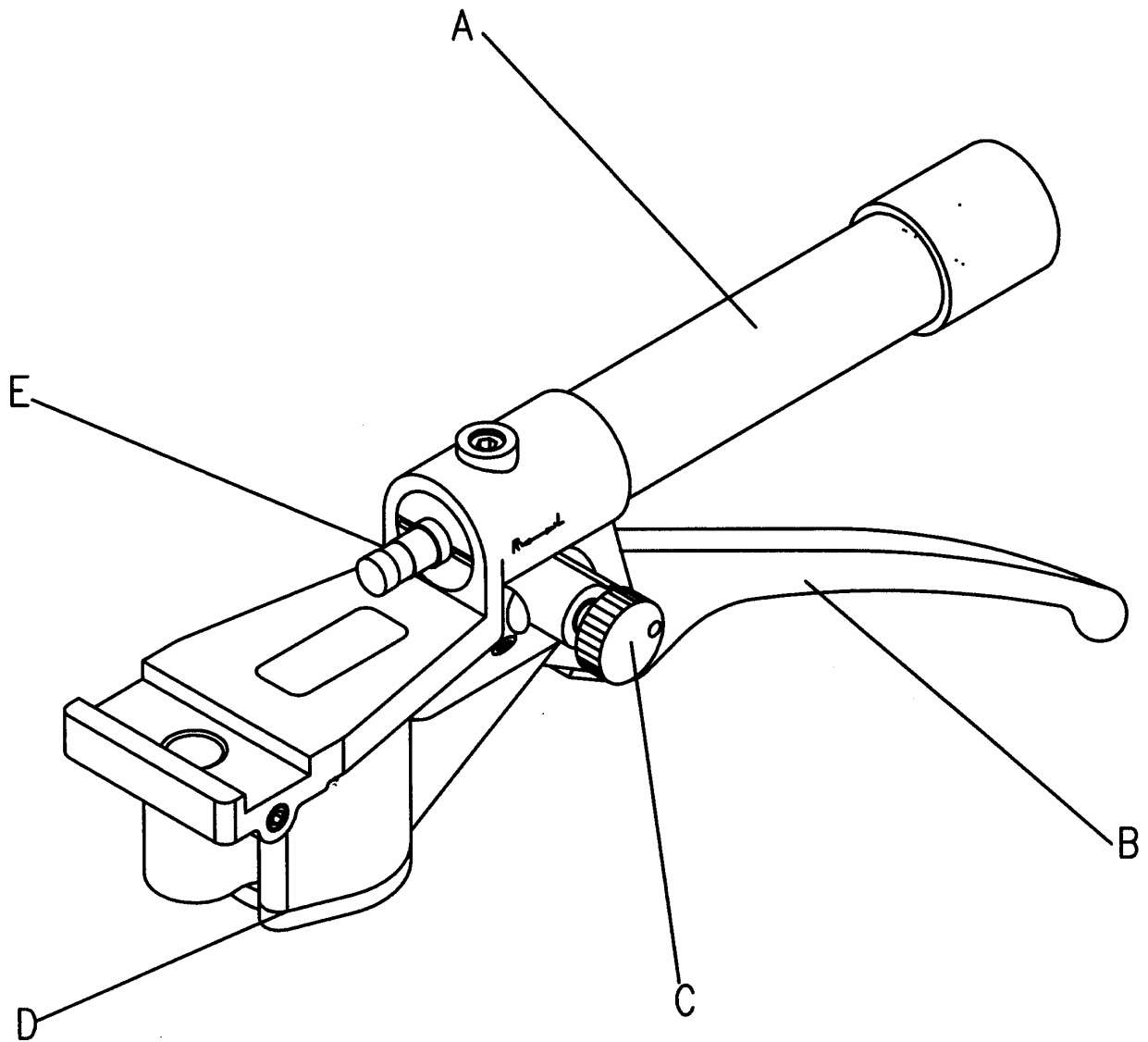
- Pump body in spindle aluminium and stainless steel with double hydraulic circuit

2.2 Capacity of bending

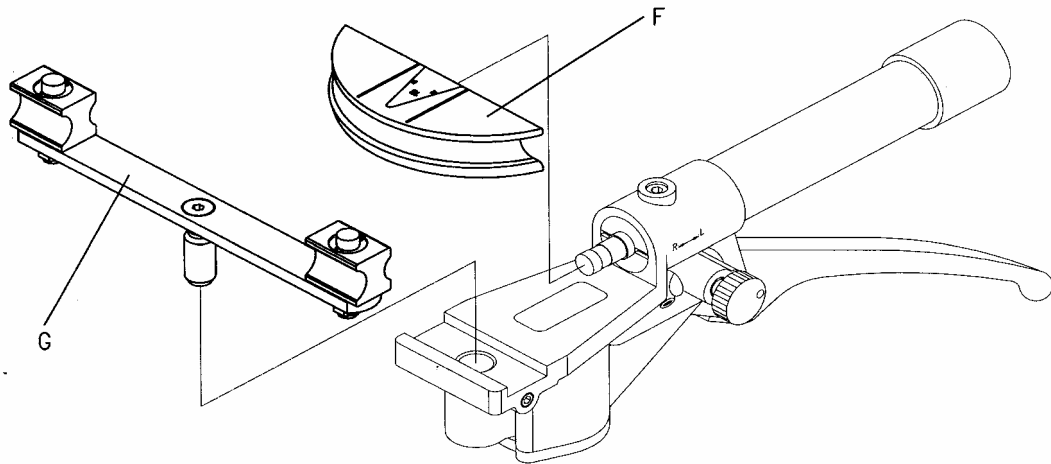
Material of the pipe	Max diam	thickness
SOFT COPPER PIPE	22	1,5 mm
COATED PIPE	32	3,0 mm

2.3 Controls' description

- A = handle
- B = action lever
- C = stopper head
- D = tank cap
- E = piston



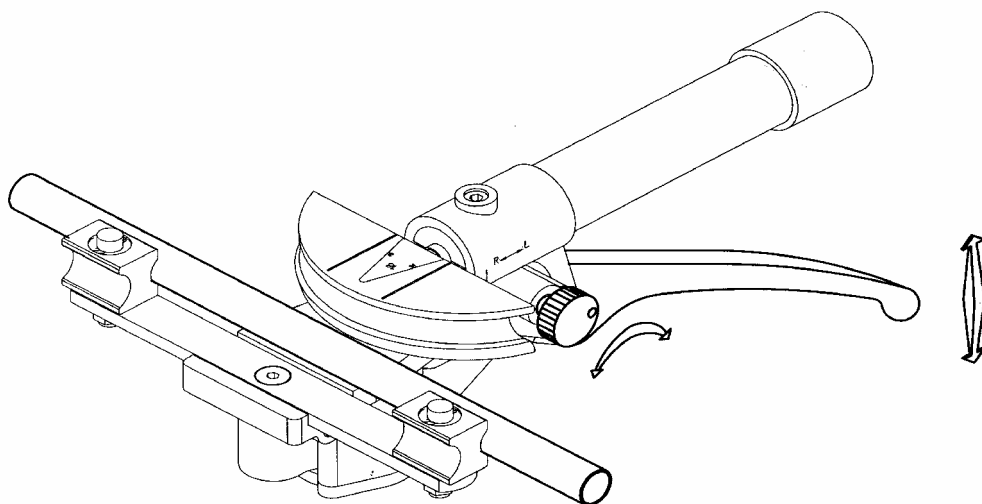
3.1 - Use OB85/S for bending



Choose the counterformer (**G**) and the former (**F**) according to the diameter of the pipes you need to bend. Put the former and the counterformer in the right place as in the picture

Please note that you must use the counterformers according to the diameter for the pipe you want to bend:

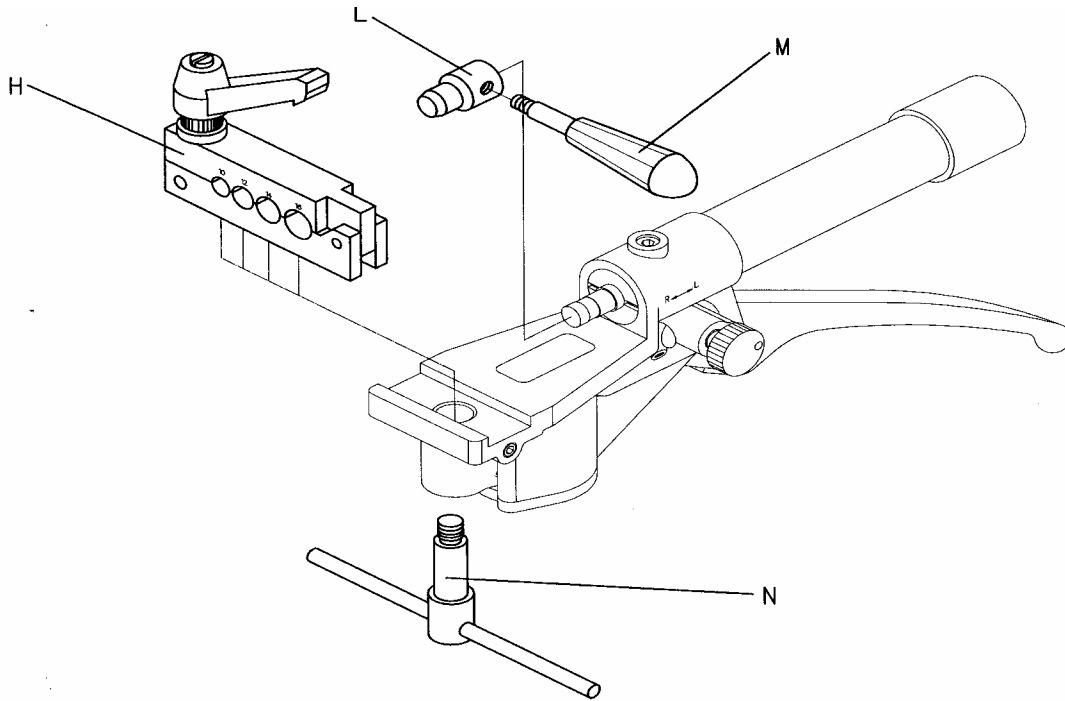
COUNTERFORMERS	MATERIAL	PIPE DIAMETER
10-12	COPPER	dal 10 al 12
14-17	COPPER	dal 10 al 17
18-22	COPPER	dal 18 al 22
16	DOUBLE COATED	16
20	DOUBLE COATED	20
26	DOUBLE COATED	26
32	DOUBLE COATED	32



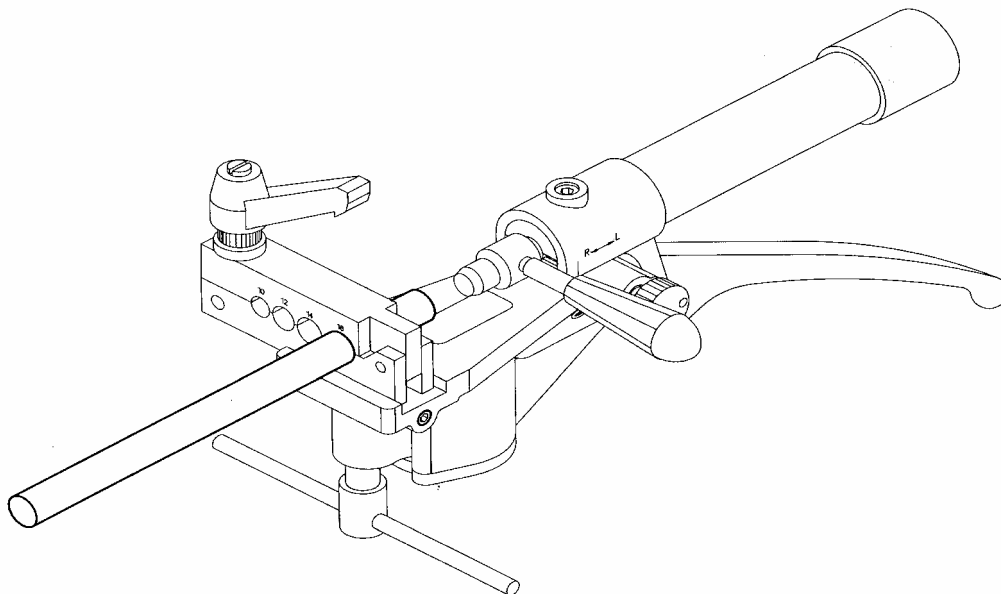
Put the pipe between former and counterformer, and place the pipe so that the centre of the bend must be lined up to the counterformer's laterals. Turn the stopper head on right "L" and actuate the lever until you have the wanted bend.

To come back to the initial operation, turn the stopper head on the left "R" and take the bended pipe off.

3.2 - USE OB/KIT FOR FLARING AND FLANGING



Choose the vice (H) and the punch (L) according to the diameter of the pipe. Put the vice as in the picture and fix it with the pin (N); be careful that the hole of the vice must be lined up to the pump piston where the punch has been placed.

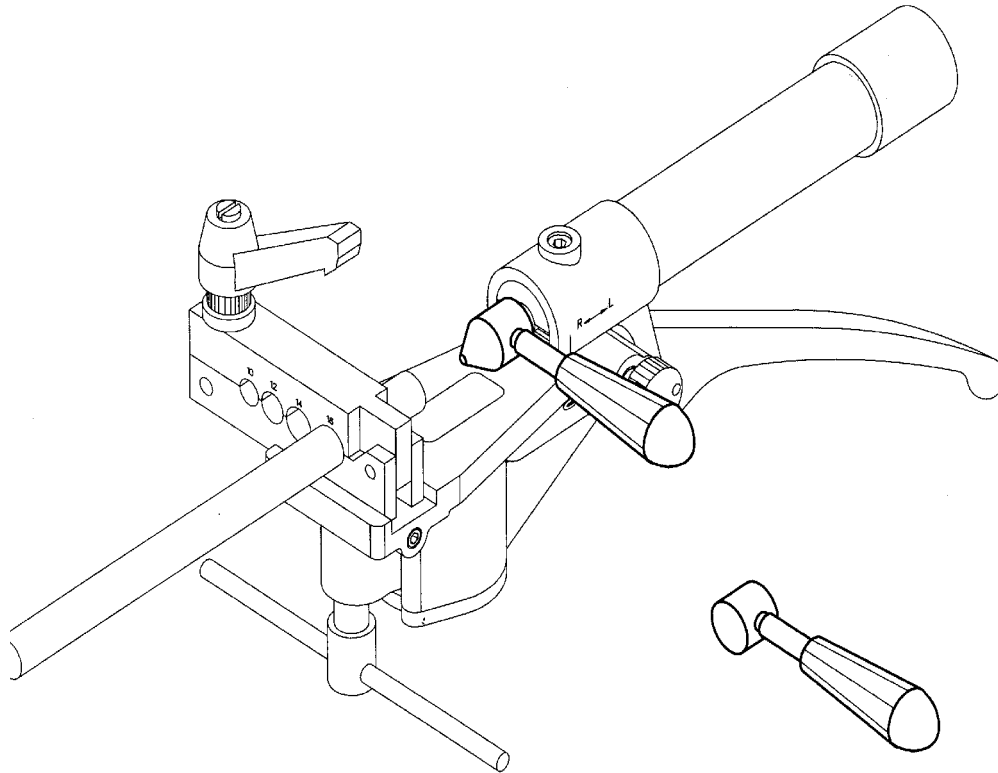


Unscrew the handle placed on the vice and open it to collocate the pipe in the right way. Close the vice; be careful that the pipe must be perfectly tight.

Turn the stopper head on the right "L" and actuate the lever until the end of the run.

To come back to the initial operation turn the stopper head on the left "R" and take off the punch moving up to down and vice versa the lever "M"

3.3 - MOD. OB/KIT FOR NECKINGS



You have the neckings in two phases:

1- Set up the universal tapered punch and turn the stopper head on the right "L" and actuate the lever until you have reached the wanted neckings.

To come back to the initial operation, turn the stopper head on the left "R" and take off the tapered punch

2- Set up the flat punch and repeat the same actions described before.

After the operation, take off the pipe.

3.4 - Wrong use

- Do not use the machine in a different way, that is not described at the paragraph 3.
- Do not use different tools from those described.

3.5 Out of order

3.5.1

You need to disassemble the machine and separate the metallic parts for each kind of material (iron, aluminium, brass, and so on...)

3.5.2

The metallic parts can be sent to the foundry. The oil must be sent to the specialised services for disposal.

4 - Guarantee

Our company guarantee the machine for 24 months after the purchase, and it is limited by those parts with defects of construction recognised by our technical staff. So the buyer has the right to ask for the substitution of the parts, but the delivery cost and the packing must be paid by himself.

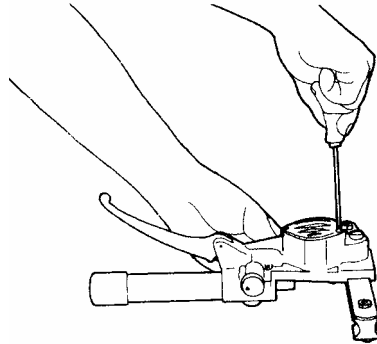
These are the things that the guarantee does not include: tampering or repairs made by someone else, damages caused by falls or wrong use, the lack observation of the maintenance rules and all the parts subject to usury. Anyway, it's not included the substitution of the machine.

Important: the guarantee passes from the purchase and it is valid only if the card is perfectly compiled and sent 10 days after the purchase to the CBC Spa company, plus a copy of the invoice or transport document.

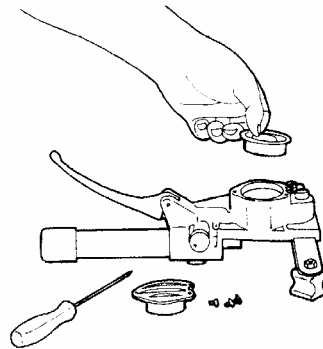
4.1 Maintenance

Please note: the machine can be ONLY repaired by our technical staff.

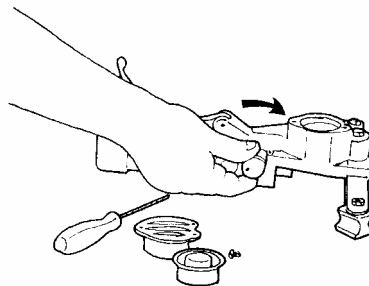
4.2 – INSTRUCTIONS TO ELIMINATE AIR BUBBLES



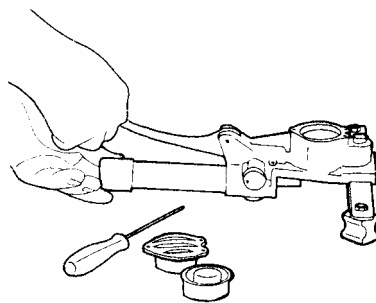
Insert a counterformer to place the pump and unscrew the screws from the tank cap.



Take off the tank cap and the rubber bonnet

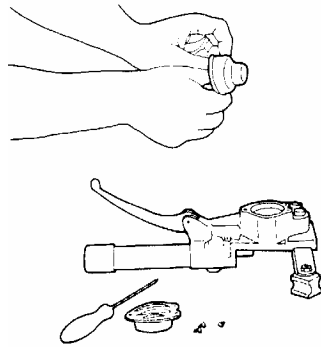


Close the stopper turning on the right side

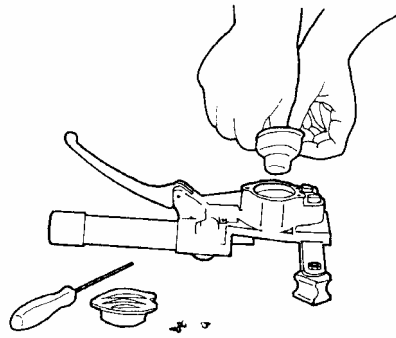


Actuate the pump lever until the complete exit of the piston

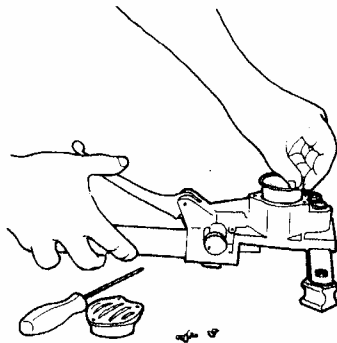
Slacken the stopper to let the piston come back. Repeat the last 3 operations 5 or 6 times, until the oil will have a good flow without air bubbles



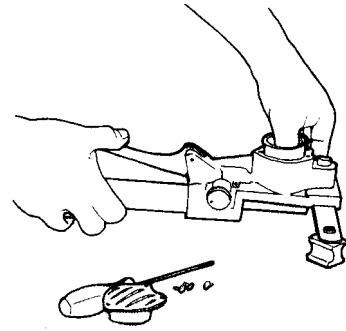
Control that the oil level in the tank is 5/6mm from the tank's side; so pour the rubber bonnet as in the picture (oil type "C 10" cc. 110 more or less)



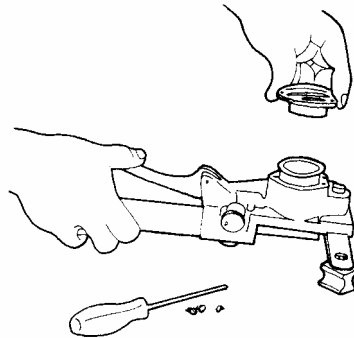
Insert the rubber bonnet



You have to introduce slowly the bonnet into the tank, without the exile of oil and ,at the same time, actuate the pomp lever in order to lower the oil level and put the rubber bonnet inside

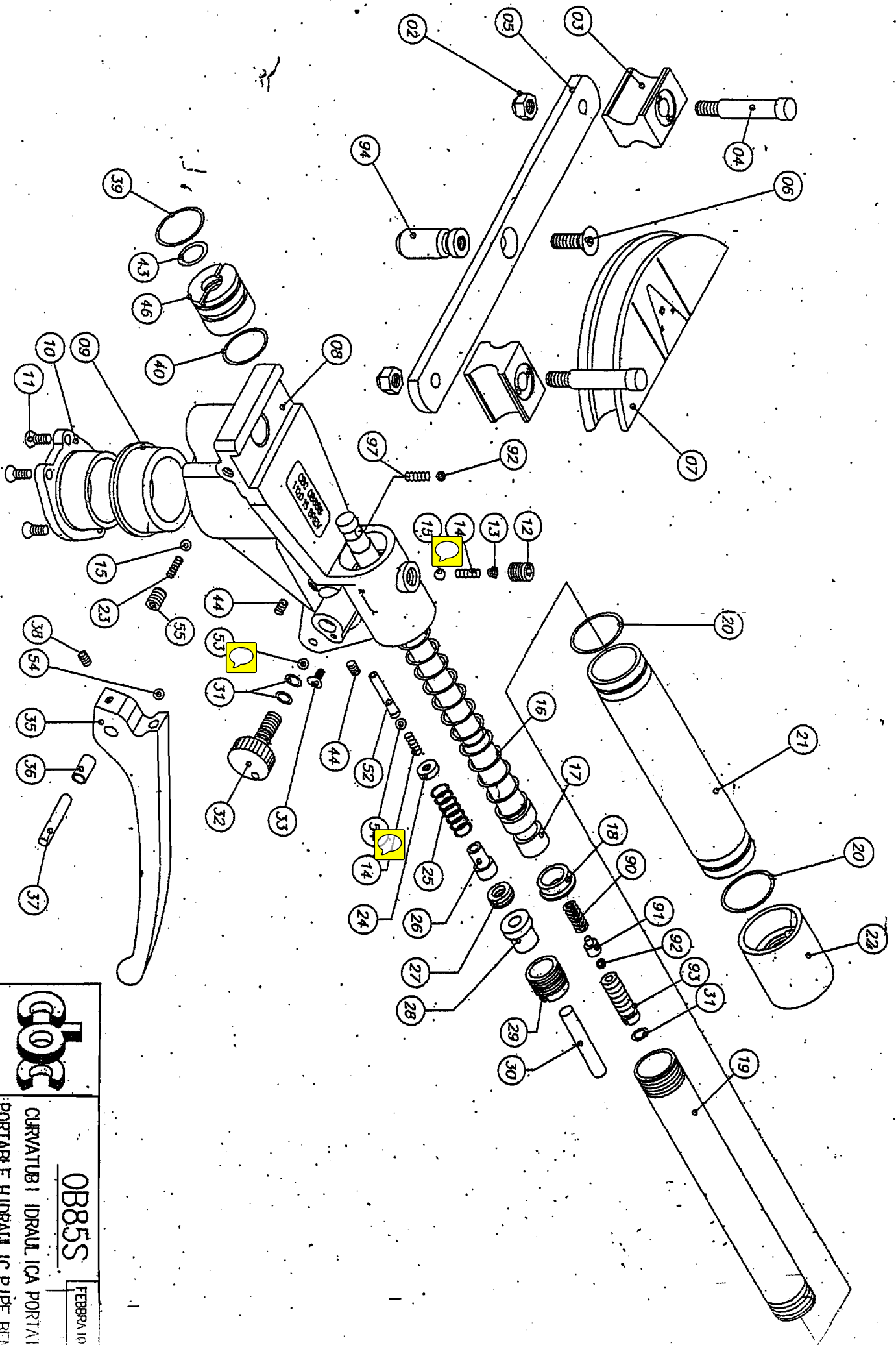


The bonnet must be 10mm (more or less) out of the tank



Put the cap tank on the bonnet, and with a little pressure, let enter the last part of the bonnet. Close the tank cap with the right screws.

NOTE: USE ONLY AN HYDRAULIC OIL 10 DENSITY



OB85S

FEBBRAIO 2010

CURVATUBI IDRAULICA PORTATILE
 PORTABLE HYDRAULIC PIPE BENDER

Part.Nr	Codice	Descrizione	Q.ta'
2	002011	Dado	6
3	112047	Laterale controforma 10/12	2
3	112079	Laterale controforma 14/17	2
3	112021	Laterale controforma 18/22	2
4	595017	Perno per c/forma	2
5	515103	Biella c/forma 10/12	1
5	515060	Biella c/forma 14/17	1
5	515061	Biella c/forma 18/22	1
6	016004	Vite	3
7	112035.1	Forma ø 10	1
7	112036.1	Forma ø 12	1
7	112037.1	Forma ø 14	1
7	112038.1	Forma ø 15	1
7	112039.1	Forma ø 16	1
7	112041.1	Forma ø 18	1
7	112042.1	Forma ø 20	1
7	112043.1	Forma ø 22	1
8	112074	Corpo pompa	1
9	003017	Cuffia serbatoio	1
10	112017	Flangia chiusura serbatoio	1
11	017004	Vite	3
12	006021	Tappo	1
13	595019	Distanziale	1
14	005006	Molla	2
15	001013	Sfera	2
16	005046	Molla	1
17	544054.2	Pistone	1
18	003018	Corteco	1
19	318005	Cilindro	1
20	003137	O-ring	2
21	518003	Impugnatura	1
22	313003	Tappo cilindro	1
23	005004	Molla	1
24	595023	Pastiglia valvola	1
25	005009	Molla	1
26	595020	Boccola	1
27	003020	Guarnizione	1
28	003016	Boccola	1
29	595021	Ghiera di tenuta	1
30	526017	Spina	1
31	003021	O-ring	3
32	595022	Pomolo valvola	1
33	017011	Vite	1
35	112018	Leva azionamento	1
36	018006	Boccola	1
37	018006	Spina	1
38	019037	Grano	1

Part.Nr	Codice	Descrizione	Q.ta'
39	003023	O-ring	1
40	003022	O-ring	1
43	003039	O-ring	1
44	019004	Grano	2
45			
46	315005	Ghiera	1
52	595087	Boccola valvola	1
53	001036	Sfera	1
54	001037	Sfera	1
55	019017	Grano	1
90	005051	Molla valvola	1
91	595275	Perno valvola	1
92	001014	Sfera	2
93	595274	Corpo valvola pistone	1
94	595018	Perno c/forma	3
97	005066	Molla	1