Visual Index

Bender Table (With Locking Casters) for HB632

Sturdy, heavy all steel construction, strongly braced to keep bender, mandrel rod, and mandrel rod stop assembly rigidly aligned. All holes are pre-drilled at factory to accommodate the HB632 bender and rod stop assembly.

DIMENSION: H – 36" W – 30" L – 10'

NOTE: Table is supplied with locking casters for ease of mobility.

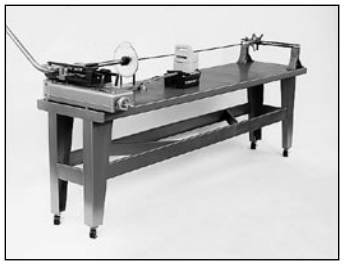

Fig. S32 — Bender Table (equipment not included)

Part No.
520515

Mandrel Bending Components

When bending thin wall tube it may be necessary to insert a mandrel into the tube to prevent excessive distortion or flattening. To accomplish such bending, a Mandrel, Mandrel Rod, and a Mandrel Rod Stop Assembly are required. The Rod Stop Assembly holds the end of the Mandrel Rod in proper alignment with the tube while the Mandrel, which is threaded onto the other end of the Mandel Rod, supports the tube on its I.D., thus preventing tube kinking or flattening during bending.

The following parts are required for mandrel bending with the 412 and 424 bender:

Part Name	Part No.
Mandrel Rod Stop Assembly	**550571**
Stop Assembly Adapter Riser (424 only)	**631154**
Mandrel Rods	See page S18
Mandrel	See page S18

The following parts are required for mandrel bending with the 632 bender:

Part Name	Part No.
Mandrel Rod Stop Assembly	**631141**
Mandrel Rods	See page S18
Mandrel	See page S18

Example:
Tube O.D.: 2"
Wall Thickness: 0.095"
Centerline Radius: 8"

Vertical Axis = $\frac{8"}{2"} = 4$

Horizontal Axis = $\frac{2"}{.095"} \approx 21$

Answer: Plug Mandrel required

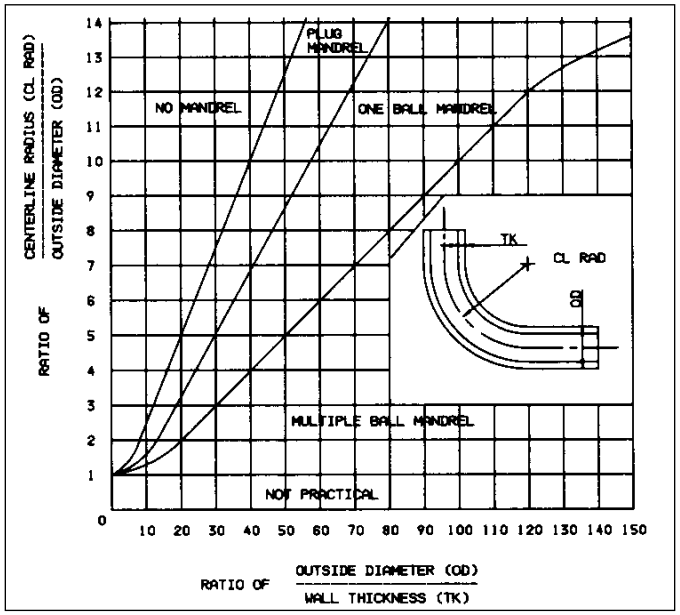

Fig. S33 — Mandrel Graph Chart

Dimensions and pressures for reference only, subject to change.