



MODEL T10050 RIGHT ANGLE IRON BENDER INSTRUCTIONS

⚠ WARNING

Damage to your eyes, face, and hands could result from using this item without proper protective gear, such as safety glasses or a face shield, and gloves.

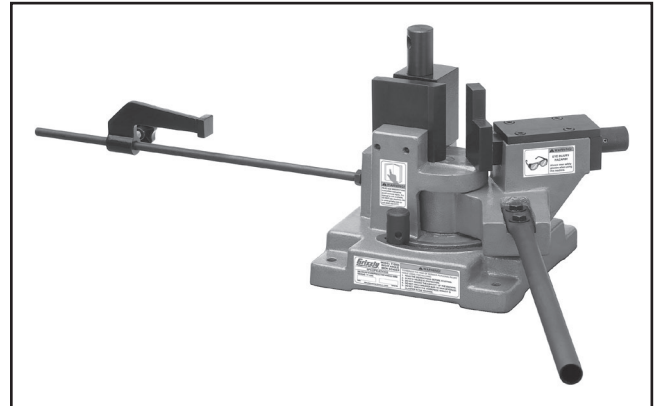
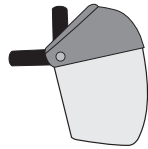


Figure 1. Model T10050.

Inventory (Figure 2)

- A. Bender (not shown)..... 1
- B. Bender Handle 1
- C. Work Stop Rod..... 1
- D. Hex Bolts M10-1.5 x 40 (Handle)..... 2
- E. Flat Washers 10mm (Handle) 2
- F. Work Stop..... 1
- G. Work Stop Knob 1
- H. Hex Nut M12-1.75 (Work Stop Rod) 1

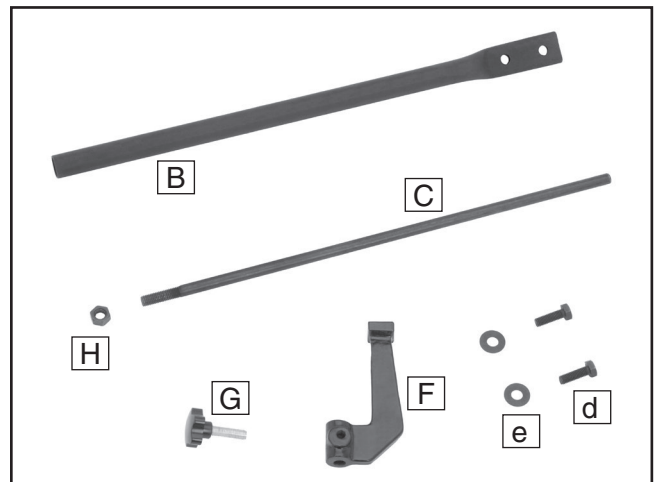


Figure 2. inventory.

Specifications

Maximum Workpiece Thickness..... 3 Ga. ($15/64$ "")
 Maximum Workpiece Width..... 4"
 Machine Weight..... 81 lbs.

If you need help with your new machine, call our Tech Support at: (570) 546-9663.

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Identification

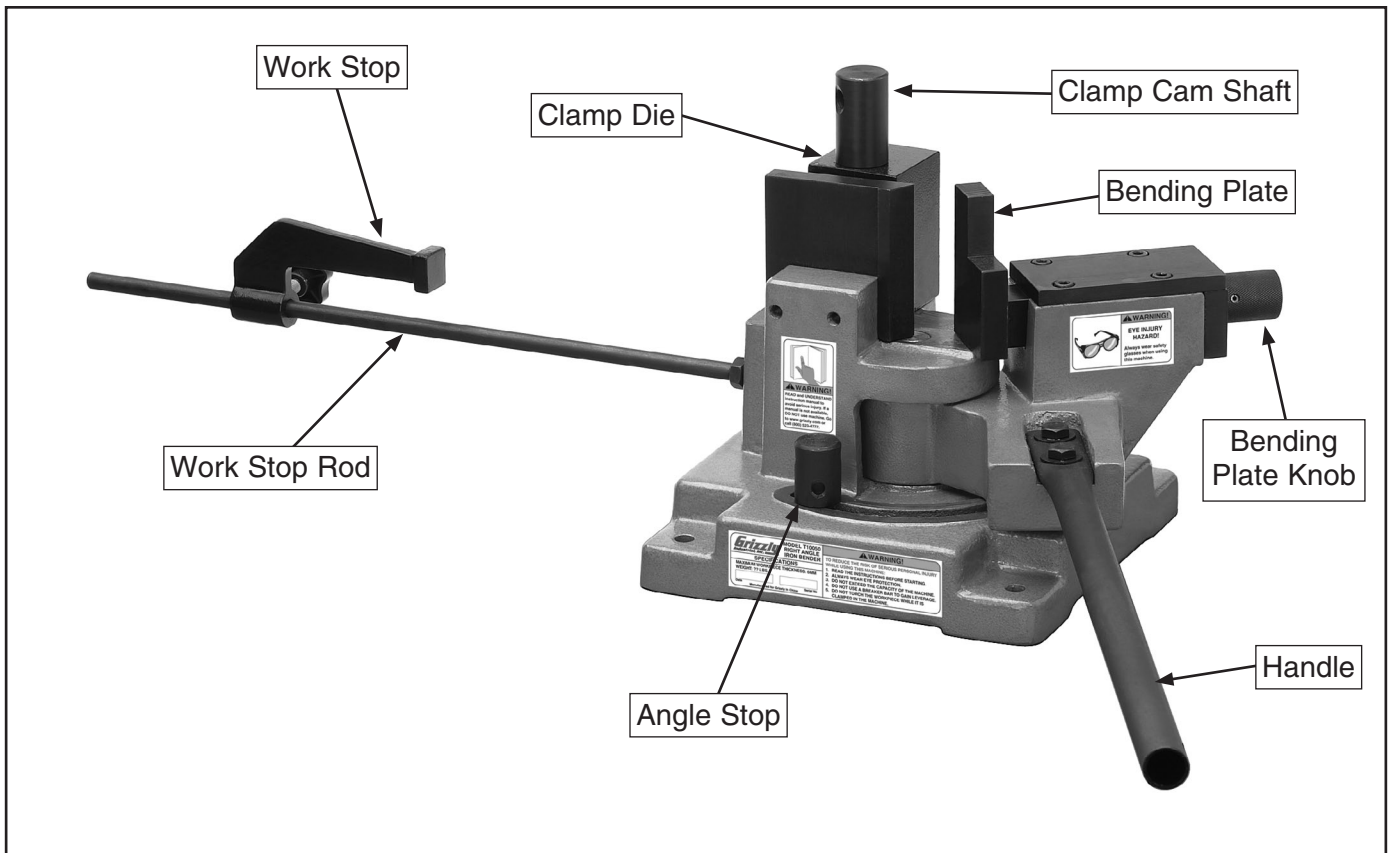


Figure 3. Identification.

Illustration Legend (Figure 4)

Throughout these instructions, diagrams are used to illustrate how the components of the machine are used during the various steps of operation.

Familiarize yourself with the following illustration, its relationship to the machine, and the symbols used in it before proceeding through these instructions.

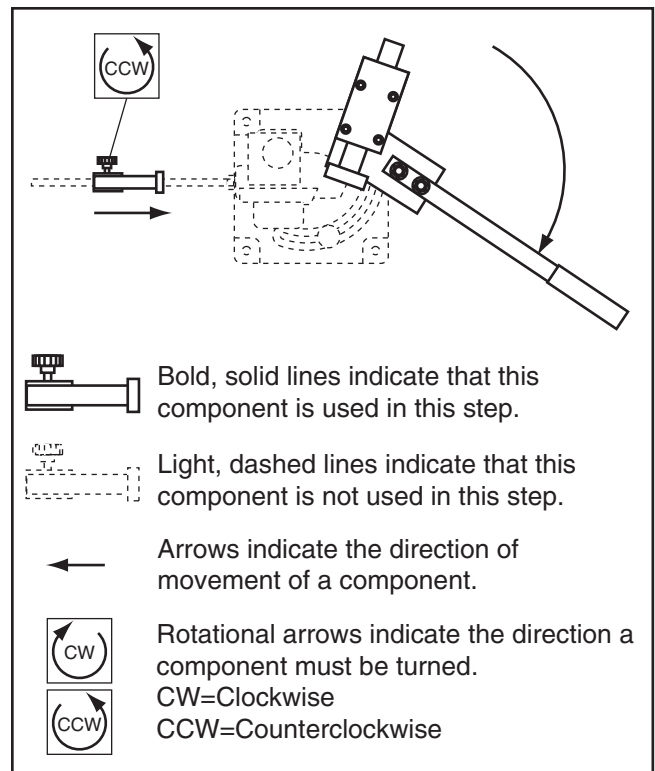


Figure 4. Illustration Legend.



Assembly

The Model T10050 requires only minimal assembly before use.

To assemble the machine:

1. Connect the bender handle to the machine with the M10-1.5 x 40 hex bolts and 10mm flat washers (**Figure 5**).

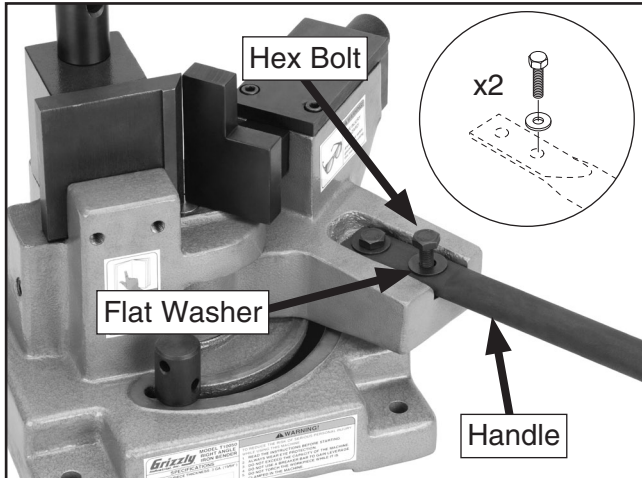


Figure 5. Attaching handle.

2. Insert the stop rod with the M12-1.75 hex nut into the base. Tighten the hex nut against the base to secure it (**Figure 6**).

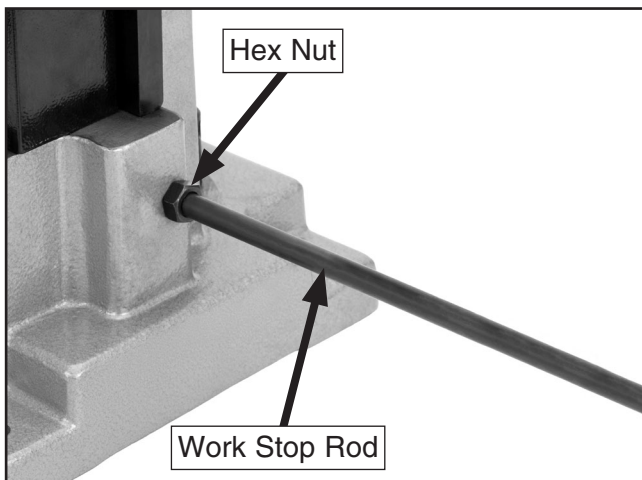


Figure 6. Attaching work stop rod.

3. Thread the work stop knob into the work stop, then slide the work stop onto the work stop rod (**Figure 7**).

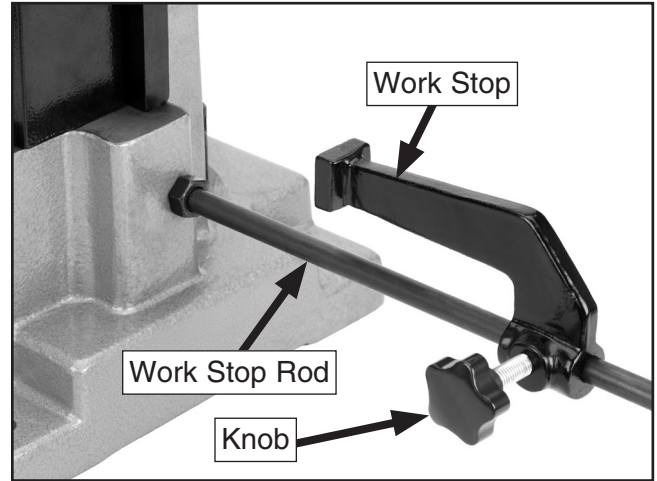


Figure 7. Work stop.

Mounting

Once you have confirmed that your machine is assembled and functioning properly, mount it to a workbench through the holes in the base. Be sure the workbench will remain stable when bending force is applied to the machine. If necessary, anchor the workbench to a wall or the floor to provide the necessary stability.

The strongest mounting option is a "Through Mount" where holes are drilled all the way through the workbench, and hex bolts, washers, and hex nuts are used to secure the machine to the workbench.

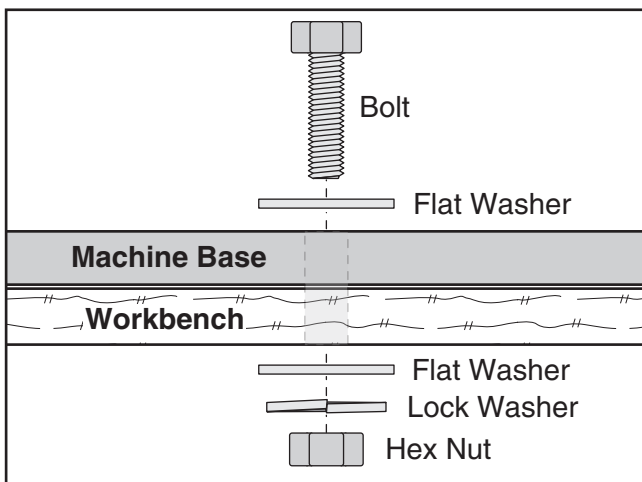


Figure 8. Example of a through mount setup.

Another option for mounting is a "Direct Mount" where the machine is simply secured to the workbench with a lag screw.

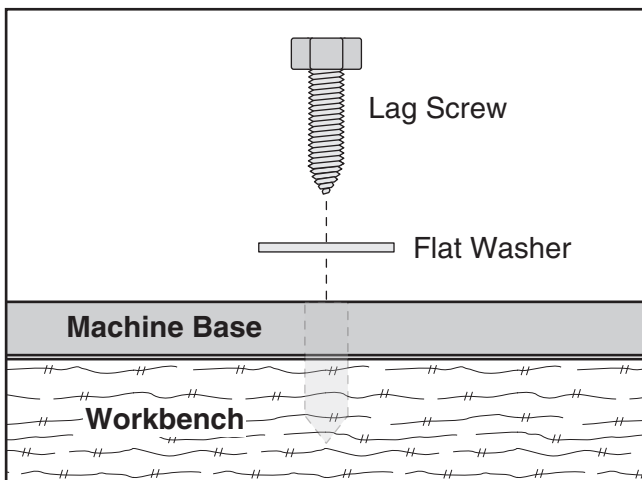


Figure 9. Example of a direct mount setup.

Operations

Creating Bends

1. Lift the clamp cam shaft to release the clamp die. Rotate the clamp die as necessary to accommodate the thickness of your work-piece, then slide the clamp cam shaft back into the base (Figures 10 & 11).

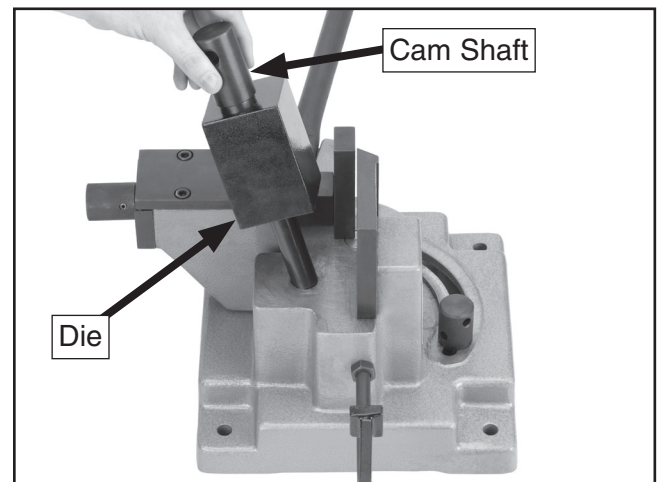


Figure 10. Lifting clamp cam shaft and die.

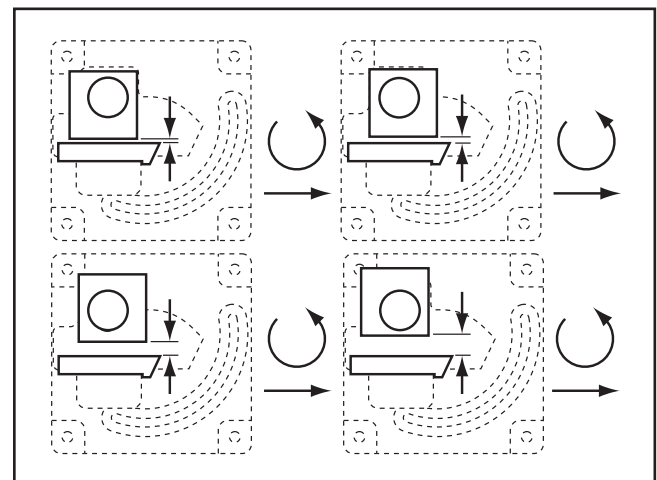


Figure 11. Clamp die positions.

- Place the workpiece into the clamp and adjust the workpiece position as needed. Rotate the clamp cam shaft to clamp the workpiece (**Figure 12**).

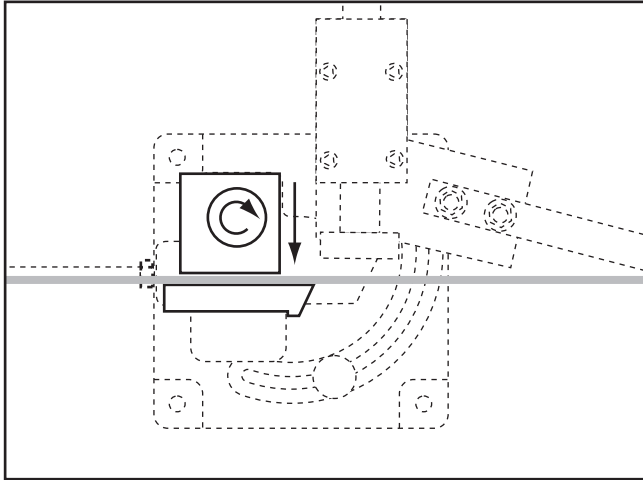


Figure 12. Clamping workpiece.

—If the clamp die does not move far enough to fully clamp the workpiece, repeat **Steps 1 & 2**.

- Adjust the bending plate to support the workpiece while bending (**Figure 13**).

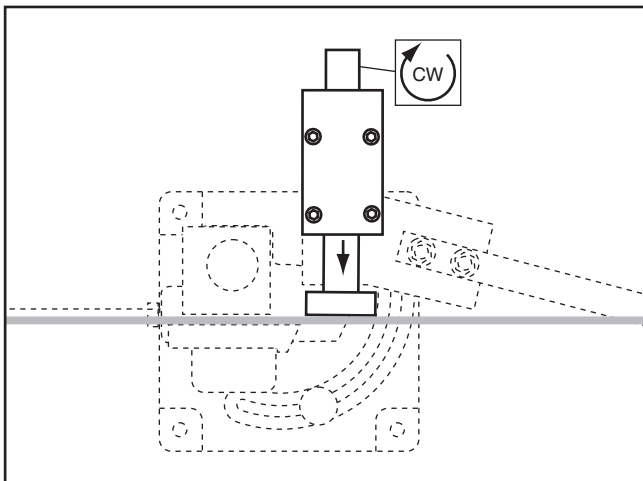


Figure 13. Tightening bending plate.

- Use the handle to bend the workpiece to the desired angle (**Figure 14**).

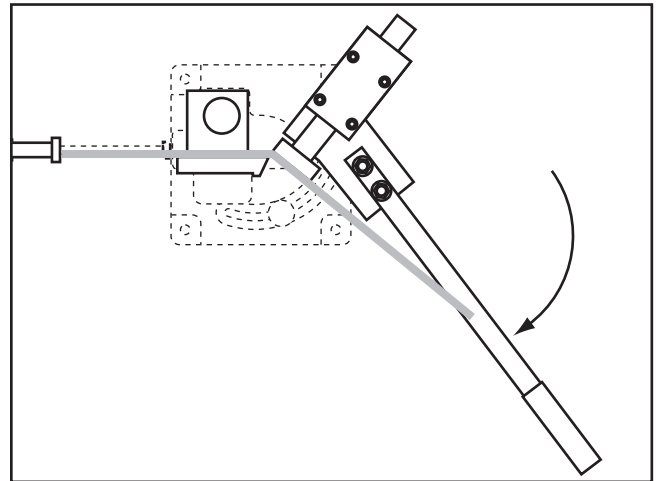


Figure 14. Bending workpiece.

- Loosen the bending plate and clamp cam shaft to release the workpiece (**Figure 15**).

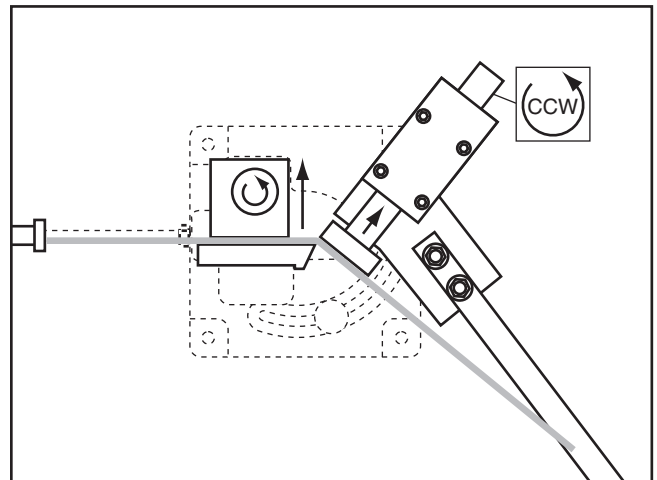


Figure 15. Releasing workpiece.

NOTICE

Use the machine only as it is intended to be used. Adding cheater bars or other methods of increasing leverage may damage the machine and will void the warranty.

Repetitive Bends

To ensure consistent and accurate bends when performing multiple, identical operations, use the work stop and angle stop.

To use the work stop and angle stop:

1. Place the workpiece in the machine as needed, then slide the work stop against the end of the workpiece. Tighten the work stop knob (Figure 16).

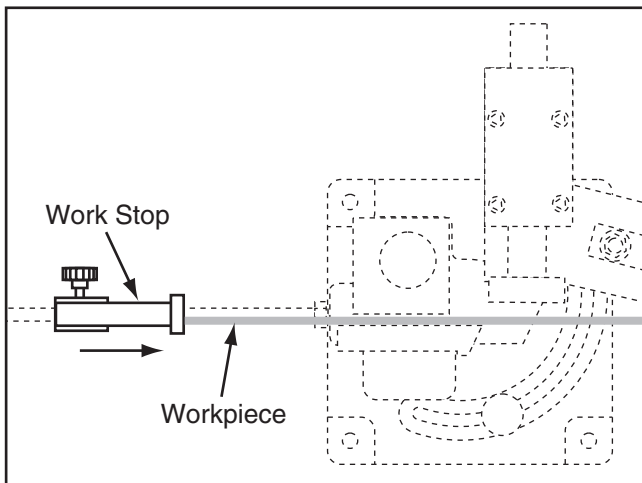


Figure 16. Using work stop.

2. Bend the workpiece to the desired angle, then slide the angle stop against the bender base. Turn the angle stop to lock it in position (Figure 17).

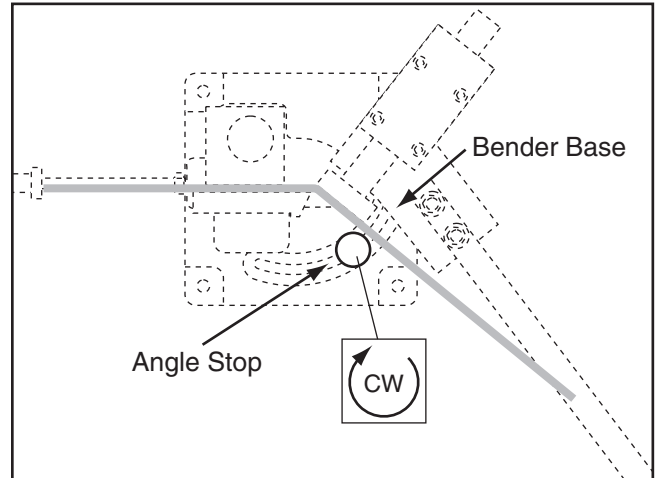
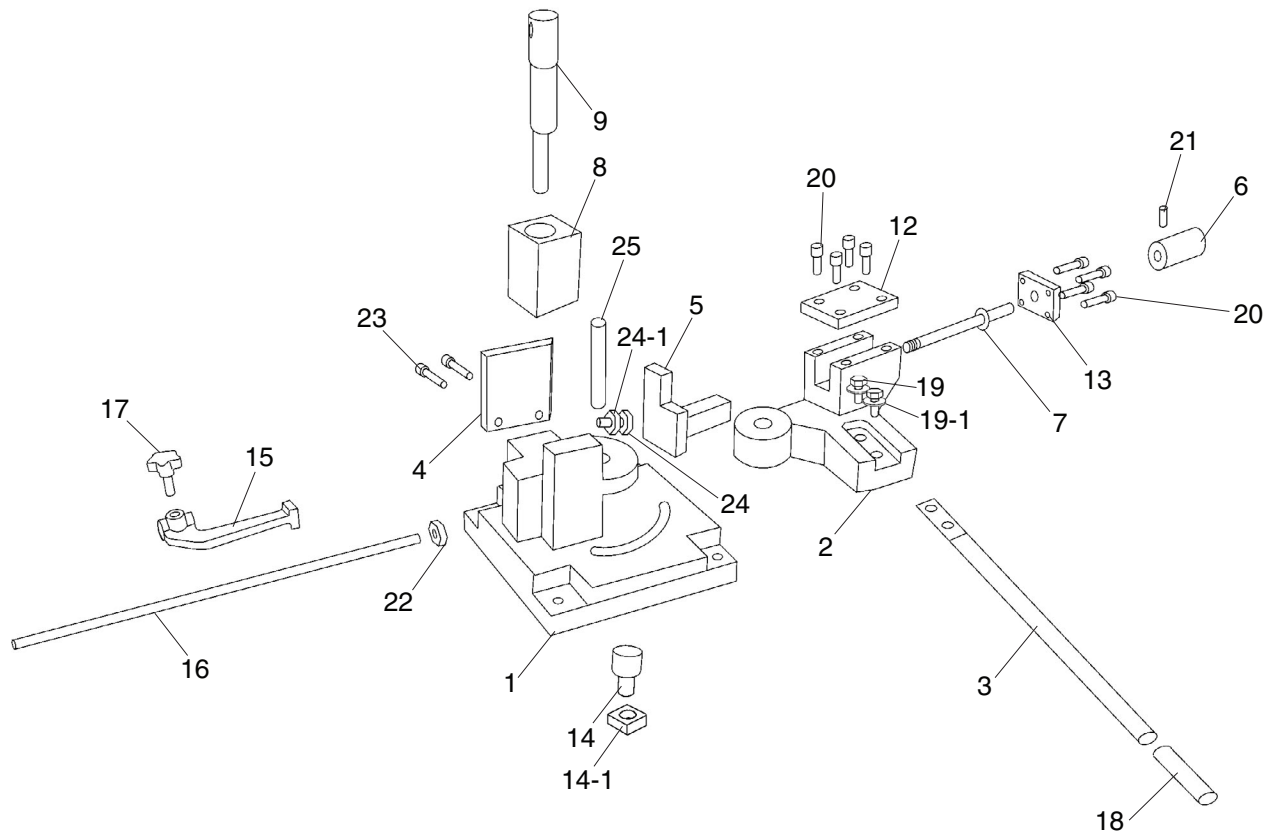


Figure 17. Using angle stop.

3. With each new workpiece, place the workpiece against the work stop, clamp it, then bend it until the moving bender base contacts the angle stop.

Parts Breakdown & List



REF	PART #	DESCRIPTION
1	PT10050001	BODY
2	PT10050002	CRANK
3	PT10050003	HANDLE
4	PT10050004	STATIONARY JAW
5	PT10050005	BENDING PLATE
6	PT10050006	BENDING PLATE KNOB
7	PT10050007	BENDING PLATE LEADSCREW
8	PT10050008	CLAMP DIE
9	PT10050009	CLAMP CAM SHAFT
12	PT10050012	COVER PLATE
13	PT10050013	END PLATE
14	PT10050014	ANGLE STOP
14-1	PSN05M	SQUARE NUT M12-1.75

REF	PART #	DESCRIPTION
15	PT10050015	WORK STOP
16	PT10050016	WORK STOP ROD
17	PSW03-1	KNOB M10-1.5 x 35
18	PT10050018	PLASTIC GRIP
19	PB31M	HEX BOLT M10-1.5 X 40
19-1	PW04M	FLAT WASHER 10MM
20	PSB14M	CAP SCREW M8-1.25 X 20
21	PRP08M	ROLL PIN 6 X 30
22	PN09M	HEX NUT M12-1.75
23	PSB64M	CAP SCREW M10-1.5 X 25
24	PB14M	HEX BOLT M10-1.5 X 35
24-1	PN02M	HEX NUT M10-1.5
25	PT10050025	PIVOT PIN



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