

Table of Contents

Table of Contents	3
Course Objectives	4
Related Publications	4
Course Agenda.....	5
Lesson 1 Objectives	6
Tube Preparation.....	7
Tube Cutter	7
Hacksaw and Tube Sawing Guide	8
Tube Deburring	8
Hand Tube Bender Components	10
Vise Clamp Block.....	10
Straight Tube Length Mark.....	11
Hand Tube Bender Operating Instructions	12
Long handle.....	12
Positioning the Tube for Changes in Direction.....	14
Making Bends 90° or Less.....	15
Springback	16
Making Bends Greater than 90°	17
Reverse Bends	19
Bend Terminology	20
Tube Bending Variables	22
Marks Used in Bend Layout	24
Reference Mark	24
Bend Marks.....	24
Directional Marks	25
Lesson 2 Objectives	26
Bend Layout Using the Measure-Bend Method	27
Bending Exercises.....	29
Exercise 1	29
Solution to Exercise 1 Using the Measure-Bend Method	30
45° Bend at P2:.....	31
45° Bend at P3:.....	33
180° Bend at P4:.....	34
End of Run at P5:.....	35



Tube System Design Considerations	36
Tube Bending Defects	37
Understanding the Relationship Between 45° and 90° Angles	38
Offsets	39
Transitional Offsets	40
Minimum Leg Lengths Between Common Bends – Hand Tube Bender.....	41
Lesson 3 Objectives	44

Course Objectives

Upon completion of this class, you should be able to:

- Explain the basic concepts of the theory and practice of tube bending
- Practice the measure-bend method through a variety of hands-on exercises using the Swagelok ® hand tube bender
- Demonstrate essential tube bending concepts necessary to complete quality 45°, 90°, 180° and offset bends

Related Publications

- Swagelok Hand Tube Bender Manual (MS-14-43)



Course Agenda

Introduction

- Introduction
- Bender components
- Bending terminology
- Types of bends

Methods

- Bending methods
- Bend offsets

Exercise

- Tube bending exercise



Lesson 1 Objectives

Introduction

- Introduction
- Bending terminology
- Bender components
- Types of bends

- Discuss proper steps for tube preparation
- Identify the components of the Swagelok hand tube bender
- Explain the purpose of the three marks used in tube bending
- Bend tubing with the correct bend angle made in the correct location
- Define bending terminology
- Identify potential bend defects

