



Model 273-15

Hydraulic Coupon Bending Machine



**SAWYER MFG. COMPANY**  
Manufacturers of Pipeline Equipment

## PRODUCT WARRANTY

All products manufactured by or for Sawyer Manufacturing Company are guaranteed against defects due to faulty workmanship or materials for twelve months from the date of purchase.

This guarantee is limited to the repair or replacement of any parts found to be defective, and no other liability, expressed, implied or contingent is assumed.

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## **Operating Instructions**

### **Model 273-15 Hydraulic Coupon Bending Machine**

#### **I. Set Up**

- a. Lay machine horizontally with the serial plate facing up, on a flat, level and substantial surface.
- b. Connect the hydraulic hose from the pump to the cylinder on the machine. Take care to clean connections and make sure connection is hand tight.
- c. Valve on pump (manual or power) will determine pressure or release of machine. To apply pressure to the machine:
  1. Manual Pump: turn screw valve counter clockwise until snug.
  2. To release, turn screw valve counter clockwise two or three turns to release pressure.

Note: Machine will operate in any position. If vertical operation is desired, set machine on the cylinder base then attach to a vertical support.

#### **II. Guided Bend Test:**

- a. Open needle valve and retract machine.
- b. Close needle valve.
- c. Hold coupon. Do not put hand or fingers between coupon or die and plunger.
- d. Actuate pump, pressurize until desired bend is achieved.
- e. Open valve to retract.

Note: It is possible bending coupon may jam die and plunger. To release, open valve, then pry die and plunger apart.

When using this equipment be sure that it is positioned securely and that the operator is wearing protective clothing, goggles and gloves. **DO NOT** place fingers or hands around working parts of the machine while operating.

**EXERCISE CAUTION.**