



Hydraulic Tube Bender Model HB632

Hydraulic power does the work in bending tube of all materials in sizes from 6 (3/8" O.D.) through size 32 (2" O.D.), 10mm through 50mm, with wall thicknesses as great as .188 for annealed steel, and pipe sizes from 3/8" through 1-1/2". See page S7 for wall thickness capabilities. The radius block, around which the tube is bent, is driven by a roller chain and sprocket powered by a cylinder and a separate hydraulic power unit.

Maximum bend angle is 180° with radii from 1 1/4" to 8". Close second bends can be performed in either direction. An adjustable stop controls the degree of bend to a maximum of 180° and is graduated in 1° increments. After the bend is completed and pressure is released, a spring returns the clamp arm to the zero starting position.

The clamp vise arm features a quick release speed screw for positioning the required clamp block. Each size of tube requires the proper sized radius block, clamp block and slide block.

Written instructions, a DVD and Bulletin 4391-B26 are included with each bender.

HB632 radius blocks, slide blocks and clamp blocks will work with the following benders as well: 624, 824, 832 and 848.

NOTE: For size 28 (1 3/4" O.D. tube) through 32 (2" O.D. tube) radius blocks, an adapter plate is required.

DIMENSIONS: L – 40" W – 11" H – 12"

COMPONENTS REQUIRED

Minimum components required are a Model HB632 Bender, hose assembly, hydraulic pump and a radius, slide and clamp block which match the tube/pipe O.D. to be bent.

Part Name	Part No.
Hydraulic Bender Model HB632 (without pump)	631050
Hydraulic Pump (10,000 psi, 110V AC)	900085
High Flow Hydraulic Pump (10,000 psi, 110V)	974691
Hose Assembly (3' long)	910004

One each of the following is required per tube O.D.:
Radius Block, Clamp Block, Slide Block.

Radius Block..... See [pages S13 – S15](#)

INCH TUBE SIZES

Clamp Block (for -6)	864266
Clamp Block (for -8, -12, -16, -24)	631092
Clamp Block (for -10, -14, -18, -20)	631093
Clamp Block (for -28)	027418-28
Clamp Block (for -32)	027418-32
Slide Block (for -6)	864276
Slide Block (for -8, -12, -16, -24)	520516
Slide Block (for -10, -14, -18, -20)	520518
Slide Block (for -28)	631063
Slide Block (for -32)	631066

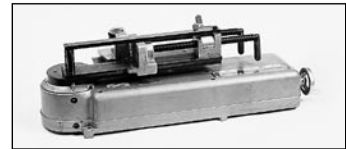


Fig. S23 — HB632



Fig. S24 — 900085 Pump



Fig. S25 — High Flow Pump



Fig. S26 — Clamp Block



Fig. S27 — Slide Block

Dimensions and pressures for reference only, subject to change.