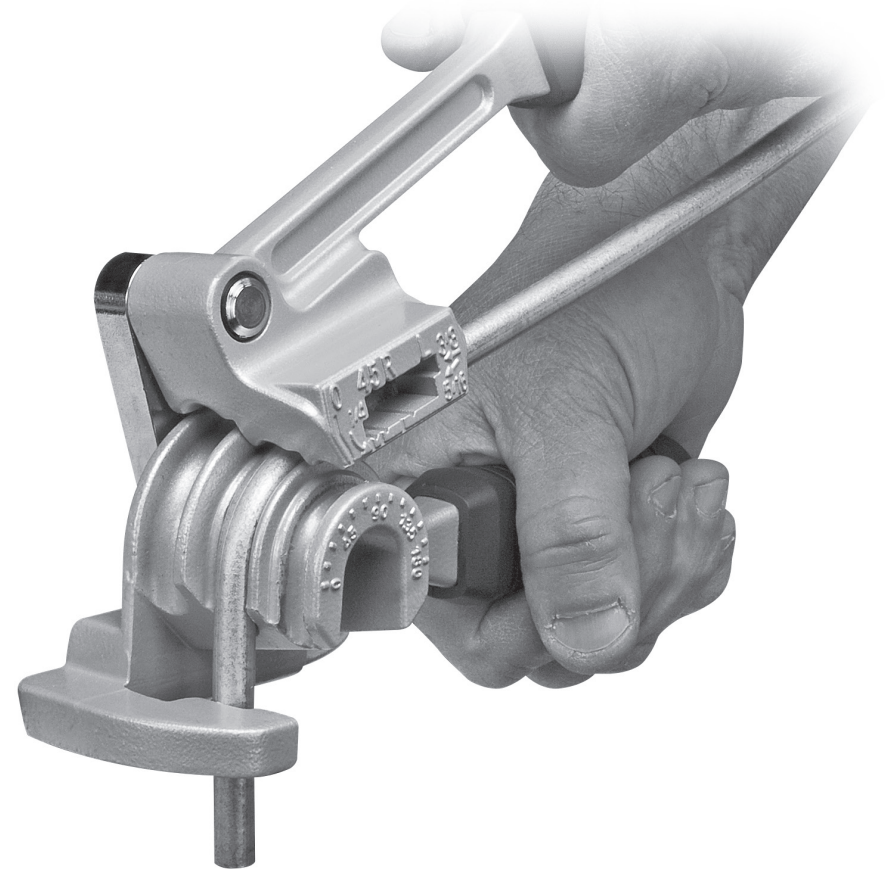


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Part #12435

# 180° Tubing Bender Instructions



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If you have any questions about the use of this product, please contact  
The Eastwood Technical Assistance Service Department:  
**1-866-759-2131 email: [techelp@eastwood.com](mailto:techelp@eastwood.com)**

**The Eastwood Company**

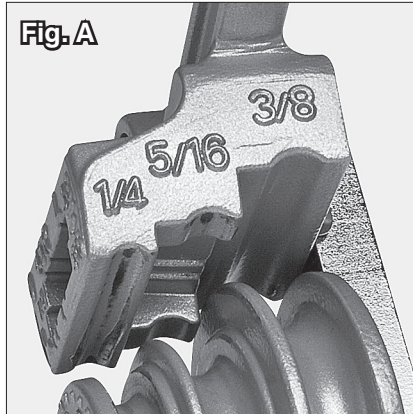
263 Shoemaker Road, Pottstown, PA 19464, USA  
US and Canada: 1-800-345-1178 Outside US: 610-718-8335  
fax: 610-323-6268 [www.eastwood.com](http://www.eastwood.com)

*Instruction Manual #12435Q - Rev. 2/10*

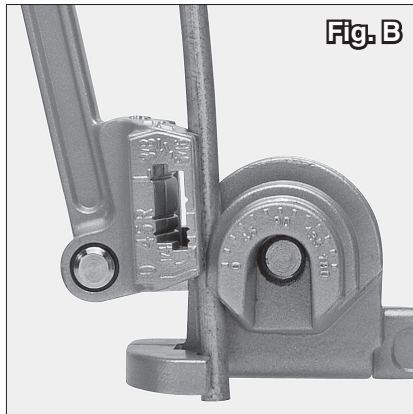
Your Eastwood 180° Tubing Bender is a high quality, precision tool capable of creating accurate, smooth, kink-free bends up to 180°. Form lines for brake, transmission, fuel and other automotive applications in annealed aluminum, steel, stainless steel and copper tubing, in sizes from 3/16" to 3/8", left and right handed.

# Operation

**1)** Place the tube in the appropriate sized groove in the Stationary Arm matching the tubing size you are planning to form. (Note: 3/16" tubing is done in the 1/4" groove). Fig A.

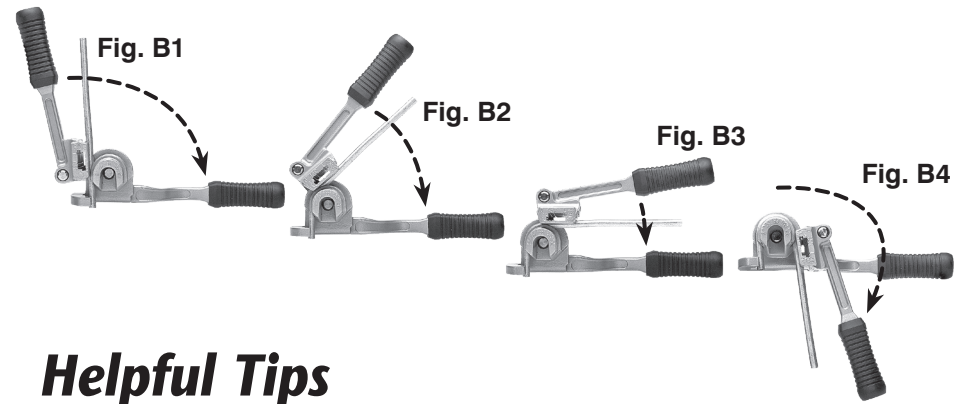
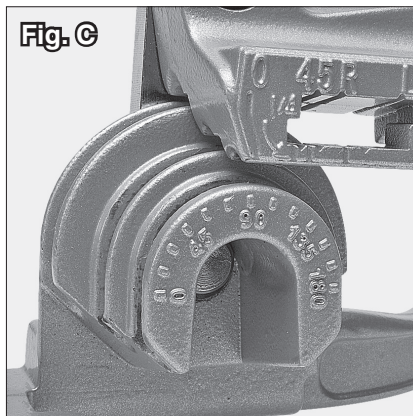


**2)** The tube must be supported by the Stop Edge of the Stationary Arm (Fig. B). Align the 0° marks on the Stationary Arm and Rotating Arm (Fig. B1-B4) and gently while keeping a downward pressure on the tubing, pull the Rotating Arm around until the "0" of the Rotating Arm aligns with the desired ° mark for a maximum of 180°.



**3)** Turn the Rotating Arm out and away from the Stationary Arm and remove formed tubing.

**4)** The gauge on the moveable arm (Fig C) is designed to indicate where the bend will begin as measured from a user defined location beyond the Stop Edge. Note that there are separate markings for 1/4", 3/16" & 3/8" as well as "L" for left and "R" for right. This feature is particularly useful when creating multiple bends in a section of tubing and to utilize it, simply measure back from the end of your previous bend and place a mark on the tubing where you want your next bend to start then align that mark with the appropriate tubing size indicating notch and depending on whether your previous bend is to the Right or Left, use the corresponding notch. Complete your bend as indicated in step 2.



## Helpful Tips

- This tool is designed to gently and accurately form a radius in a piece of line tubing. Softer metals such as aluminum and copper tubing can be formed with minimal effort while carbon and stainless steel will require greater effort to achieve results. Thicker walled tubing will also require more effort than thinner walled material. Use of a small amount of anti-seize lubricant applied to the grooved tubing contact areas of the tool will greatly ease the process particularly with stainless.
- If your bends are to be near the end of a length of tubing, it is usually best to create your flared ends before making bends as the bends may not allow the tubing to fit within the flaring tool.
- If the section of line to be formed requires multiple bends in variable directions, you may want to pre-bend a pattern piece out of mild steel welding rod or wire then using that as a guide, create your formed line.

Tubing Size	Approximate Minimum Formable Radius
3/16" and 1/4"	1/2"
5/16"	3/4"
3/8"	1"

## Other Eastwood Line-Forming Items

- 49074 Brake Forming Pliers for smaller bends and adjustments.
- 25304 Eastwood Double/Single Flaring Tool for accurate and flawless flares in a wide range of tubing.
- Eastwood also offers a complete line of line tubing and fitting kits in a variety of sizes and materials.