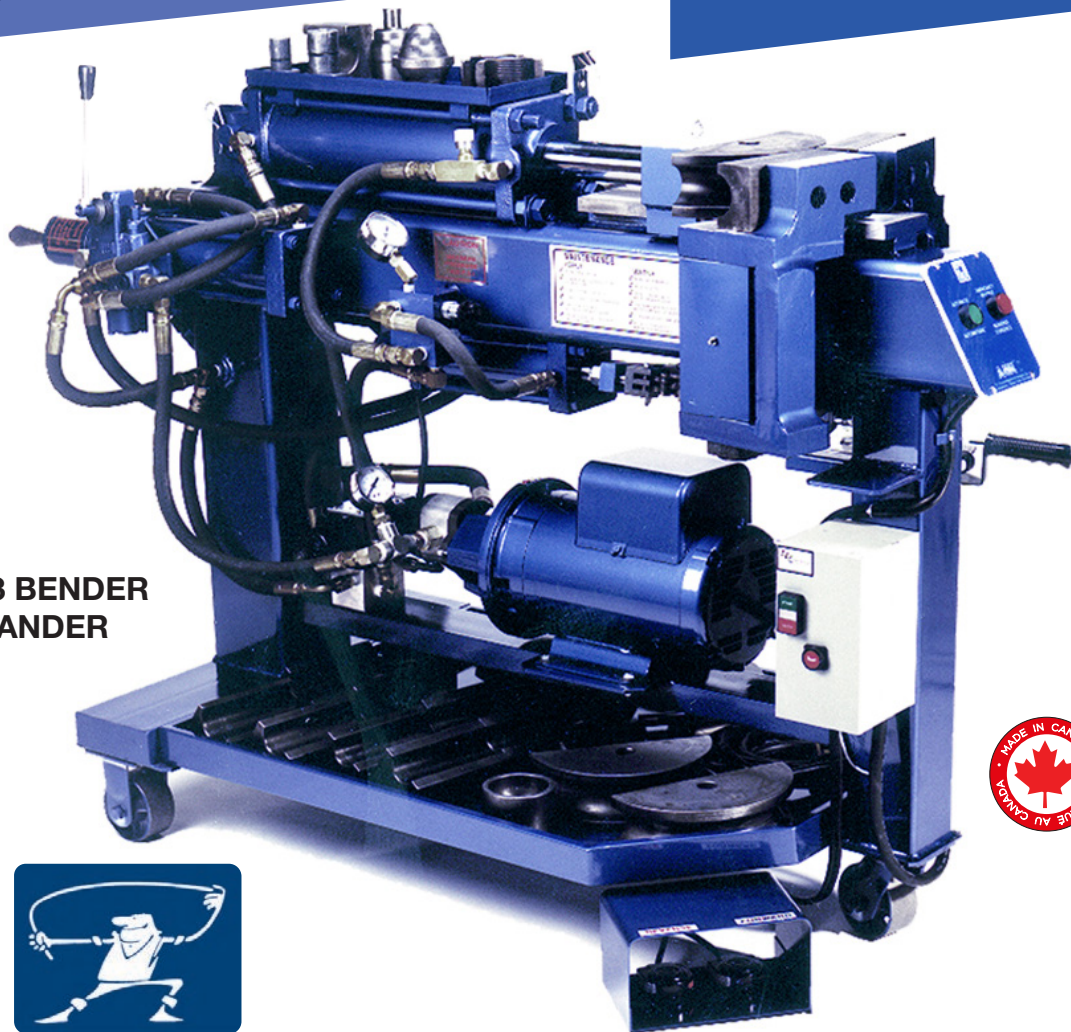


**BB-000153 Bender Plus Expander** is a top-of-the-line fully automatic tube bender, designed for high-volume, high-profit operation. Rugged tubular steel frame and proven design stand up to the toughest jobs. Equipped with two expanders, Hydra-Sizer and Swager, on separate hydraulic cylinders to let the operator maintain two different set-ups without changing tooling.

# BB-000153 BENDER PLUS EXPANDER

**BB-000153 BENDER  
PLUS EXPANDER**



*Blue Boy*



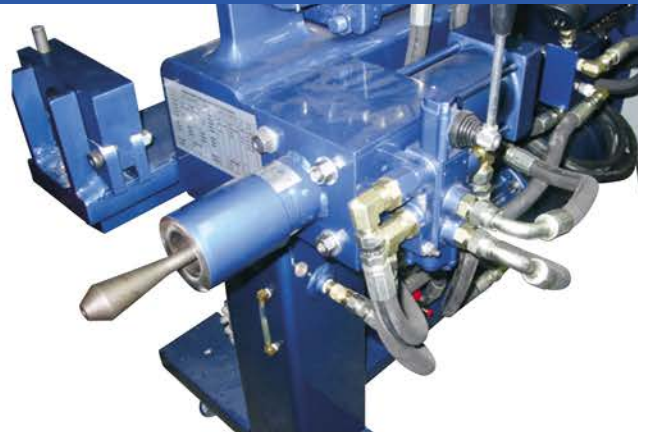


## Gripper Clamp Expander



The unique gripper clamp feature two-piece collars with double-tapered walls to eliminate pipe slippage during expansion and reduction operations. The greater the force exerted on the tube, the tighter the grip is. This unit is designed for use with solid dies to perform many different forming operations, slip fits, domes, flares, ball joints, flanges and reductions.

## Hydra-Sizer



The Hydra-sizer provides rapid set-up time and high degree of accuracy for both I.D. and O.D. expansions including slip fits, flare, inner flaring with segment type tooling. This unit can expand muffler nipples and works closer to bend than the expander. You merely snap on the proper tooling segment set, dial in the desired dimensions on the micrometer-type barrel, which is calibrated in 1/64" insert and jog the hydraulic control handle to complete the expansions.

### Flaring 90°



### Expanding



### Ball joints



### Flanging 45° 90°



## Features

- | Hydra-sizing expander
- | Gripper clam expander
- | Back gate cylinder
- | 3" bending capacity
- | Standard tooling: BT-02, ST-02, ST-03, HST-07
- | Optional tooling: BT-03, RT-01, HT-04, HTS-09, HTS-11

## Specifications

- | Motor and pump: 5hp 3gpm. single or three phase
- | Export: 50 Hz, 3-phase avail.
- | Bending Capacity: 3/4" - 3" (19mm - 76.2mm)
- | Swaging Capacity: 3/4" - 3" (19mm - 76.2mm)
- | Hydra-Sizing Capacity: 1 1/4" - 6" (31.8mm - 152.4mm)