

INSTRUCTIONS FOR USING THE (4021-01) AL-200-H RAIL BENDER

SETTING

- (A) Place rail bender frame on rail, blocking to horizontal position according to height of rail with hook of frame over head of rail, rotating frame to make contact with side of rail at bearing point farthest away from ram position.
- (B) Place ram in position with rocker shoe on bottom of ram engaging head of rail. Align vee-slotted plug with recessed vee in bender frame arm. Angle bottom (shoe end) of ram toward center hook of frame, to allow for jack rocking.
- (C) ATTACH SAFETY CHAIN PROVIDED, attaching grab hook to base "V" extension.

OPERATION

- (A) With release valve on pump closed, operate pump slowly, NOT EXCEEDING 40 STROKES PER MINUTE until desired bend in rail is obtained, bending beyond desired radius to allow for back spring in rail after pressure is released.
- (B) To disengage from rail after bending operation, open release valve on hydraulic pump which will allow removal of bender from the rail. Use flat end of pump handle to pry ram away from frame, if necessary. **(NOTE: Do not open release valve all the way when disengaging hydraulic pump, only open enough to retract the ram.)**

CAUTIONS

1. Do not use on rails heavier than bender is rated for.
2. Check bender each time before use for damage or abnormal wear.
3. Do not use to bend any object other than standard "T" rail. Do not bend pipe or special section rail. Do not bend heat-treated rail.
4. Do not exceed 40 strokes a minute on hydraulic pump or journal jack when bending.
5. Operator and bystanders must stand clear of rail when bending.
6. Do not use any other handle for hydraulic pump or jack than that furnished. Never use an extension on handle for greater leverage.
7. Rail temperature should be 70 to 80 degrees Fahrenheit before attempting to bend it.
8. Do not use electric, gasoline or other powered pumps with Aldon Rail Benders.
9. On AL-200-H Rail Benders, safety chain must always be used to secure ram or jack to bender frame. **Do not bend rail** if hydraulic pump or jack is not secured to frame by proper chain.
10. If you need replacement parts or need to return a damaged pump or jack, contact the Aldon Company before doing so.



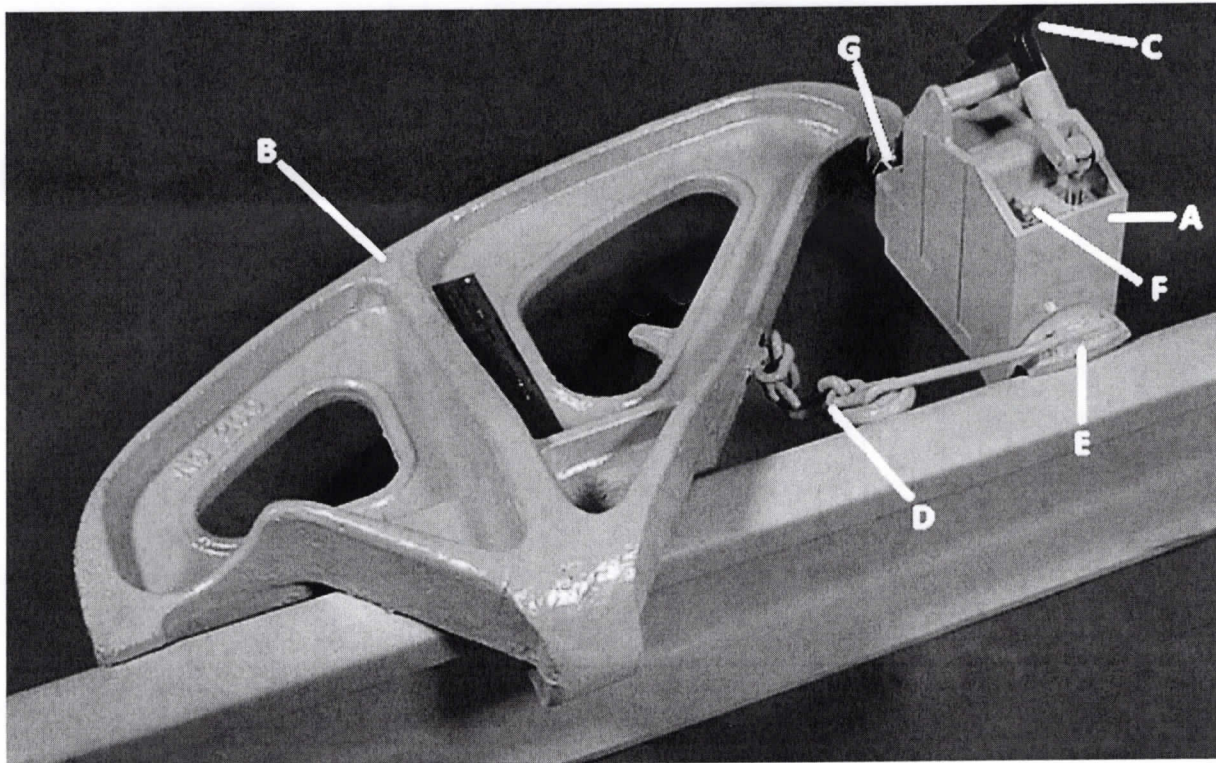
Aldon Company, Inc. | 3410 Sunset Avenue | Waukegan, Illinois 60087

PH. 847.623.8800 | FX. 847.623.6139
www.aldonco.com | e-rail@aldonco.com

4021-01 AL-200-H Hydraulic Rail Bender

Parts Diagram

- A. Hydraulic Pump
- B. Bender Frame
- C. Handle
- D. Safety Chain W/Hook
- E. Shoe (Part of Pump)
- F. Release Valve
- G. Ram



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