



*WELD*

*COUPON BENDER:*

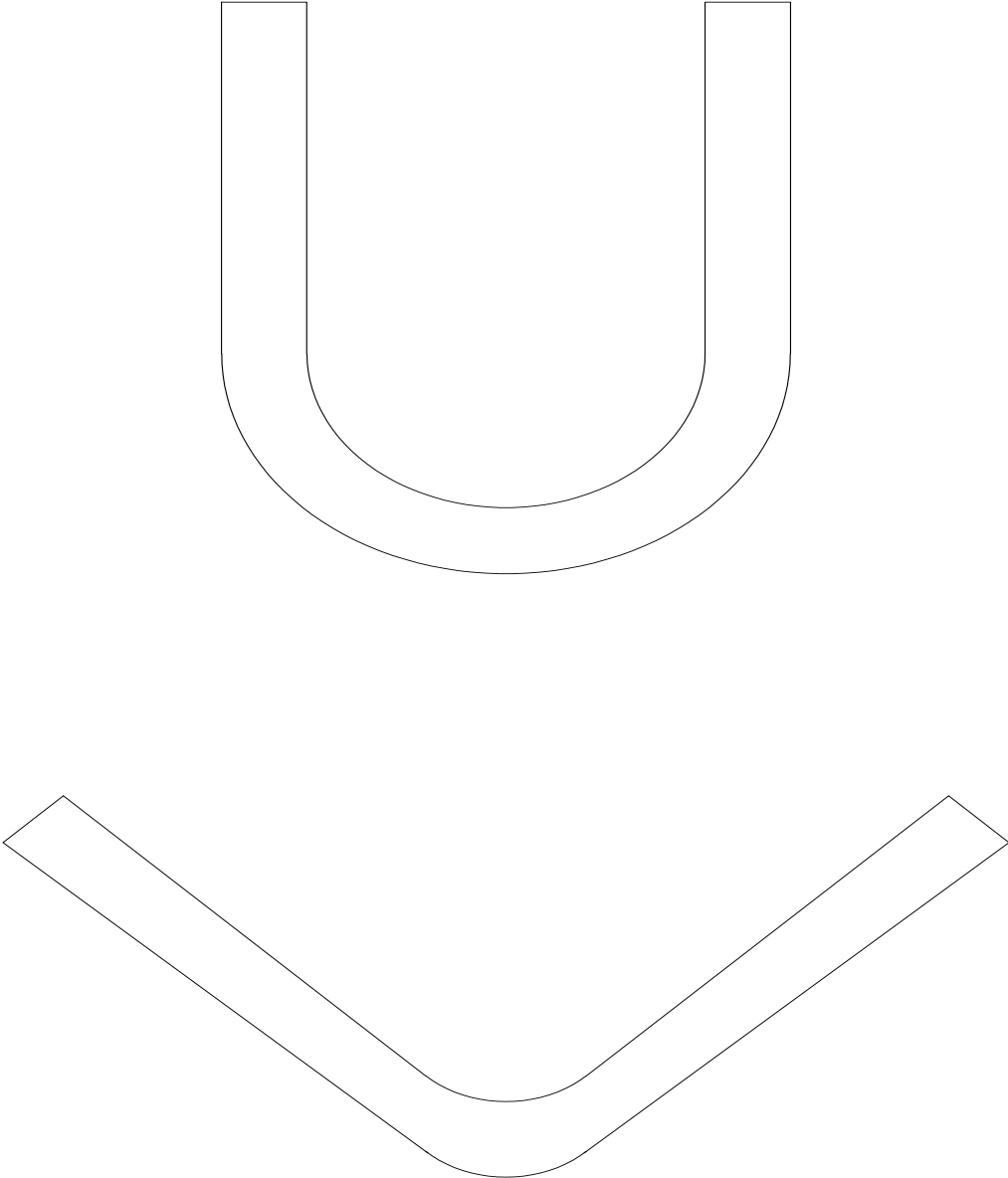
*INSTALLATION,*

*OPERATION AND*

*MAINTENANCE*

*SEPTEMBER 2017*

The weld coupon bender is a component tool designed to bend welded test coupons into U and V shapes, as seen in Figure 1, for the purpose of testing the soundness and ductility of welds. The U test die has a radius of 1.56" (39.7mm), the rollers are set at a distance of 4.0" (101.6mm) and the V test die has a radius of 0.125" (3.175mm). Test clips have a maximum capacity of 7.0" (177.8mm) long, 2.00" (50.8mm) wide and 0.375" (9.52mm) thick.

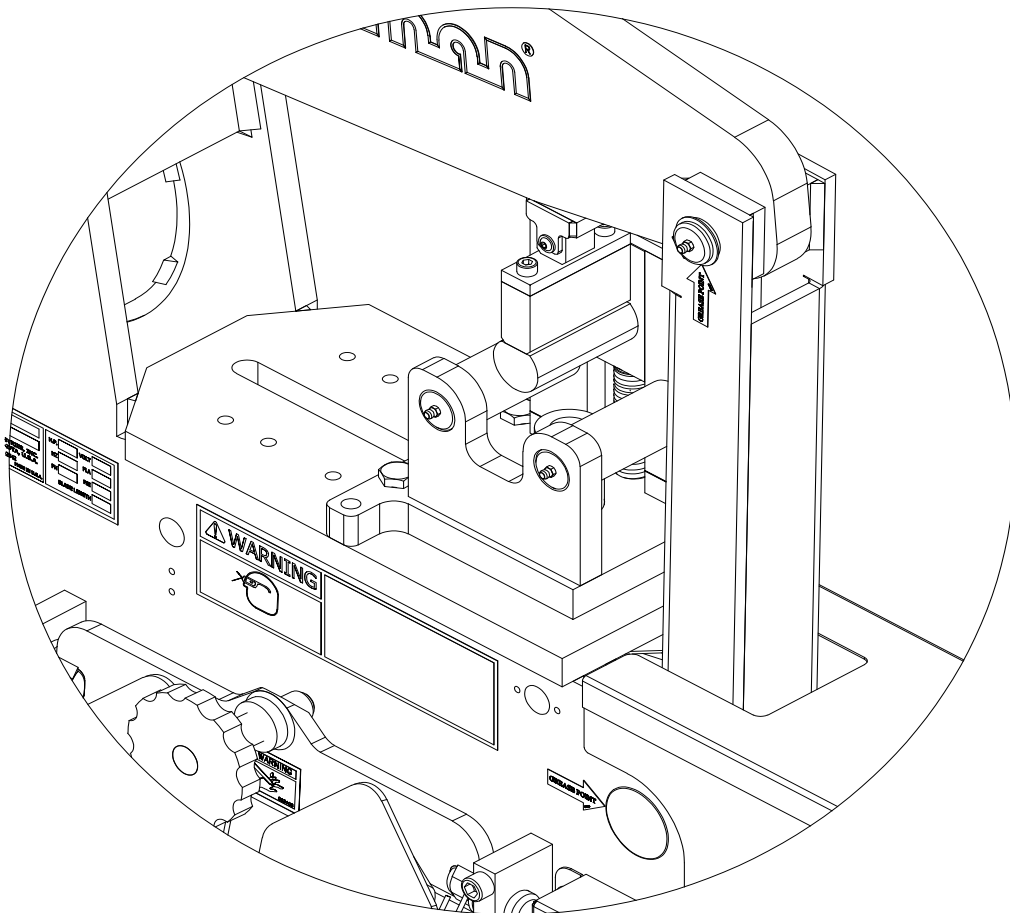


**FIGURE 1**

## Weld Tester Installation

The coupon bender mounts in the tool station under the upper arm and is held in place by an M12 bolt.

The weld tester requires approximately 2.875" (73.025mm) of stroke. On smaller machines such as the 50514-EC, 5014-ET and Porta Fab 45, the coupon bender must be bolted to the tool table on the far right side, as seen in Figure 2. On larger machines, such as the 6509-24M and DO 150/240-24M, the coupon bender must be operated under the center of the beam. For the FI85 and DO85, the tool is placed in the punch station.

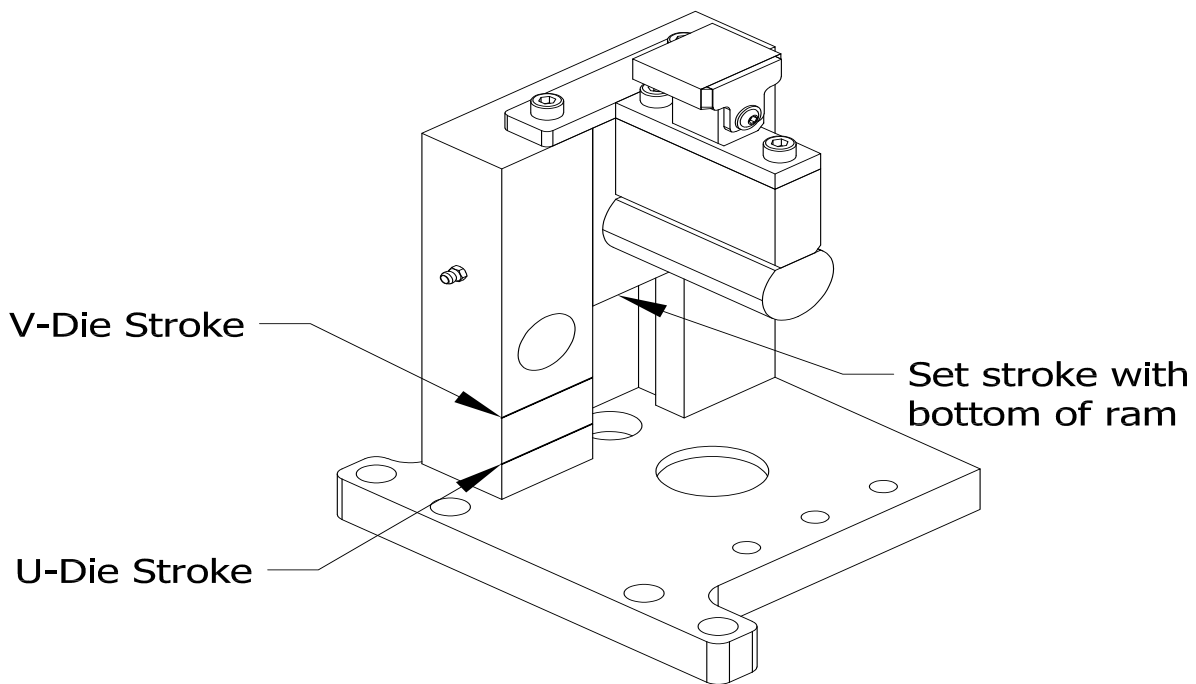


**FIGURE 2**

- **To prevent damage to the tool, the stroke of the machine must be set when using the coupon bender.**

Set the up stroke of the machine so that the test clip easily slides into the coupon bender. Set the down stroke so that the ram stops at one of the scribe lines on the back of the tool. The top scribe line is used for the v die and the bottom is used for the u die.

- **Do not stroke the machine past the bottom scribe line.**



**CAUTION: DO NOT STROKE TOOL  
PAST THE U-DIE STROKE LINE**

**FIGURE 3**

- **Ensure that the back of the coupon bender is clear of the moving arm of the ironworker.**

The coupon bender mounts in the tool station under the upper arm and is held in place by an M-12 bolt. The weld tester requires approximately 2.875" (73.025mm) of stroke for the U test. Bolt the coupon bender to the set of holes corresponding to the machine below; all hole locations are when facing the machine, with the punch station to the left.

<b>Porta Fab 45</b>	<b>4th set of holes</b>
<b>50514-CM</b>	<b>4th set of holes</b>
<b>5014-TM</b>	<b>4th set of holes</b>
<b>6509-24m</b>	<b>3rd set of holes w/finger clamps</b>
<b>9012-24M</b>	<b>4th set of holes</b>
<b>12012-24M</b>	<b>4th set of holes</b>
<b>DO 70/110-24M</b>	<b>3rd set of holes</b>
<b>DO 95/140-24M</b>	<b>3rd set of holes</b>
<b>DO 120/200-24M</b>	<b>3rd set of holes</b>
<b>DO 135/220-24M</b>	<b>3rd set of holes</b>
<b>DO 150/240-24M</b>	<b>3rd set of holes</b>
<b>FI 8510-20M</b>	<b>Mounts in punch station w/finger clamps.</b>
<b>DO 8514-20M</b>	<b>Mounts in punch station w/finger clamps.</b>

☒ **NOTE: When using the coupon bender with the 8510-20M or the DO 8514-20M, make sure that the tool completely clears the punch ram of the machine.**

➡ **REMOVE THE COUPON BENDER WHEN IT IS NOT IN USE.**

ITEM	QTY	PART #						DESCRIPTION
			Porta Fab	6509	9012	DO120	DO85	
			50514-EC		12012	DO135	FI85	
			5014-ET		DO70	DO150		
					DO95			
A	1	Varies	024720	024730	024740	024750	024760	Pusher - Sales
B	4	221315						M-12 x 40MM SHCS
C	4	073420						M-8 16MM SHCS
D	1	024716						Coupon Bender - Ram Stop
E	4	243101						M-6 Grease Zerk
F	1	024714						Coupon Bender - Spring
G	1	024702						Coupon Bender - Base
H	5	221210						M-10 x 25MM SHCS
I	2	024705						Coupon Bender- Roller
J	1	024703						Coupon Bender - Clip Spring
K	2	024704						Coupon Bender - Pin
L	1	024701						Coupon Bender - Pin Support
M	1	024708						Back Support
N	1	024713						U-Die Ass'y
O	2	343002						1/4 x 3/4 Dowel Pin
P	1	024709						Coupon Bender - Ram
Q	1	024715						Coupon Bender - V-Die
R	1	220016						M-6 x 10MM BHCS
S	1	433151						Rocker Cap

