

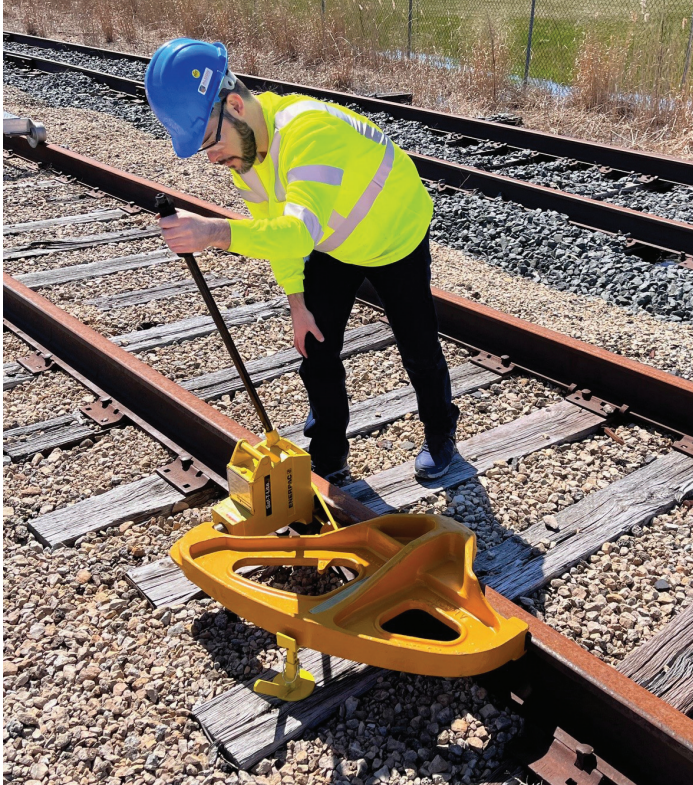
AL-200 Rail Benders

Installation & Operation Instructions

4021-01 (AL-200-H Hydraulic)

4021-02 (AL-200-S Screw-Jack)

4021-03 (AL-200-R Remote Hydraulic)



ALDON[®]
Safety on Track Since 1904

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

PH. 847.623.8800 | FX. 847.623.6139

www.aldonco.com | e-rail@aldonco.com

Cautions and Warnings

Read all warnings and cautions on products in this guide before installation and operation. If you have questions regarding rail benders, contact Aldon Company, Inc.

- 1. Designed for bending 60-142 lbs. conventional T-rail only.**
2. Always inspect the rail bender's frame, jack, safety chain and handle for excessive wear or damage before use. Never use a bender that is damaged or not working properly.
3. Do not attempt to repair the frame or structural elements of the bender. If damage or excessive wear is evident, discontinue use immediately.
4. Only use the handle and ram that were originally equipped by the manufacturer. Do not attempt to repair or modify the operating handle.
5. Do not attach auxiliary or aftermarket hydraulic systems.
6. Only use OEM replacement parts correct to the model or rail bender.
7. Do not attempt to bend any objects other than conventional T-rail sections. Only bend rail profiles indicated by the manufacturer.
8. Do not use to bend electrified 3rd rail, heat treated or special section rails.
9. Ensure the rail bender frame and ram/jack are properly positioned on the rail before use.
10. Ensure the safety chain or cable (if equipped) is properly attached.
11. The operator should always stand to the inside of the bend radius. Do not stand straddling the rail during the bending process.
12. The operator should avoid placing his/her body in line with the thrust axis of the ram or jack while it is under pressure.
13. All bystanders must keep a safe distance away from the rail bender during use.

Recommended Tools for Installation

Bender Frame Block



Designed to hold all AL-200-Series bender frames parallel to the height of the rail before and after the bending process.

4021-23

Installation

1. Position the rail bender frame on the rail where the bend needs to begin. The hook on the bender frame should wrap around the rail head.



Installation

2. Adjust the bender frame block to the correct height and place it under the center point of the bender frame. The bender frame should sit as level as possible with the rail.



3. Rotate the bender frame until it contacts the rail head. The rail head should be positioned between each flange on the bender frame. It may be necessary to readjust the bender frame block.



Installation

4. Position the “shoe” on the ram or jack against the rail head and lower it towards the bender frame.



The body of ram or jack should rest on the bender frame tab. It may be necessary to extend the screw outward on screw type jacks to achieve this. The ram or jack should now stay in a fixed position with the “shoe” straddling the the rail head. (Refer to Step 1 in the Operation section for using the Screw Jack.)



Installation

During the installation and initial bending process the rail bender will slightly move, this is normal. If the rail bender continues to rise or lower during the bending process, release pressure from the ram or jack and start your bend over.

Incorrect Bender Frame Position



Too High



Too Low

Incorrect Ram/Jack Position



Saddle-in



Saddle-out

5. Attach the safety chain hook on the bender frame to the safety loop on the ram or jack.



Operation

1. During the bending process, ALL bystanders should keep a safe distance away. Before using your ram or jack, make sure it is operating properly before starting your bend.

- **Hydraulic Ram**, check to make sure the release valve is closed. Use the cushion grip end of handle to operate the valve.
- **Screw Jack**, make sure the socket plunger is set for the right direction and rotate the handle socket to operate the jack.



2. Insert the handle into the handle socket on the ram or jack. The person operating the bender should be positioned on the “right” side of the bender handle and the opposite side of the rail during the bending process.



Operation

All other bystanders should be aware of where to stand during the bending process.



The operator and bystanders should never stand on the outside of the bend.



Do not straddle the rail.

3. Extend the ram or screw outward using the bender handle until it contacts the bender frame. The machined slot on the ram or jack head should contact the bender frame above tab. The machined slot should always be the point of contact between the bender frame and ram or jack throughout the bend.



Operation

4. As you start to bend the rail, the bender frame should be level with the rail head. The ram or jack should be square/90 degrees to the rail.



Correct Bender Frame Position



Correct Ram or Jack Position

5. As you are making a bend, use the lasered on scale on the ram or screw as a reference when making multiple bends.



Operation

- When checking the radius of your bend, the operator and bystanders should never stand on the ram or jack side of the bender when it is under pressure. If the ram or jack is ejected under pressure it will likely travel in that direction.



Removal

- To remove the bender from the rail, reposition the bender frame block if necessary. Release the pressure from the ram or jack.

Hydraulic Ram



Use the cushion grip end of the handle to open the release valve. As you open the valve, the ram will compress. Never remove the release valve from the ram.

Screw Jack



Push the socket plunger in the opposite direction and insert the handle into the handle socket. Slowly ratchet the screw back into the jack.

Removal

2. Remove the safety chain hook attached to the safety loop on the ram or jack. Lift and rotate the ram or jack away from the frame and rail.



3. Remove the bender frame block and let frame rest on the ballast. Lift upwards near the hook on the frame and finish removing frame from the rail.





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

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

Follow us on



Printed in USA November 2024