QUICK INSTRUCTION GUIDE

2020/4010 | BENDER KIT

Quick operating instructions • Keep this sheet for reference

PURPOSE	BENDER KIT
Two-tool kit for forming a 180° hem: the WUKO 2020 makes the initial bend; the 4010 completes the hem.	2020 Mini Bender and 4010 Mini Disc-O-Bender.

BEFORE YOU START

- Inspect both tools and confirm rollers and discs are undamaged.
- Wear safety glasses and cut-resistant gloves when handling metal.
- Check material thickness and flange height against both tool ratings.

HOW TO USE

1. Place the sheet metal on a stable surface and mark the bend line. Confirm the material is within rated bending capacity.
2. Adjust the 2020 Mini Bender to 5–20 mm (3/16–13/16 in.) bending height. Secure the setting.
3. Seat the 2020 rollers on the sheet edge and align them with the bend line.
4. Apply controlled upward pressure while moving the 2020 back and forth until a 90° bend is formed.
5. Remove the 2020. Seat the 4010 Mini Disc-O-Bender on the pre-bent edge; check its allowed flange height.
6. Move the 4010 forward and backward, gradually folding the edge toward 180°.
7. For inside or outside radii, guide each tool along the curve with consistent roller contact.
8. Continue controlled passes until the hem is complete. Remove the tool and inspect the finished edge.

IMPORTANT SAFETY NOTES

- Keep hands clear of rollers, discs, and pinch points.
- Never exceed the rated bending capacity of either tool.
- Sharp sheet metal edges can cause injury; handle with care.

CARE AND STORAGE

Remove debris, inspect rolling surfaces for wear, and store both tools clean and dry.

SPECIFICATIONS

WUKO 2020: Initial bend to 90°; height 5–20 mm (3/16–13/16 in.).

WUKO 4010: Finishes to 180°; the flange must be within BOTH tools' rated ranges.

HELP AND REFERENCE

Manufacturer instructions: Consult the official WUKO 2020 and 4010 manuals.

Customer support: rapidmaterials.com

IMPORTANT: This quick guide does not replace manufacturer instructions.