QUICK INSTRUCTION GUIDE

2050/4010 | BENDER KIT

Quick operating instructions • Keep this sheet for reference

PURPOSE	BENDER KIT
Two-tool kit for forming a 180° hem: the WUKO 2050 makes the initial bend; the 4010 finishes the hem.	2050 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 sheet metal on a stable surface; mark the bend line. Confirm material thickness is within rated capacity.
2. Adjust the 2050 Mini Bender to 5–50 mm (3/16–2 in.) bending height. Secure the setting.
3. Seat the 2050 rollers on the sheet edge, aligned with the bend line.
4. Apply controlled upward pressure while moving the 2050 back and forth until the bend reaches 90°.
5. Remove the 2050. Fit the 4010 onto the 90° edge. For a 180° hem, flange height must be 8–23 mm (5/16–7/8 in.).
6. Move the 4010 forward and backward, gradually folding the edge toward 180°.
7. For inside or outside radii, guide both tools 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 2050: Initial bend to 90°; bending height 5–50 mm (3/16–2 in.).
WUKO 4010: 180° hemming flange height 8–23 mm (5/16–7/8 in.).

HELP AND REFERENCE

Manufacturer instructions: Consult the official WUKO 2050 and 4010 manuals.
Customer support: rapidmaterials.com

IMPORTANT: The 2050 can bend to 50 mm; the 4010 can hem only 8–23 mm.
This quick guide does not replace the manufacturers' operating instructions.