



QUICK INSTRUCTION GUIDE

2050/4040 | BENDER KIT

Quick operating instructions • Keep this sheet for reference

PURPOSE

The WUKO 2050 forms the initial 90° bend; the WUKO 4040 completes a hem up to 180°.

BENDER KIT

2050 Mini Bender + 4040 Disc-O-Bender Twist.
Two-stage hemming.

BEFORE YOU START

- Inspect both tools and verify secure, undamaged rollers and adjustments.
- Wear safety glasses and cut-resistant gloves when handling sheet metal.
- Check material thickness and both tools' rated capacities before use.

HOW TO USE

1. Place metal on a stable support, mark the bend line and check material thickness against rated limits.
2. Adjust the WUKO 2050 bending height to 5–50 mm (3/16"–2"); secure the adjustment.
3. Position the 2050 on the sheet edge with rollers properly seated and aligned.
4. Move the 2050 back and forth with gentle upward pressure, increasing each pass to form 90°.
5. Remove the 2050. On the WUKO 4040, use the locking bolt to twist the roller stop open.
6. Place the 4040 on the 90° edge; flange height must be 8–32 mm (5/16"–1-1/4").
7. Twist the roller stop back to its operating position and secure it before bending.
8. Move the 4040 forward and backward, folding the pre-bent edge gradually toward 180°.
9. On inside or outside curves, guide each tool carefully while maintaining roller contact.
10. When finished, open the 4040 roller stop, remove the tool and inspect the hem.

IMPORTANT SAFETY NOTES

- Keep hands clear of bending rollers, discs and pinch points.
- Do not exceed the rated limits of either tool.
- Sharp sheet metal edges require careful handling and suitable PPE.

CARE AND STORAGE

Clean metal debris from both tools, inspect rollers, and store in a dry location.

SPECIFICATIONS

2050 bend height: 5–50 mm (3/16"–2"); forms initial bends up to 90°.
4040 hemming flange: 8–32 mm (5/16"–1-1/4"); finishes up to 180°.

HELP AND REFERENCE

Manufacturer instructions: Consult official WUKO 2050 and 4040 manuals.
Customer support: rapidmaterials.com

IMPORTANT: The 2050 can bend to 50 mm; the 4040 can hem only 8–32 mm.