



QUICK INSTRUCTION GUIDE

2204/4040 | BENDER KIT

Quick operating instructions • Keep this sheet for reference

PURPOSE

Two-stage hemming kit: the WUKO 2204 forms the initial 90° bend and the WUKO 4040 completes a 180° hem.

MODEL 2204/4040

2204: bends 5–200 mm. 4040: hems 8–32 mm flanges.

BEFORE YOU START

- Inspect bending rollers, discs, and the twist-away roller stop.
- Wear safety glasses and cut-resistant gloves when handling sheet metal.
- Check tool and material limits before bending or hemming.

HOW TO USE

1. Support and mark the sheet metal. Verify thickness is within both tools' rated limits.
2. Set the WUKO 2204 bending height to 5–200 mm using the inch scale; secure adjustment.
3. Position the 2204 with bending rollers and four guide rollers aligned on the edge.
4. Move the 2204 back and forth with controlled upward pressure to form a 90° bend.
5. Remove the 2204. Open the WUKO 4040 roller stop using its locking bolt.
6. Seat the 4040 on the pre-bent edge; confirm flange height is within 8–32 mm.
7. Rotate the roller stop into operating position and secure it.
8. Move the 4040 back and forth to progressively fold the edge toward 180°.
9. For curved edges, maintain steady roller contact and pressure with each tool.
10. Open the 4040 roller stop, remove the tool, and inspect the finished hem.

IMPORTANT SAFETY NOTES

- Keep fingers clear of rollers, discs, and pinch points.
- Do not exceed either tool's rated capacity or force the bend.
- Handle cut edges and finished hems with care; they are sharp.

CARE AND STORAGE

Remove debris safely, check rollers for wear, and store both tools clean and dry.

SPECIFICATIONS

2204 Uni Bender: 5–200 mm (3/16"–8") initial bend, up to 90°.

4040 Twist: 8–32 mm (5/16"–1¼") flange for hemming to 180°.

HELP AND REFERENCE

Manufacturer instructions: Consult official WUKO 2204 and 4040 manuals.

Customer support: rapidmaterials.com

IMPORTANT: Hem height is limited to 8–32 mm, even though 2204 bends up to 200 mm.