



QUICK INSTRUCTION GUIDE

3202/4000 | BENDER KIT

Quick operating instructions • Keep this sheet for reference

PURPOSE

The WUKO 3202 forms the initial 90° bend; the WUKO 4000 finishes the edge into a 180° hem.

MODEL 3202/4000

Two-tool kit for long, straight sheet metal edges.

BEFORE YOU START

- Inspect both tools, rollers and discs before use.
- Wear safety glasses and cut-resistant gloves when handling metal.
- Check material thickness and flange height against rated limits.

HOW TO USE

1. Place sheet metal on a stable surface, mark the bend line and verify rated capacity.
2. Set the 3202 Duo Bender to 5–200 mm (3/16–8 in.) using its inch scale; secure adjustment.
3. Seat both pairs of Duo Bender rolls along the straight edge and align with the bend.
4. Hold both handles; apply gradual upward pressure while moving back and forth.
5. Make repeated controlled passes until the initial bend reaches 90°.
6. Remove the 3202; verify the 4000 hemming flange is 8–40 mm (5/16–1-9/16 in.).
7. From an accessible panel end, position the WUKO 4000 on the 90° edge.
8. Guide the Disc-O-Bender along the edge with controlled passes toward 180°.
9. Continue passes while maintaining even contact and pressure until the hem is formed.
10. Remove the tool carefully and inspect the finished hem for uniformity.

IMPORTANT SAFETY NOTES

- Keep hands clear of rollers, bending discs and pinch points.
- Do not exceed either tool's rated forming or hemming capacity.
- Sheet metal edges can be sharp; handle finished hems carefully.

CARE AND STORAGE

Clear metal debris, inspect rollers and discs for wear, and store both tools dry.

SPECIFICATIONS

3202: Initial bends 5–200 mm (3/16–8 in.), up to 90°.

4000: Hemming height 8–40 mm (5/16–1-9/16 in.), up to 180°.

HELP AND REFERENCE

Manufacturer instructions: Consult official WUKO 3202 and 4000 manuals.

Customer support: rapidmaterials.com

IMPORTANT: The 4000 cannot hem the full 3202 bending-height range.