



QUICK INSTRUCTION GUIDE

6050/4040 | BENDER KIT

Quick operating instructions • Keep this sheet for reference

PURPOSE

Two-stage 180° hemming kit: the WUKO 6050 forms the initial bend and the WUKO 4040 completes the hem.

MODEL 6050/4040

6050: bends up to 50 mm. 4040: hems 8–32 mm flanges.

BEFORE YOU START

- Inspect both tools, discs, rollers and the twist-away stop before use.
- Wear safety glasses and cut-resistant gloves when handling metal.
- Confirm material thickness and hem height are within rated limits.

HOW TO USE

1. Support sheet metal and mark the bend line. Check the rated material capacity.
2. Set the WUKO 6050 bending height (up to 50 mm / 2 in.) and secure it.
3. Seat the 6050 angled bending disc and guide rollers on the sheet edge.
4. Move the 6050 back and forth with gentle pressure until the bend reaches 90°. It can bend to 100° to allow for spring-back.
5. Remove the 6050. Release the WUKO 4040 locking bolt and twist the roller stop open.
6. Place the 4040 on the 90° edge. Flange height must be 8–32 mm (5/16–1¼ in.).
7. Twist the roller stop into operating position and secure it before bending.
8. Move the 4040 back and forth to fold the edge gradually toward 180°.
9. For curved edges, guide each tool along the radius with consistent roller contact.
10. When hemmed, open the 4040 roller stop, remove the tool and inspect the edge.

IMPORTANT SAFETY NOTES

- Keep hands clear of bending rollers, discs and moving stop mechanisms.
- Do not exceed either tool's material or bending-height ratings.
- Sharp metal edges can cause cuts; handle finished pieces carefully.

CARE AND STORAGE

Remove metal debris, inspect rollers and discs, and store clean and dry.

SPECIFICATIONS

WUKO 6050: Initial bend up to 50 mm (2 in.); bend angle up to 100°.

WUKO 4040: Finishes 8–32 mm (5/16–1¼ in.) flanges to 180°.

HELP AND REFERENCE

Follow the official WUKO 6050 and 4040 operating instructions.

Customer support: rapidmaterials.com

IMPORTANT: The 6050 bends to 50 mm; the 4040 can only hem 8–32 mm.