



User Manual



BKK 25 + BKK 50

Flange- and curve Bender

Extremely light and handy

Bending Material fast and perfect
On Site or at the work shop

Item No.:	Bending 0°- 90°	Bending height	kg
91540	BKK 25	5 – 25 mm	0,8
91540S1	BKK 50	5 – 50 mm	0,9

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Manual

Flange- and curve bender BKK 25 & 50

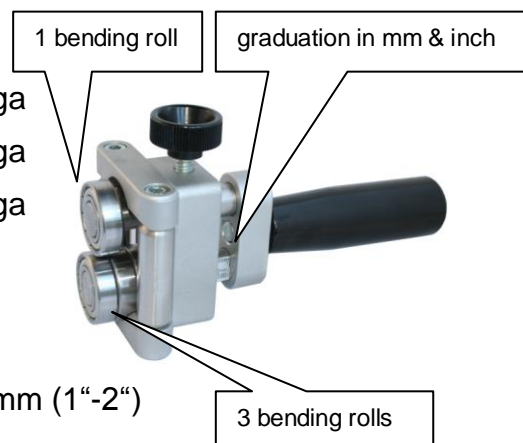


1. Max. thickness of material

- | | |
|---------------------------|--------------------|
| a. copper/zinc/aluminium | up to 1,00 mm/19ga |
| b. galvanized steel | up to 0,75 mm/21ga |
| c. stainless steel/Uginox | up to 0,50 mm/24ga |

2. Profile heights

- | | |
|------------------------|---------------------------|
| a. min. bending height | from 5 mm (0,2") |
| b. max. bending height | to 25 resp. 50 mm (1"-2") |

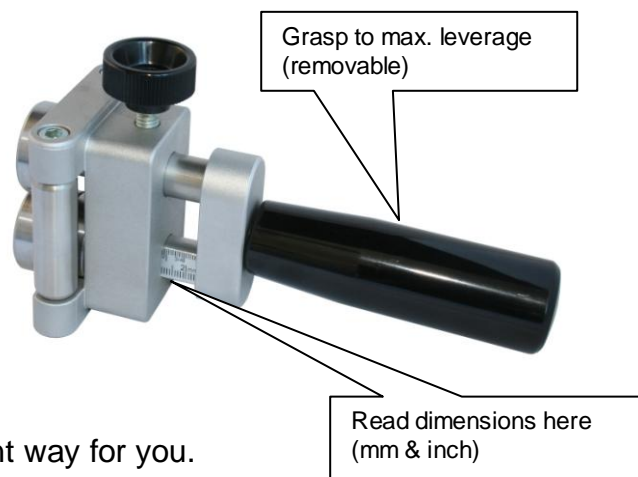


Examples way of working:

Wear protecting gloves!



- Adjust the requested bending dimensions by using the integrated measuring device and lock it with the setscrew.
- The single bearing, on top, is the bending edge. The 3 bending rolls carry the force of bending up.



c. First pass:

Hold the bender the most convenient way for you.

Our advice: hold the bender with a fist grasp.

Move the bender forth and back and push up at an angle of 10°. The pressure should be held on the middle of the bending rolls.

Depending on the material characteristics proceed in the following way:

- Bend up by pushing slightly to the top.

Dräco's professional tip: when going through the sheet metal, please go all the way down (till the end) and also all the way back (till the beginning) to get the best result.

Note: depending on the material data might be different, max bending heights depending on radius.