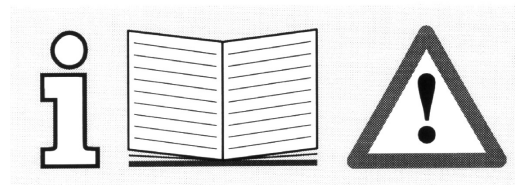




the total roofing system from coil to roof



Operating instructions



Before commissioning and before using machines, it is absolutely essential to carefully read and follow the associated operating instructions and especially the safety instructions listed therein!

Mobile detail brake

K1-AGN-4 (without frame)

K1-AGNU-4 (with frame)



Mach.-No.:

Max Draenert Apparatebau GmbH & Co.KG - Elektro-Druckluftwerkzeuge Germany

Werk I: Verwaltung
Gutenbergstr. 15-17

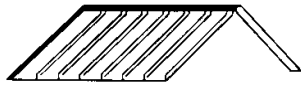
D-73777 Deizisau
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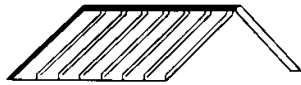


the total roofing system from coil to roof



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... the total roofing system from coil to roof



Hand-operated detail brake K1-AGNU-4 and K1-AGN-4 (without frame)

Scope of delivery:

- ☒ 1 x Hand-operated bending machine
- ☒ 1 x Base frame (K1-AGNU-4 only)
- ☒ 1 x depth stop (2 rails with measuring tape)
- ☒ 10 x finger inserts (segments for upper cheek)
30; 40; 50; 60; 100L; 100R; 4x180mm
- ☒ 1 x bending angle (stainless steel) 1120 mm
- ☒ 1 x Accessory Box (K1-AGNU-4 only)
- ☒ 3 x bending angle (aluminum) 200; 300; 500mm.
- ☒ 6 x cylinder head screws M8 x 16
- ☒ 3 x Allen keys 4; 5; 6 mm
- ☒ 1 x roller shears (optional)
- ☒ 1 x adapter set for rollers (optional)



Detail folding brake K1-AGNU-4

Check for completeness upon delivery!

The intended use of the DRÄCO K1-AGNU-4 segment detail brake includes the manual bending and edging of sheet metal, especially in roofing and wall applications. It is designed for mobile use, enabling bending operations to be carried out directly on the construction site. The specified bending capacity must not be exceeded, particularly when working at full width.

Bending performance:

Aluminum, lead, copper, zinc	0.8 mm
Steel	0.6 mm
Stainless steel	0.5 mm

For a bending height of less than 15 mm, the maximum bending width for zinc, steel, and stainless steel may be reduced to 700 mm.

Data

Width	1420 mm	Weight including base:	90 kg
depth	500 mm	Weight without base:	60 kg
Height:	1375 mm	Working height with base frame:	895 mm
Opening width:	120 mm	Working width:	1120 mm
Segment height:	100 mm		

Main areas of application and functions:

- **Edges:** Production of diamonds, tabs and cassettes.
Allows bending in all technically possible directions, both upwards and downwards.
- **Eaves edges:** Creating eaves edges for roof panels.
- **Material clamping:** Fast sheet metal clamping via hand lever.
- **Segmented upper jaw:** Finger inserts (segments) in various widths for flexible bending tasks.
- **Segmented bending jaw:** Bending angle (aluminium) in three different widths 200; 300; 500mm.
- **Stops:** Parallel, miter, depth, and detent stops for repeatable and fast work
- **Mobile:** Due to its low weight, it is mobile and suitable for on-site use.
- **Cutting:** Rotary shears for cutting to length
- **Profiling:** Creating heels and beads



... the total roofing system from coil to roof



Working with the segment hand-operated bending machine K1-AGN-4 or K1-AGNU-4

The segments can be replaced by simply pulling them downwards without tools.
To do this, press on the segment with one hand at the top and with the other hand downwards to deduct.

The upper cheek is height-adjustable by 120 mm.
Gas springs stabilize the upper cheek in any desired position.

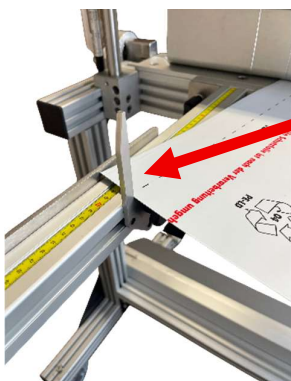


The upward bending is achieved with the help of the rail attached to the lower cheek and the segments mounted above.

2 adjustable material stops on the depth stop for the precise guidance of the material.

Depth stops

The stops can be adjusted differently for diagonal bends on the left and right



The supplied angle rails can be mounted on the lower cheek as needed, instead of the continuous rail, thus enabling segmentation of the lower cheek.

Stop latches

Furthermore, efficient work can also be done using the stop notches mounted on the depth stop. These are used for quickly edging over- and underdeck spars and are standard on the Dimensions of a 25 mm high standing seam set.





... the total roofing system from coil to roof



Creating eaves edges with a hand-operated bending machine K1-AGN/-3/-4 or K1-AGNU/-3/-4

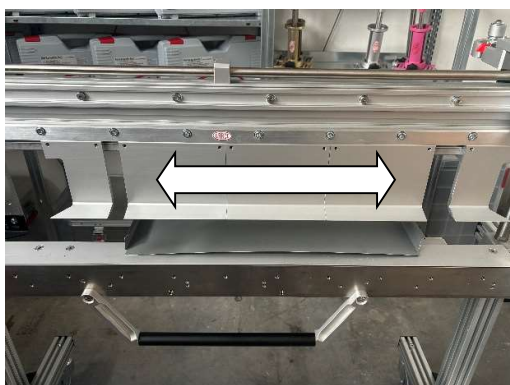


Step 1 (Fig . with Rail)



Step 2 (Fig . without rail)

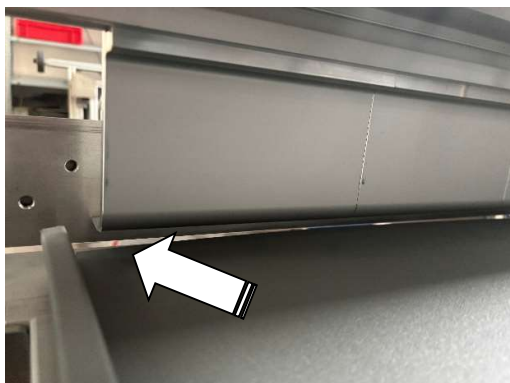
To create eaves edges, the bending bar of the lower cheek must first be removed using the supplied Allen key. All screws should be completely unscrewed.



Step 3 adjust the segments to the inside width of the panel.



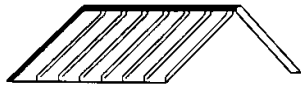
Step 4 Open upper cheek
Swing the lower jaw all the way up.



Step 5
Push the panel from behind through the slot
between the segments and bending bar



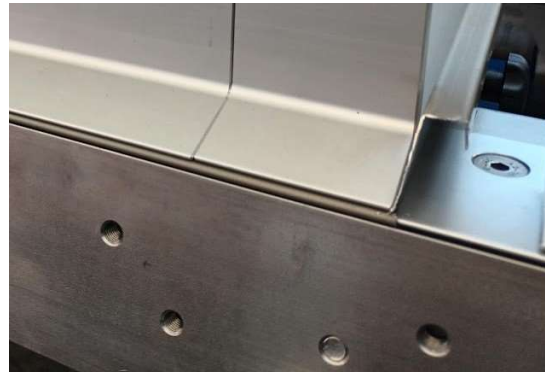
Step 6 Push down on the lower cheek.



... the total roofing system from coil to roof



Step 7:
Lower cheek down to the stop.
The eaves edge should not 25 mm deep
fold exceed.



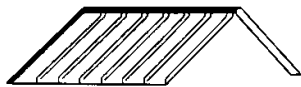
Close-up of Step 7



Step 8
Fully open the upper jaw. Push the panel
forward out of the detail brake.



Step 9
Gently move the lower cheek forward until it is pulled out.
The panel can be easily pulled out without pressure.



... the total roofing system from coil to roof



Example of work for tabs

Figs. 1-6

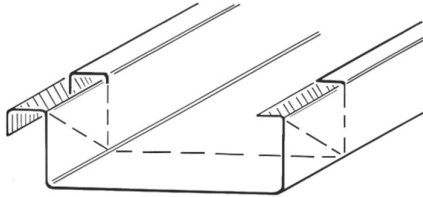


Fig. 1

For tabs, cut out the hatched areas on the top and bottom folds.

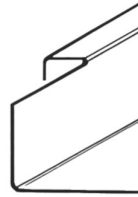


Fig. 2

Top and bottom folds cut out by 25 mm / 1".

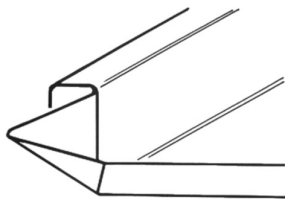
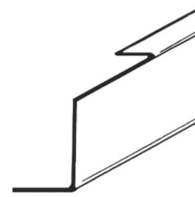


Fig. 3

Bend upwards by approximately 30° using a hand-held bending machine and press the tab outwards with folding pliers.

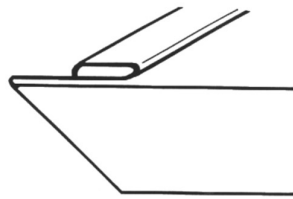


Fig. 4

Bend upwards at a 90° angle, crimp the tab together with folding pliers.

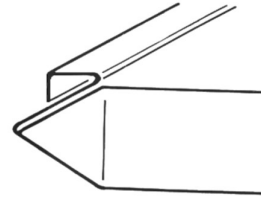


Fig. 5

Using folding pliers, bend the crease to the right or left, see item 6.

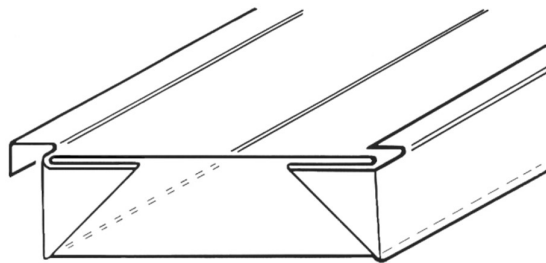
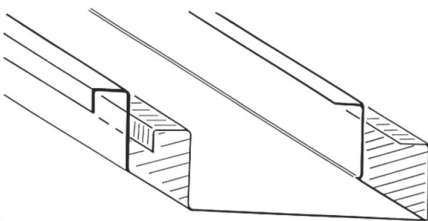


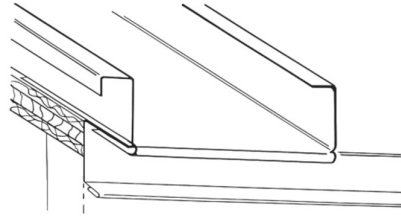
Fig. 6

Use the folding pliers to crimp the fold on the left and right sides and the piece is finished.

Example of work for bends upwards or downwards



To create upward or downward bends, cut out the hatched parts 25 mm from the top and bottom folds.



For eaves edge or wall connection, chamfer upwards or downwards.

Mounting of material support/depth stop :



Release/remove the black transport securing straps and insert the stops into the designated holder. Slide them to the desired width. Secure with the tension lever.

Push & Pull tool-free segment change.

To change the segments, they should be pressed down slightly at the top and simultaneously pulled downwards.

