

# Manual BKK 25

## PINK EDITION



Read, observe and follow this manual and the other applicable documents, especially all safety instructions and warnings.



Always wear protection gloves!

Handle tool carefully and protect against dirt. If nec. lubricate shafts with e.g. sewing machine oil.



Item No.:	Bending 0°– 90°	Bending height	kg
915404003	BKK 25	5 – 25 mm	0,8

### Max. thickness of material

copper/zinc/aluminium	up to	1,00 mm/19ga
galvanized steel	up to	0,75 mm/21ga
stainless steel/Uginox	up to	0,50 mm/24ga

### Profile heights

min. bending height	from	5 mm (0,2")
max. bending height	to	25 mm (1")

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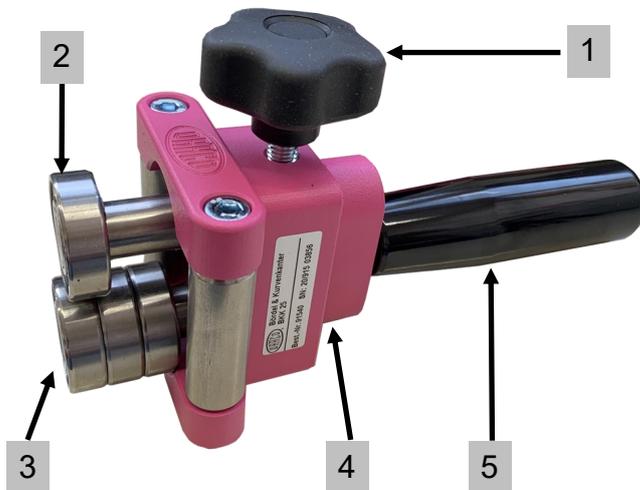


# Manual Disc-Bender DB41

## PINK EDITION



### Tool elements:



1	Set screw
2	1 bending roller on top
3	3 bending rollers under
4	Measuring scale (mm & inch)
5	Grasp to max. leverage (removable)

### Way of working:

- 1) Adjust the requested bending dimensions by using the integrated measuring device and lock it with the setscrew.
- 2) Insert metal between the bending rolls. The single bearing on top, is the bending edge. The 3 bending rolls carry the force of bending up.
- 3) 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:
- 4) Bend up by pushing slightly to the top. (max. 90°)



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.

Your  
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dealer:

