



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.

## BKK 25 & BKK 50



**BKK 25**



**BKK 50 S1,**  
with two upper rollers



**BKK 50 S2,**  
with one upper roller

Item no.:	Bending 0°– 90°	Bending height	kg
91540	BKK 25	5 - 25 mm	0,8
91540S1	BKK 50 S1, with two upper rollers	5 - 50 mm	0,9
91540S2	BKK 50 S2, with one upper roller	5 - 50 mm	0,9

### Max. thickness of material

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

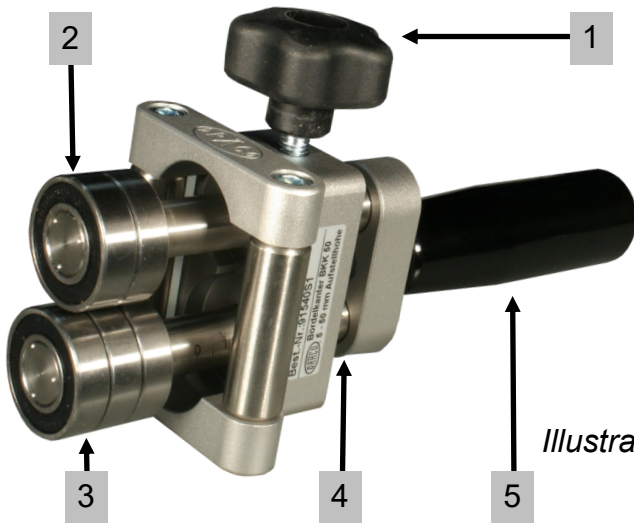
Note: depending on the material data might be different, max bending heights depending on radius.

### Profile heights

min. bending height	5 mm (0,2")
max. bending height	25 mm (1") (BKK 25)/ 50 mm (2") (BKK 50)



## Tool elements:




1	Set screw
2	Two upper bending rollers resp. one (depending on model)
3	Three bending rollers under
4	Measuring scale (mm & inch)
5	Grasp to max. leverage (removable)

Illustration: BKK 50 S1

## 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 rollers. The single bearing (resp. the two bending rollers, BKK 50 S1) on top, are the bending edge. The three bending rollers under carry the force for 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°)



'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.

## Specialty about model BKK 50 S2

Because the BKK 50 S2 model only has one upper roller it is possible to make standing seam profiles.

