

Manual EcO-Bender3/200

PINK EDITION



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



Always wear protective gloves!

Handle tool carefully and protect against dirt. If necessary lubricate shafts (e.g., sewing machine oil).

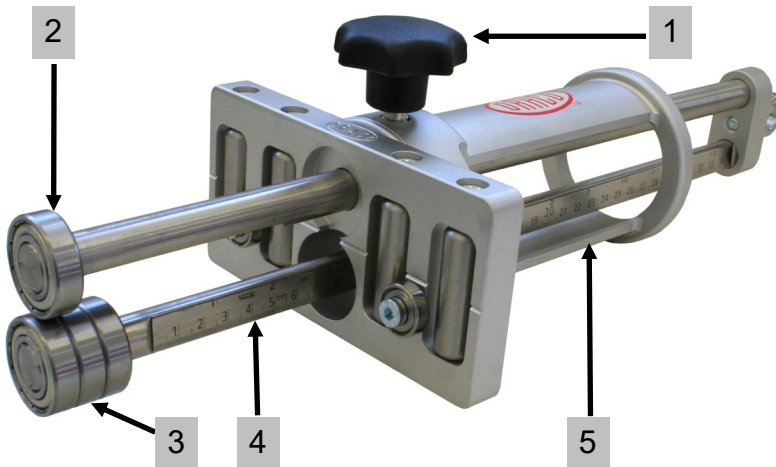


<i>Item no.:</i>	Bending 0°- 90°	Bending height	kg
915454003	EcO-Bender 3/200, with O-handle	5 – 200 mm	1,8

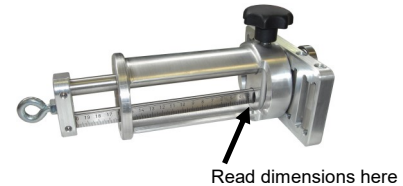


Manual EcO-Bender


1. Tool elements



1	Set screw
2	One bending roller above
3	Three bending rollers below
4	Measuring scale (mm & inch)
5	Optional O-Handle



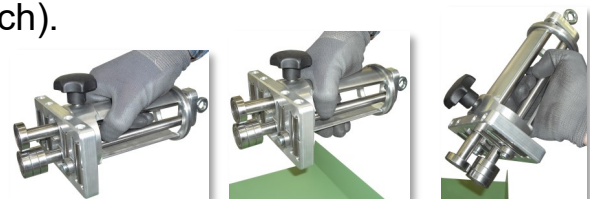
2. Operation method EcO- & Duo-EcO-Bender

- 1) Unlock the set screw(s) and adjust the desired bending height by using the integrated measuring device and lock it with the set screw(s).
- 2) Place the metal between the bending rolls. The single roller is on top and shows in the bending direction (bending edge), the other 3 rollers carry the force to bend up. 
- 3) First pass: Hold the bender the most convenient way for you. Move the bender for- and backwards and push up at an angle of 10-25°. The pressure should be held on the middle of the bending rolls and always move bender all the way to the edges. Depending on the material characteristics proceed the following way:
- 4) Move bender back in an angle of about 20-45°.
- 5) Move bender forward in an angle of about 60° (now it can be easier to hold the bender from below).
- 6) Continue to move Bender forth and back by pushing slightly up till requested angle is reached. Maximum angle of EcO-Bender 3 is 90°.

If necessary, depending on the material characteristics, repeat movement more often and in smaller steps.

Addition to O-handle:

The optional O-Handle enables the full usage even when leverage is entirely extended to 200 or 350 mm (8 or 14 inch). Handle also offers three ergonomic grip positions.



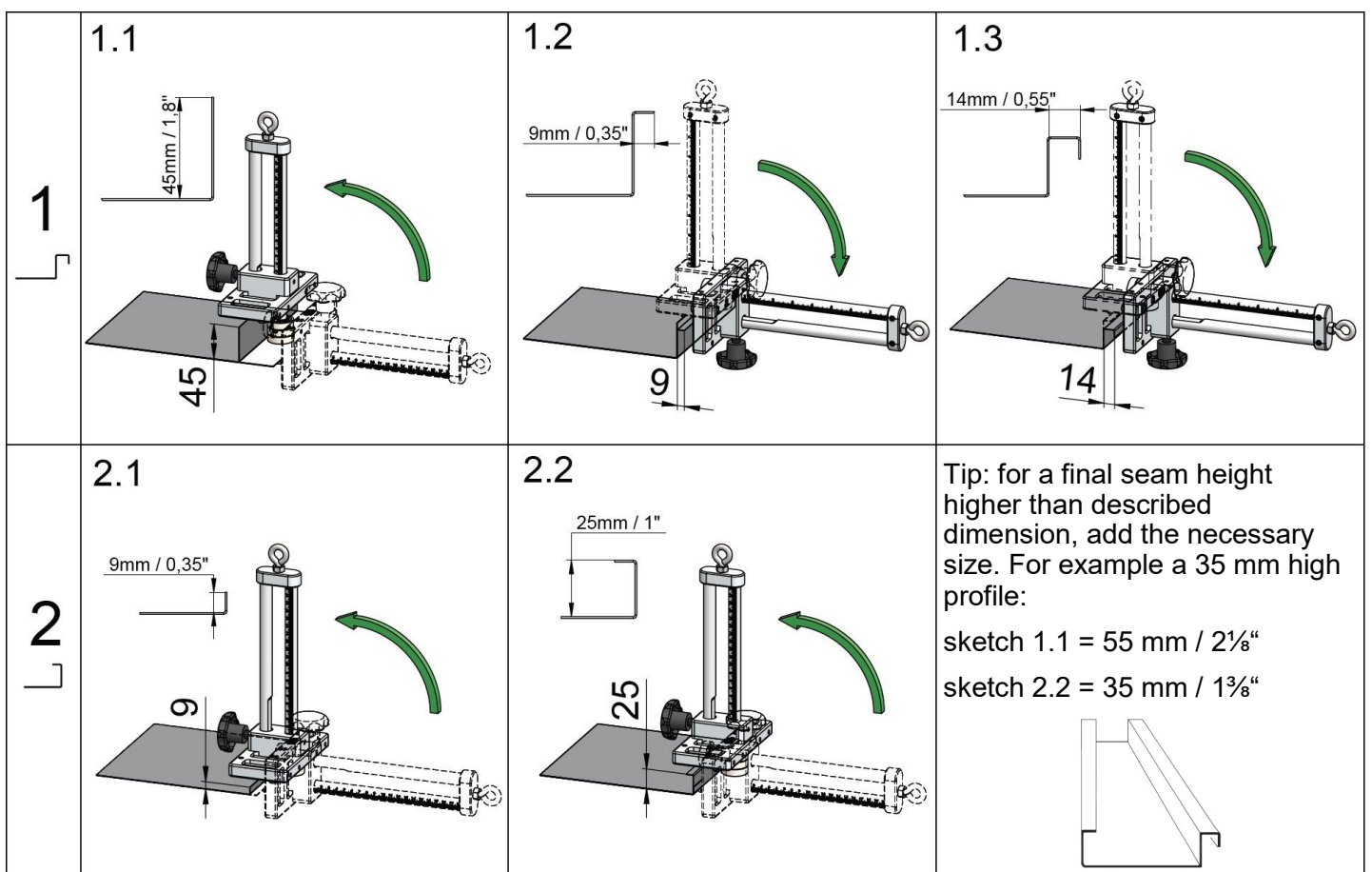
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3. Technical data

Max. thickness of materials:

Copper / zinc / alumium	up to	1,00 mm (19 ga.)
Galvanized steel	up to	0,70 mm (22 ga.)
Stainless steel / Uginox	up to	0,50 mm (25 ga.)

4. Fabrication of standing seam profile (25 mm/1" height)



Female profile (over cloak)

- 1.1 Set the bending height to 45 mm (1.8") and bend up to 90° in accordance with the "Operation Method" explained on the previous page.
- 1.2 Set the height to 9 mm (0.35"), about the width of the upper bending roller, and bend up to 90° in the opposite direction. The single bending roller is always the bending edge, the 3 bending rollers are always the bending bar.
- 1.3 Set the height to 14 mm (0.5") (depending on material specifications) and bend to 90° over the second bend downwards.

2 Male profile (under cloak)

- 2.1 Set the bending height to 9 mm (0.35"), about the width of the upper bending roller, and bend it to 90° in accordance with the "Operation Method" explained on the previous page.
- 2.2 Set the height to 25 mm (1") and bend up over the first profile to 90°.

