

Manual Supra-Bender



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).





*Supra-Bender with O-handle
in 200 or 350 mm length*



*Supra-Bender without O-handle
in 200 or 350 mm length*

Item no.:	Bending 0°- 120°	Bending height	kg
91550	Supra-Bender 200, with O-handle	30 – 200 mm	1,8
91550S3	Supra-Bender 350, with O-handle	30 – 350 mm	2,2
91550S1	Supra-Bender 200, without O-handle	30 – 200 mm	1,5
91550S4	Supra-Bender 350, without O-handle	30 – 350 mm	1,9

Item no.:	Accessories		kg
91549-1	Adapter set (adapter + handle) to connect two Supra-Benders and ensures a convenient grip		1,5
KH70400	O-handle for Supra-Bender		0,3

Technical data

Max thickness of materials:

Copper / zinc / aluminium	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.)

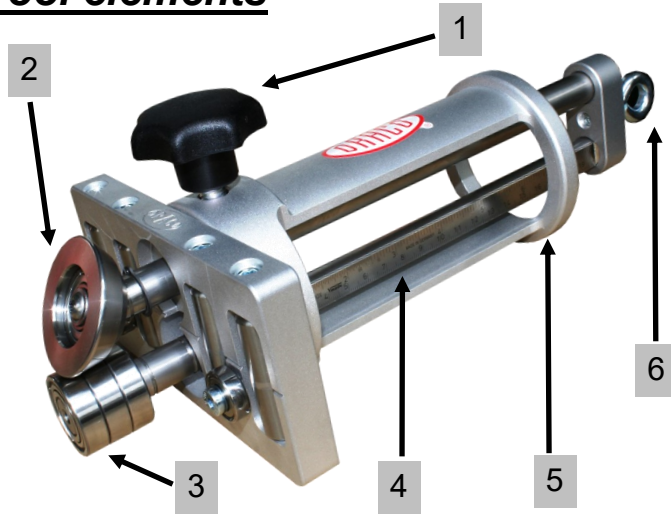
Bending height:

Min. bending height	from	30 mm
Max. bending height	up to	200 or 350 mm



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Tool elements



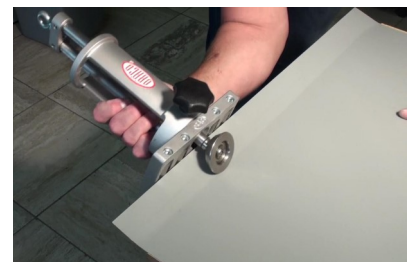
1	Set screw
2	One bending roller above
3	Three bending rollers below
4	Measuring scale (mm & inch)
5	Optional O-Handle
6	Eyelet for tool holder

Proper use:

The tool is used for bending initially flat sheets in the material thicknesses described on the first page. This is achieved by moving the tool along the material using manual force and back and forth movements. Improper use and handling can create hazards and cause damage.

Operation method EcO- & Duo-EcO-Bender:

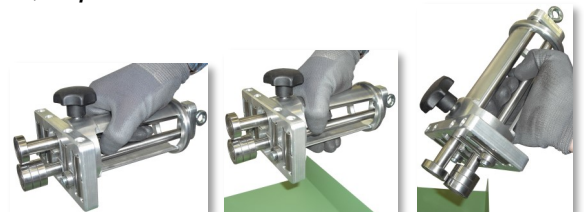
- 1) Unlock the set screw and adjust the desired bending height by using the integrated measuring scale and lock it with the set screw.
- 2) Place the metal between the bending rolls. The single roller is on top and shows in the bending direction (bending edge), the other three rollers carry the force to bend up.
- 3) First pass: Hold the bender in the most convenient way for you. Move the bender forwards 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 in the following way:
 - 4) Move bender back at an angle of 20-45°.
 - 5) Move bender forward at an angle of 60°.
 - 6) Continue to move bender forwards and backwards by pushing slightly up until the requested angle (max. 120°) is reached.



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

O-handle:

The O-handle enables the full usage even when leverage is entirely extended. Three ergonomic grip positions.



Adapter set:

Two Supra-Benders can be connected by an adapter. This makes bending even easier when working on long and straight sheets. If working on shorter and more curvy sheets, it may be helpful to detach the Duo-Bender into two Supra-Benders.



Animation assembly



Attention:

Due to the smallest bending height of 30 mm standing seam profiles cannot be produced. For this we recommend the DRÄCO EcO-Bender4 (max. 100 °), or alternatively the DRÄCO Mini-Bender4 (max. 100 °).