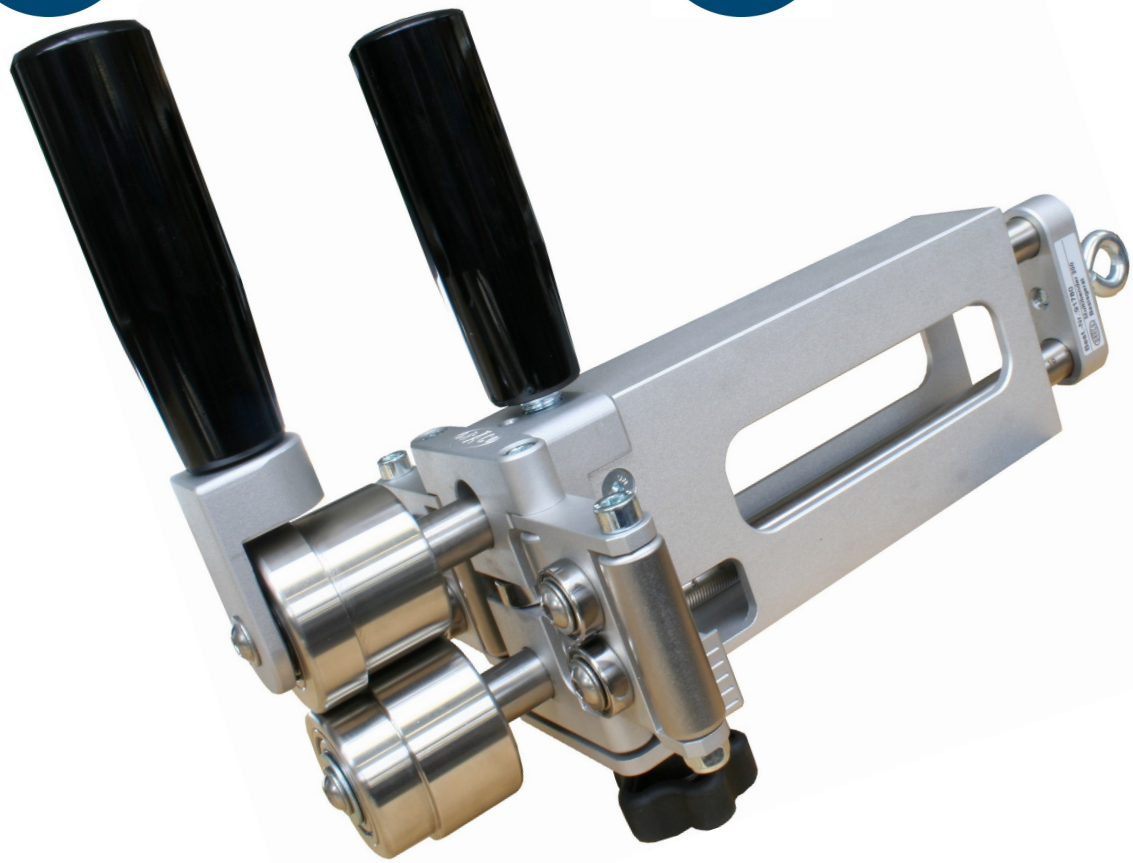
Manual
Multi-Bender MB 200

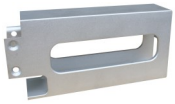
Engineered and Made in Germany

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

Always wear protective gloves!

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



Item no.:	Type	Illustration	kg
91780	Multibender 200 Basic tool		2,1
91785	Grip (optional)		0,3
91786	Pulling handle (optional)		0,2

Techn. Data	Copper/ Zinc/ Alu	Steel	Stainless steel	Min. bending height	Max. bending height	Beading depth
mm	1,0	0,7	0,5	44	244	3,5

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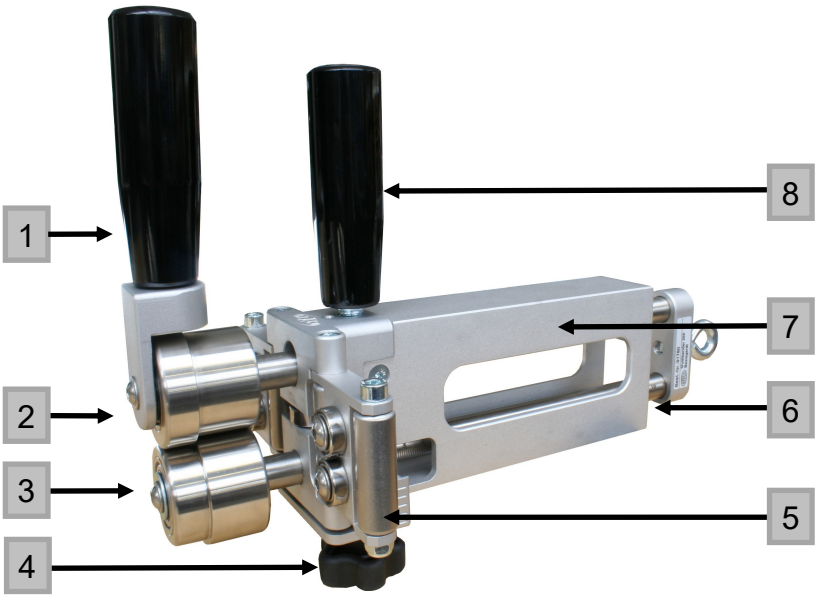
Tool elements



1	Pulling Handle
2	Top Roller
3	Lower Roller
4	Set Screw
5	Foldable Wings
6	Measuring scale (mm & inch)
7	Optional Grip
8	Adjustment Screw

Intended use

This tool is exclusively for beading, trimming and bending sheet metal, folded or pre-profiled material in the material thicknesses on the front page. This is achieved by moving the tool along the material using manual force and back and forth movements.

Operation method

1) Unlock set screw (4) and adjustment screw (8) and adjust to desired depth by using the integrated measuring scale (6), then lock it with set screw (4) only.
2) Place the metal sheet or panel between the rollers (2+3).
3) Hand tighten adjustement screw (8) and hold bender in the most convenient way for you.
4) ***Beading rollers (Roller pair #1, 2, 3, 5, 6, 7, 8, 9):***
   a) Move bender back and forth. Hold pressure on the middle of the beading rollers. To get the best result do not stop in the middle of the procedure, always move bender till the sheet edges.
   b) Tighten the adjustement screw (8) a bit more and move bender back and forth.
   c) Repeat procedure by tightening the adjustment screw (8) more and more and moving bender back and forth until desired beading depth is reached.
   Setting/Bending (Roller pair #4):
   a) If present remove optional pulling handle (1) first
   b) Move bender forwards and backwards and push up at an angle of 10-25°. Hold pressure on the middle of the bending rollers. Always move bender all the way to the ed ges. Depending on material characteristics, proceed the following way:
   c) Move bender back at an angle of 20-45°
   d) Move bender forward at an angle of 60° and continue with procedure by moving for wards and backwards till requested angle is reached.
   Cutting (Roller pair #10)
   a) Move bender forwards and backwards, all the way to the edges. Keep the pressure on the middle of the cutting rolls
   b) Repeat procedure until sheet is separated

Dräco-Tip: Fold in the wings (5) when working on curves.

Roller exchange

Release the roller pressure by loosening the adjusting screw (8) and, if necessary, the set screw (4). pull out the shaft. Loosen the top and bottom rollers by removing fixing screws. Pull off the rollers and push the desired rollers onto the shaft. Mount the rollers according to the desired bead shape (top or bottom). Then tighten the fixing screws.

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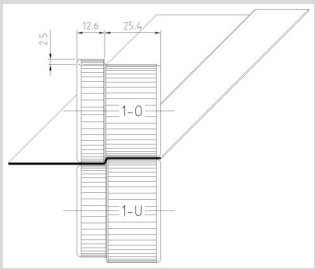
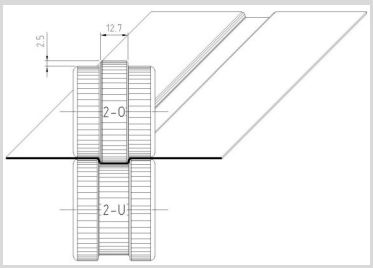
Pair of rollers

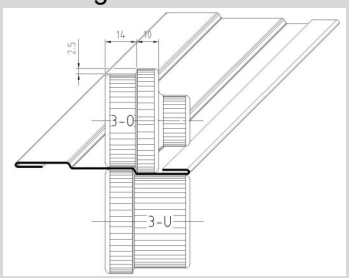
No. 1: AS **#9179001**
Offsetting 1



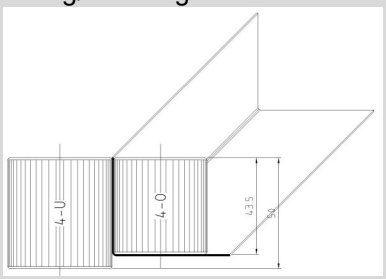
No. 2: SF12 **#9179002**
Flat beading 1/2“. 12,5 mm



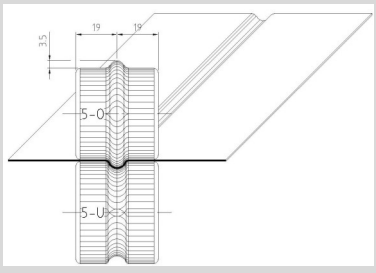
No. 3: VS **#9179003**
Offsetting



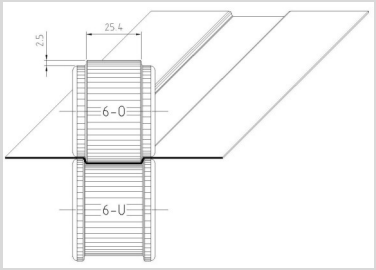
No. 4: AB **#9179004**
Setting/ Bending



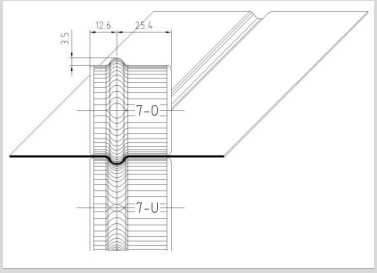
No. 5: SRS **#9179005**
Beading circularly (symmetric)



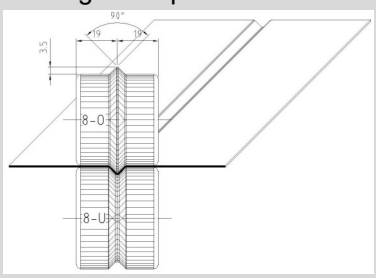
No. 6: SF25 **#9179006**
Flat beading 1“, 25 mm



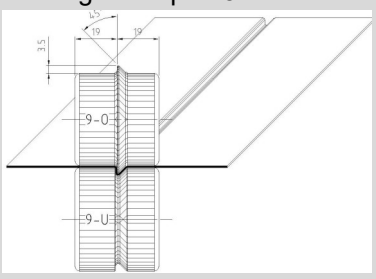
No. 7: SRA **#9179007**
Beading circularly (asymmetric)



No. 8: SV90 **#9179008**
Beading V-shape 90°



No. 9: SV45 **#9179009**
Beading V-shape 45°



No. 10: SR **#9179010**
Cutting rollers