



BN PRODUCTS-USA, LLC.

3450 Sabin Brown Road • Wickenburg, Arizona 85390
(800) 992-3833 • (928) 684-2813 • www.bnproducts.com



Bender Handling Instructions DBD-20M 0-180 degree Portable Rebar Benders



BN Products-USA, LLC.
3450 Sabin Brown Road
Wickenburg, AZ 85390
(800) 992-3833 • (928) 684-2813
FAX: (928) 684-7041
mail@bnproducts.com
www.bnproducts.com

Products that make money, save money and add value to your bottom line



BN PRODUCTS-USA, LLC.

3450 Sabin Brown Road • Wickenburg, Arizona 85390
(800) 992-3833 • (928) 684-2813 • www.bnproducts.com

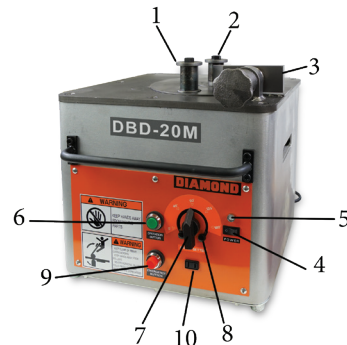
Bender Handling Instructions DBD-20M Rebar Benders (0-180 degree)

Important: When using electric tools, basic safety precautions should always be followed to reduce the risk of electric shock and personal injury, please note the followings items:

READ ALL INSTRUCTIONS AND SAVE THIS DOCUMENT FOR REFERENCE.

1. Keep hands away from all moving parts and rollers while operating.
2. Dress properly. Loose clothing or jewelry can get caught in moving parts. Wear sturdy boots with non-skid soles. Steel toed boots and safety glasses are recommended.
3. Keep children and bystanders away. Distractions can cause you to lose control.
4. Do not overreach. Keep proper footing and balance at all times. This enables better control of the power tool in unexpected situations.
5. Stay alert. Watch what you are doing and use common sense when operating a power tool. Do not use a power tool while you are tired or under the influence of drugs or alcohol. A moment of inattention while operating power tools may result in serious personal injury.
6. Do not exceed the maximum number of bars that can be bent at one time. Please refer to the **Rebar Bender Roller Selection Chart**
7. When positioning the bar between rollers, make sure to lay it flat on the machine surface. Failure to do so may cause the rebar to fly out.
8. Do not expose tool to rain or use in damp locations. Do not use tool in presence of flammable liquids or gases. Keep work area well lit. If the tool is used outdoors, keep it covered when not in use and protect it from rain or water.
9. Do not try to bend materials harder than “Grade 60 or 600N/mm²” as they will either crack and fly out or cause machine failure.
10. Disconnect tool from receptacle when not in use. Disconnect the tool when servicing or changing rollers to prevent accidents.
11. Keep tool clean at all times for best and safest performance. Follow instructions for lubricating and changing parts. Keep hands dry and free of oil or grease. Inspect switches, tool cords periodically and have them repaired or replaced by an authorized service center if damaged. Check moving parts for alignment and binding as well as for breakage and improper mounting. Damaged parts should be repaired or replaced by an authorized service facility unless otherwise indicated in this instruction book.

- | | |
|-----------------------------|--------------------------------------|
| 1. Moving bending roller | 8. Angle stopper (Left & Right) |
| 2. Center roller | 9. Emergency stop button |
| 3. Adjustable stopper | 10. Plug-in for foot switch |
| 4. Main switch | 11. Roller set (not shown) |
| 5. Pilot lamp | 12. Foot Operated Switch (not shown) |
| 6. On/Off Button | |
| 7. Angle setter (dial type) | |



Products that make money, save money and add value to your bottom line

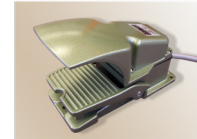


BN PRODUCTS-USA, LLC.

3450 Sabin Brown Road • Wickenburg, Arizona 85390
 (800) 992-3833 • (928) 684-2813 • www.bnproducts.com

SPECIFICATIONS

| | |
|------------------------------|--|
| Model | DBD-20M |
| Max. Bending Capacity | 3/4" (# 6) (19 mm) Grade 60 Rebar |
| Bending Angle | 0-180° |
| Bending Speed | 7 seconds for a 180° bend |
| Electric Power Supply | 115 Volts, 50/60 Hz, 15 amps, 1725 watts |
| Dimensions L x W x H (mm) | 16.4" x 18" x 16.2" (420) x (462) x (415) |
| Weight (Kg) | 134.5 lbs (61) |



DBD-20M Rebar Bender Roller Selection Chart

| Rebar Diameter Size | Center Roller | Moving Roller | # of Grade 60 Rebar Bent |
|---------------------|----------------------|----------------------|--------------------------|
| # 6 (3/4") (19mm) | # 4 (3.71" diameter) | # 2 (2.65" diameter) | 1 piece at one time |
| # 5 (5/8") (16 mm) | # 4 (3.71" diameter) | # 3 (2.93" diameter) | 2 pieces at one time |
| # 4 (1/2") (13 mm) | # 3 (2.93" diameter) | # 5 (3.90" diameter) | 3 pieces at one time |
| # 3 (3/8") (10 mm) | # 1 (2.22" diameter) | # 6 (4.80" diameter) | 4 pieces at one time |

PLEASE NOTE: CRSI (Concrete Reinforcing Steel Institute) recommends the finished inside bend diameter or center roller outside dimension for standard hooks be 6 times the bar diameter from #3 to #8, and 8 times the diameter for #9, #10 and #11 rebar. For #3, #4 and #5 stirrup hooks it's only 4 times the bar diameter, #6, #7 and #8 are again 6 times.

CHANGING ROLLERS OR ACCESSORIES.

WARNING: ALWAYS UNPLUG TOOL BEFORE CHANGING ROLLERS

1. Select and set the correct rollers for the bars to be bent. See **Rebar Bender Roller Selection Chart**
2. Plug the electrical power cord into an appropriate outlet.
3. Lay the bar on the machine surface between the center roller and bending roller. Adjust the

stopper so that the bar is parallel to the front edge of the machine.

4. Turn the main switch on and check that the pilot lamp has lit up.
5. Set the angle and make a test bend. If the bent angle is not exact, adjust the angle setter slightly to the right or left. Lock in the angle stoppers to duplicate the same angle each time.
6. Push the operation button or foot switch. The moving bending roller will automatically return to the start position once the bend has been completed.
7. If it is necessary to stop the machine in an emergency, push the emergency stop button or release your foot from the foot operated switch. The bending roller will return to the start position automatically.

Products that make money, save money and add value to your bottom line



BN PRODUCTS-USA, LLC.

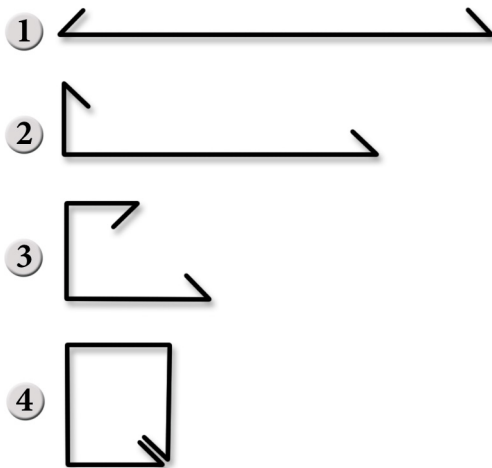
3450 Sabin Brown Road • Wickenburg, Arizona 85390
(800) 992-3833 • (928) 684-2813 • www.bnproducts.com

BENDING ANGLES CAN BE PRESET

1. Set the angle setter to 135° then tighten the right angle stopper to lock the 135° position.
2. Set the angle setter to 90° then tighten the left angle stopper to lock the 90° position.
3. Set the angle setter to 135°. Push the operation button to make your first bend.
4. Slide the rebar to the desired length and set the angle setter to 90°. Push the operation button to complete your second bend.

For stirrups, cut your rebar to the desired length before bending. Then make both bends for your turn downs. Finally make your (3) 90° bends to connect your ends together. See chart (below)

WARNING: Never touch any moving parts or rollers while the rebar bender is being operated.



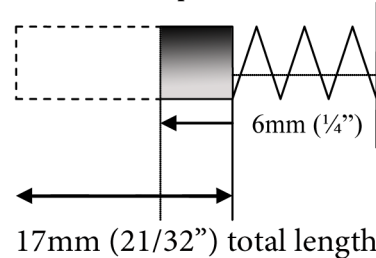
INSPECTION AND MAINTENANCE

WARNING: ALWAYS UNPLUG TOOL BEFORE PERFORMING MAINTENANCE.

DO NOT USE PARTS OR ACCESSORIES THAT ARE NOT GENUINE DIAMOND BRAND FROM: BN PRODUCTS-USA, LLC.

At least once a month remove the bottom plate and grease all the visible gears and pinions. At the same time, check the carbon brushes for wear or damage. Replace with new brushes if they are worn out. (wear limit → replace carbon brushes)

Wear Limit → Replace Carbon Brushes



1. Check that there are no loose nuts and bolts before starting the operation.
2. After operation is completed, be sure to remove metal dust, dirt, oil, etc... adhering to the machine surface.
3. In order to empty the metal dust from the bender, remove side cover (DBD-25X and DBD-32X models) then tilt the machine to one side allowing the debris to fall out of the catch pan. Be sure to blow out any remaining dirt and dust with compressed air prior to using the tool again (wear safety goggles to block blowing debris).

CUSTOMER SERVICE:

(800) 992-3833
mail@bnproducts.com

Products that make money, save money and add value to your bottom line



BN PRODUCTS-USA, LLC.

3450 Sabin Brown Road • Wickenburg, Arizona 85390
(800) 992-3833 • (928) 684-2813 • www.bnproducts.com

DBD-16H PORTABLE #5 MINI REBAR BENDER



Capable of bending No. 5 (5/8") Grade 60 Rebar 180°

- Bending speed is 0 to 180° in less than 5 seconds and it only pulls 9.5 Amps (115V 50/60Hz).
- This is a electric/mechanical bender and only weighs 49 lbs.
- This tool has a removable table and a convenient carrying handle. Ideal for quick on-site rebar bending.



PRODUCT No. DESCRIPTION
DBD-16H Portable Rebar Bender

DBD-16X PORTABLE #5 REBAR BENDER



Easy to handle in-field portable rebar bender.

- Maximum bending diameter for this tool is 5/8" grade-60 rebar.
- Bending speed is 0 to 180° in less than 5 seconds only pulls 10 amps.
- This is a electric/mechanical bender with a 6 piece bending roller set and only weighs 90 lbs.
- This tool can lock-in two different bending angles and has an emergency stop feature.



PRODUCT No. DESCRIPTION
DBD-16X Portable Rebar Bender

DBD-20M PORTABLE #6 JOB SITE REBAR BENDER



Capable of bending No. 6 (3/4") Grade 60 Rebar 180°

- Bending speed is 0 to 180° in less than 6 seconds and pulls 10 amps.
- This is a electric/mechanical bender with a 6 piece bending roller set and only weighs 147 lbs.
- This tool can lock-in two different bending angles and has an emergency stop feature.



PRODUCT No. DESCRIPTION
DBD-20M Portable Rebar Bender

DBD-25X PORTABLE #7 REBAR BENDER



The most popular in-field rebar bender in the USA

- Maximum bending diameter for this tool is 7/8" grade-60 rebar.
- Bending speed is 0 to 180° in less than 6 seconds only pulls 12 amps.
- This is a electric/mechanical bender with a 6 piece bending roller set and only weighs 190 lbs.
- This tool can lock-in two different bending angles and has an emergency stop feature.



PRODUCT No. DESCRIPTION
DBD-25X Portable Rebar Bender

DBD-25H PORTABLE #8 REBAR BENDER



One of the best selling rebar benders in the USA

- Maximum bending diameter for this tool is 1" grade-60 rebar.
- Bending speed is 0 to 180° in less than 9 seconds only pulls 15 amps.
- This is a electric/mechanical bender with a 6 piece bending roller set and only weighs 210 lbs.
- This tool can lock-in two different bending angles and has an emergency stop feature.



PRODUCT No. DESCRIPTION
DBD-25H Portable Rebar Bender

DBD-32X TABLE-TOP #9 REBAR BENDER



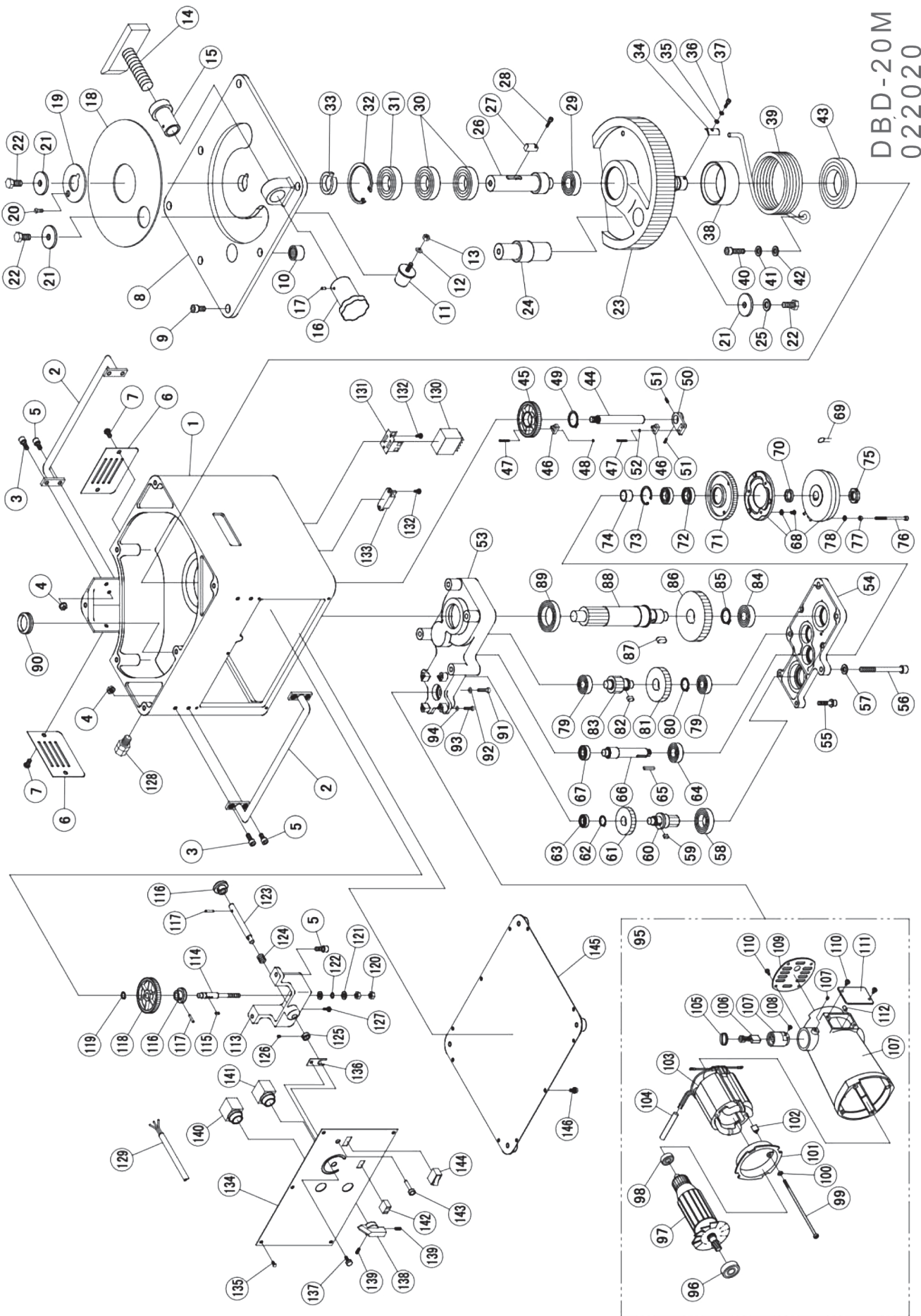
Ideal for small and medium size production shops

- Maximum bending diameter for this tool is 1-1/8" (#9) grade-60 rebar.
- Bending speed is 0 to 180° in less than 8 seconds and pulls 12 amps.
- This is a electric/mechanical bender comes with a complete radius roller set, an emergency stop feature, a hands-free foot pedal and can lock-in two separate bending angles.



PRODUCT No. DESCRIPTION
DBD-32X Portable Rebar Bender

Products that make money, save money and add value to your bottom line



DBD-20M
022020

| No. | Part No. | Part Name | Qty |
|-----|-------------|-------------------------------|-----|
| 1 | 1BL51028500 | FRAME | 1 |
| 2 | 1BL5303401 | HANDLE | 2 |
| 3 | 7CB08020 | CAP BOLT M8X20 | 4 |
| 4 | 7NS008 | NUT W/DISC SPRING 8 | 4 |
| 5 | 7CB08015 | CAP BOLT M8X15 | 4 |
| 6 | 1BL5402801 | BRUSH COVER | 2 |
| 7 | 7PB08015 | PAN HEAD BOLT M8X15 | 4 |
| 8 | 1BL51028700 | BASE PLATE | 1 |
| 9 | 7CB10020 | CAP BOLT M10X20 | 7 |
| 10 | 7TAF243220 | NEEDLE BEARING TAF243220 | 1 |
| 11 | 7KI40 | ANTI-VIBRATION RUBBER (KI-40) | 1 |
| 12 | 7SW008 | SPRING WASHER 8 | 1 |
| 13 | 7N008 | NUT M8 | 1 |
| 14 | 1BL54265800 | ADJUSTABLE STOPPER | 1 |
| 15 | 1BR5064 | ADJUSTABLE NUT S45C50X74 | 1 |
| 16 | 1BR5065 | ADJUSTABLE HANDLE | 1 |
| 17 | 7SP05008W | SPRING PIN M5X8 | 2 |
| 18 | 1BL54265600 | CENTER COVER | 1 |
| 19 | 1BL54265700 | CENTER PLATE | 1 |
| 20 | 7SB06015 | CAP BOLT M6X15 | 1 |
| 21 | 1BL5402000 | WASHER | 3 |
| 22 | 7B12025T11 | BOLT (11T) M12X25 | 3 |
| 23 | 1BL5101503 | SWIVEL GEAR | 1 |
| 24 | 1BL54265300 | SWIVEL SHAFT | 1 |
| 25 | 7SW012 | SPRING WASHER 12 | 1 |
| 26 | 1BL53136600 | MAIN SHAFT | 1 |
| 27 | 1BL54265200 | KEY (4) | 1 |

| | | | |
|----|-------------|-------------------------------|---|
| 28 | 7CB05018 | CAP BOLT 5X18 | 1 |
| 29 | 76205ZZ | BEARING 6205ZZ | 1 |
| 30 | 76207ZZ | STOPPER CRESCENT TYPE 5103-18 | 2 |
| 31 | 762072RS | BEARING 62072RS | 1 |
| 32 | 7SRH072 | C TYPE STOP RING 72 FOR HOLE | 1 |
| 33 | 1BL54265400 | SHAFT COLLAR | 1 |
| 34 | 1BL5403200 | LS DOCK | 1 |
| 35 | 7PW005 | PLATE WASHER 5 | 1 |
| 36 | 7SW005 | SPRING WASHER 5 | 1 |
| 37 | 7CB05008 | CAP BOLT M5X8 | 1 |
| 38 | 1BL5402200 | SPRING COLLAR | 1 |
| 39 | 1BL53136700 | RETURN SPRING | 1 |
| 40 | 7CB10035 | CAP BOLT M10X35 | 1 |
| 41 | 7SW010 | SPRING WASHER 10 | 1 |
| 42 | 7PW010 | PLATE WASHER 10 | 1 |
| 43 | 762122RS | BEARING 62122RS | 1 |
| 44 | 1BL5401700 | MAIN SHAFT SUPPORT | 1 |
| 45 | 1BL9404400 | ANGLE GEAR (B) | 1 |
| 46 | 7SS5GL2 | LIMIT SWITCH SS5GL2 | 2 |
| 47 | 7PB2.3015 | TAPPING SCREW M2.3X15 | 4 |
| 48 | 7N002.3 | NUT M2.3 | 2 |
| 49 | 7SRS030 | C TYPE STOP RING 30 FOR SHAFT | 1 |
| 50 | 1BL5403102 | OVERRUN LS STAY | 1 |
| 51 | 7SS04008 | SET SCREW M4X8 | 2 |

| | | | |
|----|-------------|------------------------------|---|
| 52 | 7SW002.3 | SPRING WASHER 2.3 | 2 |
| 53 | 1BL51028600 | GEAR CASE (A) | 1 |
| 54 | 1BL5100300 | GEAR CASE (B) | 1 |
| 55 | 7CW08035 | CAP BOLT M8X35 | 4 |
| 56 | 7CB10110 | CAP BOLT M10X110 | 4 |
| 57 | 7GW010 | WASHER 10 | 4 |
| 58 | 76006ZZ | BEARING 6006ZZ | 1 |
| 59 | 7K0606012R2 | KEY 6X6X12 | 1 |
| 60 | 1BL5400502 | PINION (1) | 1 |
| 61 | 1BL5400402 | GEAR (1) | 1 |
| 62 | 7SRS020 | SNAP RING | 1 |
| 63 | 76902ZZ | BEARING 6902ZZ | 1 |
| 64 | 76004ZZ | BEARING 6004ZZ | 1 |
| 65 | 7K0505028R1 | KEY 5X5X28 | 1 |
| 66 | 1BL5400802 | PINION (2) | 1 |
| 67 | 76002ZZ | BEARING 6002ZZ | 1 |
| 68 | 1BDL401162 | CLUTCH TMC 2.5KW | 1 |
| 69 | 7TND14V471K | VARISTOR TND14V-471KB00AAAA0 | 2 |
| 70 | 1BDL400280 | COLLAR | 1 |
| 71 | 1BDL400242 | CLUTCH GEAR | 1 |
| 72 | 76904ZZ | BEARING 6904ZZ | 2 |
| 73 | 7SRH037 | S TYPE STOP RING 37 FOR HOLE | 1 |
| 74 | 1BL5400700 | CLUTCH COLLAR | 1 |
| 75 | 7FU02SC | FINE U NUT | 1 |
| 76 | 7CB05080 | CAP BOLD M5X80 | 1 |
| 77 | 7N005 | NUT M5 | 1 |
| 78 | 7SW005 | SPRING WASH-ER 5 | 1 |
| 79 | 76203ZZ | BEARING 6203ZZ | 2 |
| 80 | 7SRS025 | S TYPE STOP RING 25 FOR HOLE | 1 |

| No. | Part No. | Part Name | Qty |
|-----|-------------|-------------------------------|-----|
| 81 | 1BL5400902 | GEAR (2) | 1 |
| 82 | 7K0807015R2 | KET 8X7X15 | 1 |
| 83 | 1BL5401002 | PINION (3) | 1 |
| 84 | 76204ZZ | BEARING 6204ZZ | 1 |
| 85 | 7SRS030 | C TYPE STOP RING 30 FOR SHAFT | 1 |
| 86 | 1BL5401202 | GEAR (3) | 1 |
| 87 | 7K1008023R2 | KEY 10X8X23 | 1 |
| 88 | 1BL53136500 | PINION (4) | 1 |
| 89 | 76909ZZ | BEARING 6909ZZ | 1 |
| 90 | 7V40S | V RING (40S) | 1 |
| 91 | 7CB06025 | CAP BOLT M6X15 | 2 |
| 92 | 7GW006 | WASHER 6 | 2 |
| 93 | 7CB05020 | CAP BOLT M5X20 | 2 |
| 94 | 7GW005 | WASHER 5 | 2 |
| 95 | 7UML8 | MOTOR ASSEMBLY 95 - 112 | 1 |
| 96 | 76202ZZ | BEARING 6202ZZ | 1 |
| 97 | 7M315320G01 | ROTOR (100V) | 1 |
| 98 | 76200ZZ | BEARING 6200ZZ | 1 |
| 99 | 7PB05100 | TAPPING SCREW M5X100 | 2 |
| 100 | 7SW005 | SPRING WASHER 5 | 2 |
| 101 | 7P304229H01 | FAN GUIDE | 1 |
| 102 | 7P850966H01 | BRACKET | 1 |
| 103 | 7M315321G01 | STATOR (100V) | 1 |
| 104 | 7WT06110 | VARNISH TUBE Ø6X110 | 1 |
| 105 | 7P504595H01 | BRUSH CAP | 2 |
| 106 | 7P442416G01 | BRUSH | 2 |
| 107 | 7P445180G01 | FLAME SET W/ BRUSH HOLDER | 1 |
| 108 | 7P203006BS | TAPPING SCREW M3X6 | 2 |
| 109 | 7P858310H01 | END COVER | 1 |

| | | | |
|-----|-------------|------------------------|---|
| 110 | 7P205008 | TAPPING SCREW M5X8 | 6 |
| 111 | 7P445701H01 | COVER | 1 |
| 112 | 7P443817H01 | RUBBER PIN | 1 |
| 113 | 1BL9303802 | ANGLE STAND | 1 |
| 114 | 1BL9404200 | ANGLE SHAFT (B) | 1 |
| 115 | 7K0404010R2 | KEY 4X4X10 | 1 |
| 116 | 1BL9403900 | ANGLE PLATE | 2 |
| 117 | 7SP04020W | SPRING PIN M4X20 | 2 |
| 118 | 1BL9404300 | ANGLE GEAR (A) | 1 |
| 119 | 7SRS012 | SNAP RING | 1 |
| 120 | 7N008 | NUT M8 | 2 |
| 121 | 7PW008 | PLATE WASHER 8 | 2 |
| 122 | 7WW008 | WAVE WASHER 8 | 1 |
| 123 | 1BL54265900 | ANGLE SHAFT (A) | 1 |
| 124 | 1BL9405900 | ANGLE SPRING | 1 |
| 125 | 1BL9404100 | ANGLE COLLAR | 1 |
| 126 | 7SS04004 | SET SCREW 4X4 | 1 |
| 127 | 7NT304016 | TAPPING SCREW M4X16 | 1 |
| 128 | 7AG1610B | CABLE GRAND (AG16-10B) | 1 |
| 129 | 1BDL401180 | CORD W/GRIP | 1 |
| 130 | 7G7J4AT | RELAY G7J4AT AC100 | 1 |
| 131 | 7R9904 | BRACKET R99-04 | 1 |
| 132 | 7P304012 | TAPPING SCREW M4X12 | 4 |
| 133 | 7ORM0309FS | CLUTCH POWER | 1 |
| 134 | 1BL52070300 | CONTROL PANEL | 1 |
| 135 | 7TS05010 | SCREW M5X10 | 6 |
| 136 | 1BL5404200 | ANGLE PLATE | 2 |
| 137 | 7YB05015 | BUTTON SCREW M5X15 | 2 |
| 138 | 1BL9404501 | ANGLE SETTER | 1 |
| 139 | 7SS05010 | SET SCREW M5X10 | 2 |

| | | | |
|-----|----------------------------|--------------------------------|----|
| 140 | 7ABS110N | START-UP SWITCH ABS110N | 1 |
| 141 | 7ABS201NR | EMERGENCY STOP SWITCH | 1 |
| 142 | 7ACT03FB03 | OUTLET | 1 |
| 143 | 7NB106PWF | PILOT LAMP | 1 |
| 144 | 7AJ8101B | MAIN SWITCH | 1 |
| 145 | 1BL53136800 | BOTTOM PLATE | 1 |
| 146 | 7B206012 | BOLT M6X12 | 10 |
| * | 1BL52071400AS Not Shown | DBD20M STAND SET | 1 |
| * | 1BL54035ST Not Shown | ROLLER SET (DBD20M) (20M) | 1 |
| * | 1BDL401190A Not Shown | FOOT SWITCH OFL-55SM2C W/ PLUG | 1 |



DBD-20M PORTABLE #6 JOB SITE REBAR BENDER

Capable of bending No. 6 (3/4") Grade 60 Rebar 180°

- Bending speed is 0 to 180° in less than 6 seconds and pulls 10 amps.
- This is a electric/mechanical bender with a 6 piece bending roller set and only weighs 147 lbs.
- This tool can lock-in two different bending angles and has an emergency stop feature.



PRODUCT No. DESCRIPTION
DBD-20M Portable Rebar Bender