



BN Products-USA, LLC.

3450 Sabin Brown Road • Wickenburg, Arizona 85390

(800) 992-3833 • (928) 684-2813 • www.bnproducts.com

Recommended Bending Roller Selection Chart

for DBD-25H Bender on Standard Hook Details

Combination of Center Roller and Moving Roller according to the bar size:

Bar Diameter Size Max. Grade 60	Center Roller #	Center Roller Outside Diameter	CRSI Recommended Inside Bend Diameter	Moving Roller	No. of bars that can be bent
1" (25mm) #8	No. 7	5.97" (153mm)	6.00" (155mm)	No. 1	1 -Piece
7/8" (22mm) #7	No. 6	5.15" (132mm)	5.25" (135mm)	No. 3	1 -Piece
3/4" (19mm) #6	No. 4	4.45" (114mm)	4.50" (115mm)	No. 5	2 -Pieces
5/8" (16mm) #5	No. 3	3.63" (93mm)	3.75" (95mm)	No. 6	2 -Pieces
1/2" (13mm) #4	No. 2	3.09" (79mm)	3.00" (80mm)	No. 8	3 -Pieces
3/8" (10mm) #3	No. 1	2.54" (65mm)	2.25" (60mm)	No. 9	4 -Pieces

**** Use a second No. 4 Roller on moving roller to produce a complete 180° Bend.**

Recommended Bending Roller Selection Chart

for DBD-25H Bender on Stirrup Hooks

Combination of Center Roller and Moving Roller according to the bar size:

Bar Diameter Size Max. Grade 60	Center Roller #	Center Roller Outside Diameter	*ACI Recommended Inside Bend Diameter	Moving Roller	No. of bars that can be bent at one time
5/8" (16mm) #5	No. 1	2.54" (65mm)	2.50" (51mm)	No. 8	2 -Pieces
1/2" (13mm) #4	Special *	1.95" (50mm)	2.00" (51mm)	No. 9	3 -Pieces
3/8" (10mm) #3	**	1.57" (42mm)	1.50" (38mm)	No. 9	4 -Pieces

*** Requires optional roller #1BR5140 used on DBD-25X bender**

**** Use roller shaft only with no roller, shaft outside diameter 1.57"**

Bending Roller Sizes for DBD-25H Rebar Bender	
Part Number -Roller Number	Outside Diameter
#1BR4212500 -No. 1	2.54" (65mm)
#1BR4212600 -No. 2	3.09" (79mm)
#1BR4207000 -No. 3	3.63" (93mm)
#1BR4207201 -No. 4	4.45" (114mm)
#1BR4207101 -No. 5	4.45" (114mm)
#1BR4207300 -No. 6	5.15" (132mm)
#1BR4212800 -No. 7	5.97" (153mm)
#1BR4209600 -No. 8	6.48" (166mm)
#1BR4212900 -No. 9	7.14" (183mm)



Information from CRSI -Concrete Reinforcing Steel Institute, www.crsi.org

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