## PROPER BENDING TECHNIQUE Insufficent Bend Radius Can Cause Paint To "Craze" Or Crack On Outside Of Bend. Base Metal And/Or Metallic Coating Can Fracture Causing Potential Corrision At Bend. O Thickness Bend Radius (Outside Of Warranty Limits) 2x Metal Thickness Minimum Bend Radius.

Folded Over Seam/Hem With Bend Radius

Proper Bend Radius Maintains Quality Of Paint And Base Metal

EXAMPLE: 0.032 Aluminum x 2 = 0.064 Minimum Bend Radius

Tech Tip: Increasing the bend radius may be achieved by using tooling with a larger punch tip radius and wider die opening on press brakes, adjusting the clamping tool back on manual folding machines, or lowering the folding beam on auto-folders.

Proper Bend Radius As Noted In Warranty

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