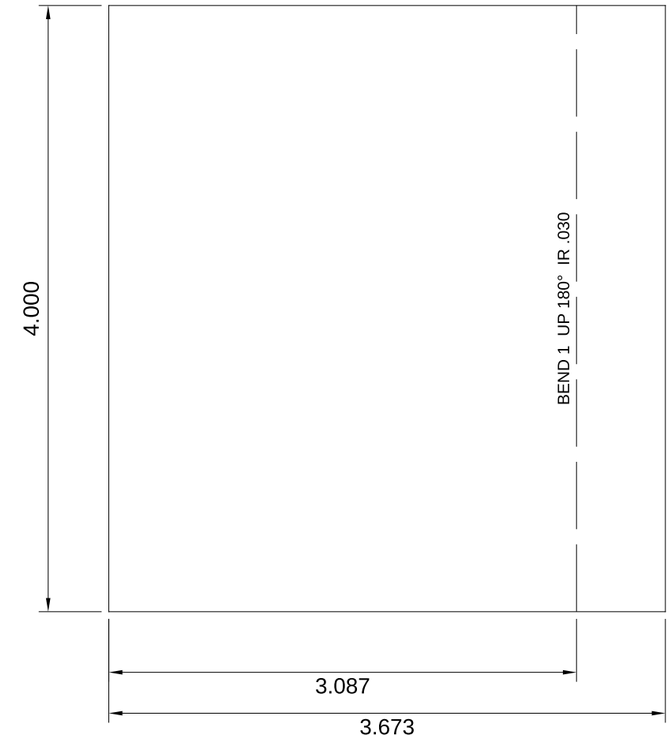


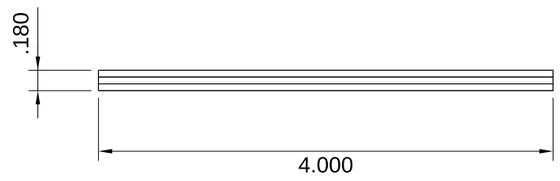
FLAT PATTERN

SCALE 1:1 · K = 0.42 · BEND ALLOWANCE PER BEND TABLE

VIEWS SCALE 3:4

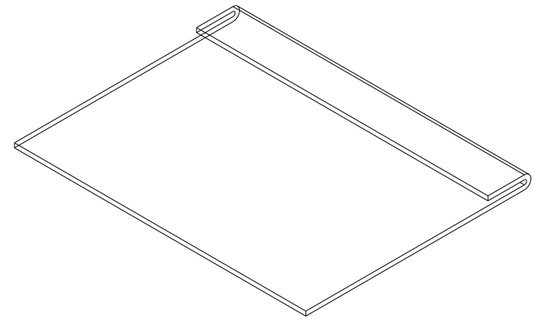


TOP

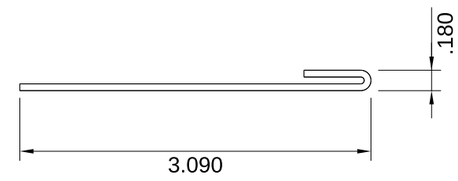


FRONT

IR .030



ISOMETRIC (REF)



RIGHT

BEND TABLE

BEND	DIR	ANGLE	INSIDE R	K	BEND ALLOW.
1	UP	180°	.030	0.42	0.1731

NOTES:

1. MATERIAL: MILD STEEL, HOT ROLLED P&O (ASTM A1011 CS TYPE B), 0.0598 THK.
2. FLAT PATTERN DEVELOPED WITH THE K-FACTOR AND RADII IN THE BEND TABLE; SHOP MAY ADJUST TO ITS TOOLING. FORMED DIMENSIONS GOVERN.
3. BEND LINES ARE SHOWN DASHED AT THE CENTRE OF EACH BEND ZONE.
4. DEBURR ALL CUT EDGES. NO BURRS ON HOLE EDGES.
5. PART MARKING: NONE. PACK FLAT, NO SCRATCHES ON VISIBLE FACES.
6. TEST DRAWING FOR QUOTE CHECKS. NOT FOR PRODUCTION.

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES
TOLERANCES:
X.XX ±.010 X.XXX ±.005
FORMED DIMS ±.015
BEND ANGLES ±1°
HOLE ⌀ +.005 / -.000
BREAK SHARP EDGES .010 MAX
THIRD ANGLE PROJECTION

COLDBROOK FABRICATION & MACHINE				ROCKFORD, IL
TITLE: PROBLEM: OPEN HEM (180° BEND)				PART NO.: CB-PROBLEM-OPEN-HEM-16GA
MATERIAL: MILD STEEL, HOT ROLLED P&O (ASTM A1011 CS TYPE B)			THICKNESS: 16 GA (0.0598)	WEIGHT: 0.25 LB
SCALE: AS NOTED	UNITS: INCH	K-FACTOR: 0.42	FINISH: PER PO	SHEET: 1 OF 1
DRAWN: J. HALVERSEN	DATE: 2026-10-13	SIZE: B	REV: A	FLAT BLANK: 3.673 X 4.000