PAC BENDING GUIDELINES

METAL BENDING GUIDELINES

Proper bending techniques must be followed when fabricating PAC-CLAD steel and aluminum. Failure to follow bending guidelines can result in product and/or paint failure. To remain in compliance with Petersen's finish warranty for PAC-CLAD metal, follow the guidelines outlined in this document.

BENDING TOLERANCES

The PAC-CLAD finish is engineered to be durable, but it can be stretched, cracked or exhibit compromised adhesion if bent beyond its tensile strength limits. Additionally, metal can crack, fracture or become weakened if bent improperly. The following tolerances apply when bending PAC-CLAD metal into 180-degree angles.

MATERIAL THICKNESS	BEND TYPE
.032" aluminum	2T
.040" aluminum	2T
.050" aluminum	2T
.063" aluminum	2T
22 gauge steel	2T
24 gauge steel	2T

FINISH WARRANTY COMPLIANCE

Reference to proper bending of Petersen's PAC-CLAD metal can be found in Part II, Section 3 of the 30-year finish warranty as follows:

"This warranty does not apply to failure of the coating in the following additional circumstances: forming where the bend is tighter than 2T, forming which involves severe reverse bending, or which subjects the coating to alternate compression and tension..."

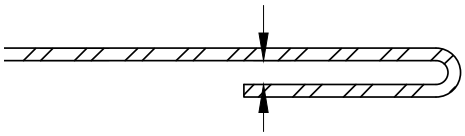
TERMINOLOGY

Metal bends are given descriptions such as 0T, 1T, 2T, etc., where T refers to the thickness of metal. These designations are used to measure the inner radius of the bend applied to sheet metal in a 180-degree bend. Typical bends are defined as follows:

RECOMMENDED

2T BEND (TWO-T BEND)

The inside radius of the bend is equal to 2x the metal thickness.

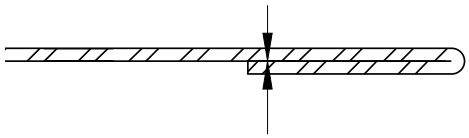


2x the metal thickness

VOIDS WARRANTY

0T BEND (ZERO-T BEND)

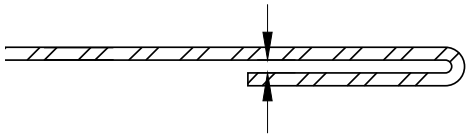
Inside radius of the bend is zero. The legs of the bend are fully compressed together.



0x the metal thickness

1T BEND (ONE-T BEND)

The inside radius of the bend is equal to 1x the metal thickness.



1x the metal thickness

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