

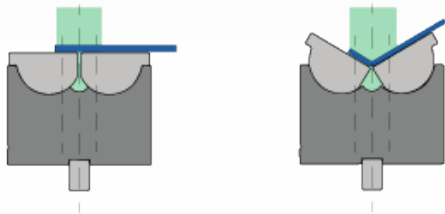
## V-SERIES BLACK USAGE TIPS

### Flange Length and Sheet Placement

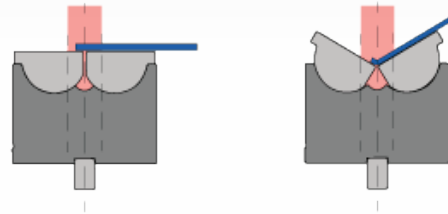
- Tools work most efficiently when the full length is used.
- Material to be bent should be centered on the tool.
- The bend length should not be less than 60% on a roller.
- Use an 88° or more acute punch where possible to form a 90° bend.
- Center sheet on rollers for maximum accuracy.

#### Flange Length

The **recommended** flange length is long enough to cover at least 60% of the rollers.

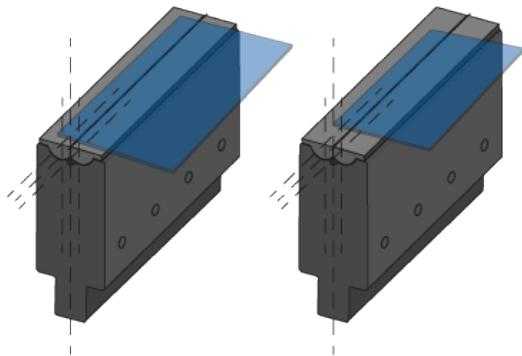


A flange that is too short (less than 60% of roller coverage) is **not recommended**.

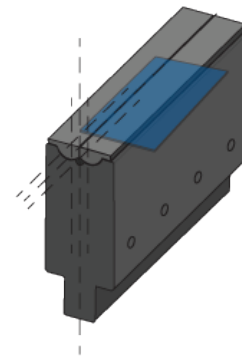


#### Sheet Placement

**Maximum accuracy** is obtained when the sheet is centered on the rollers.



**Decreased accuracy** occurs when the sheet is not centered on the rollers.



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