

NOTE: USE AT YOUR OWN RISK.

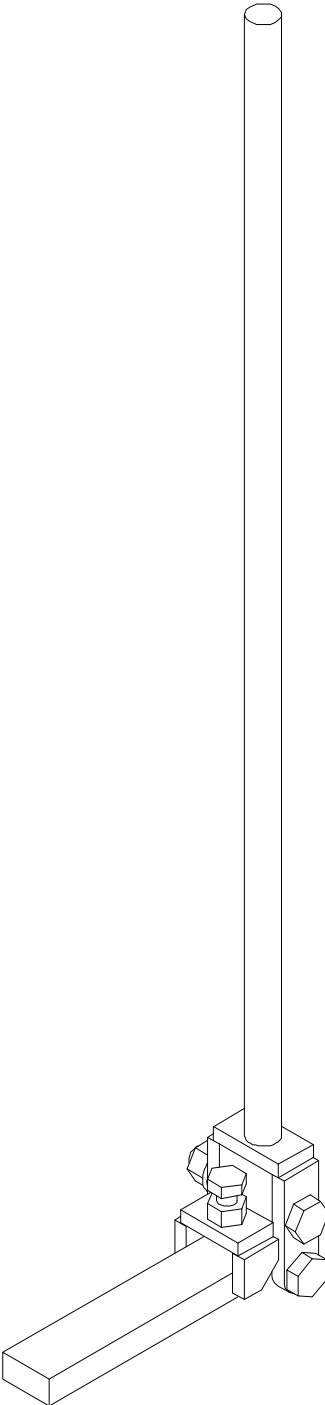
AWS D1.1: 2015, Fig. 4.12 - FOR MATERIAL $\frac{3}{8}$ " THICK AND YIELD STRENGTH OF 50 KSI (345 MPa) AND UNDER.

CSA W47.1 - 09, Fig. 18: FOR MATERIAL $\frac{3}{8}$ " THICK AND YIELD STRENGTH OF 345 MPa AND UNDER.

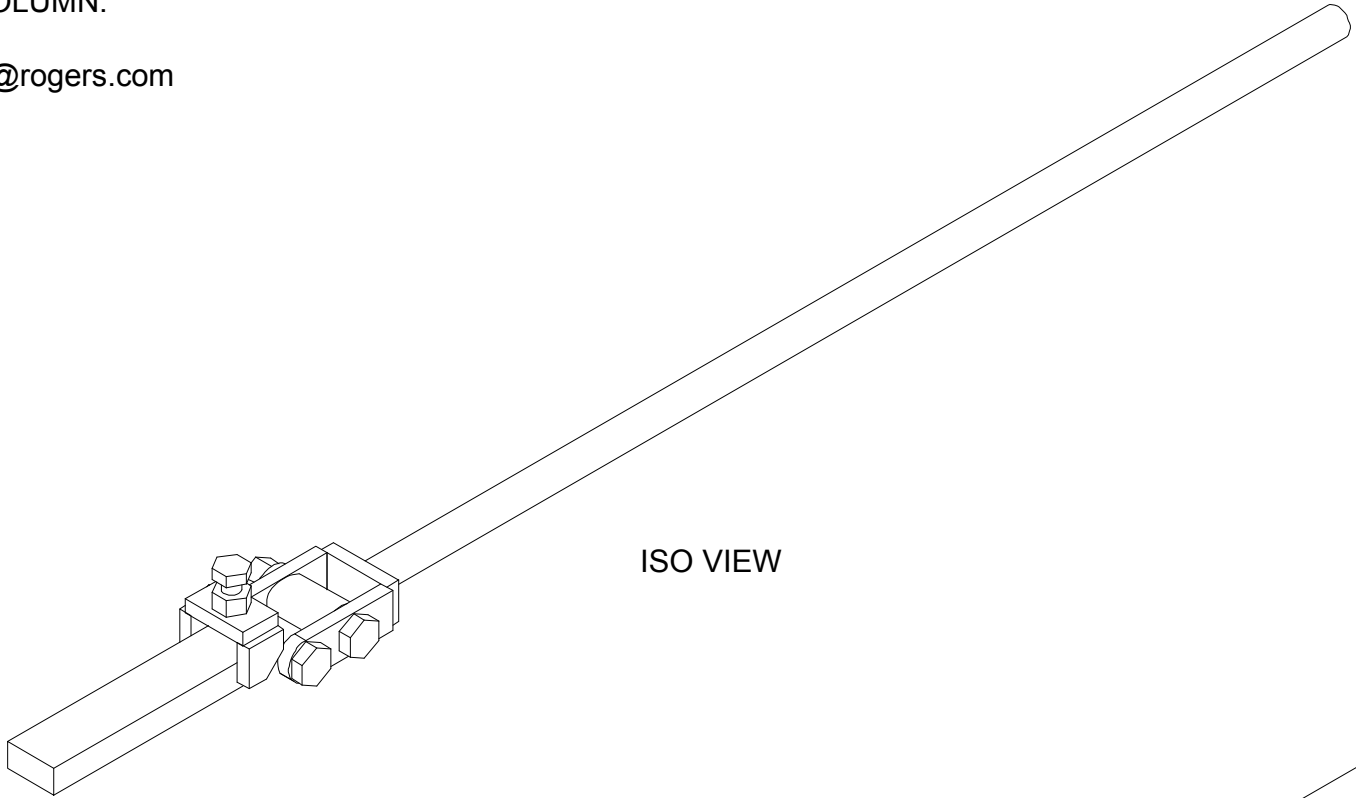
SHOP VICE SHOULD BE BOLTED TO A TABLE OR COLUMN.

DRAWING SIZE: 11x17.

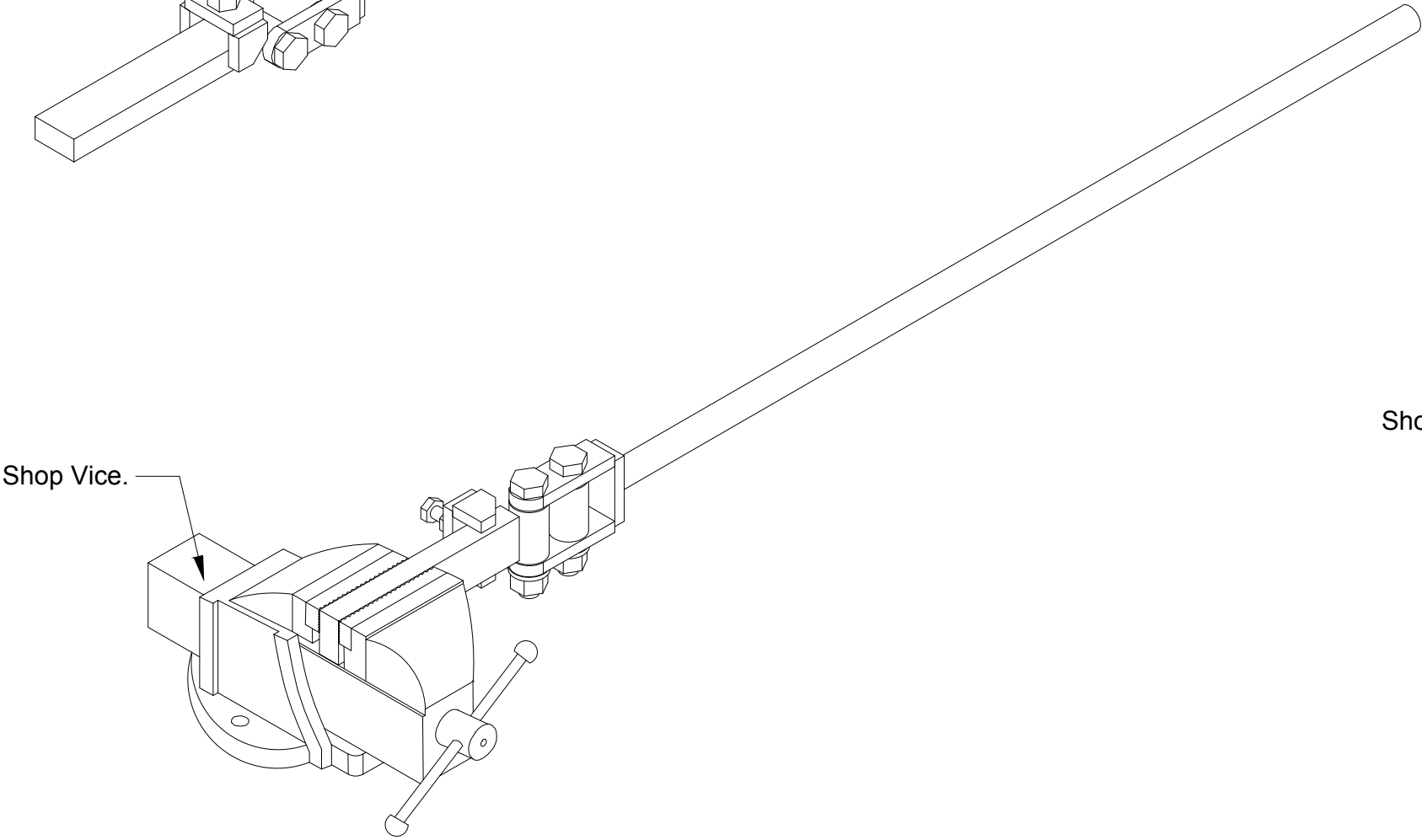
QUESTIONS OR TECH. SUPPORT? email: raycormier@rogers.com



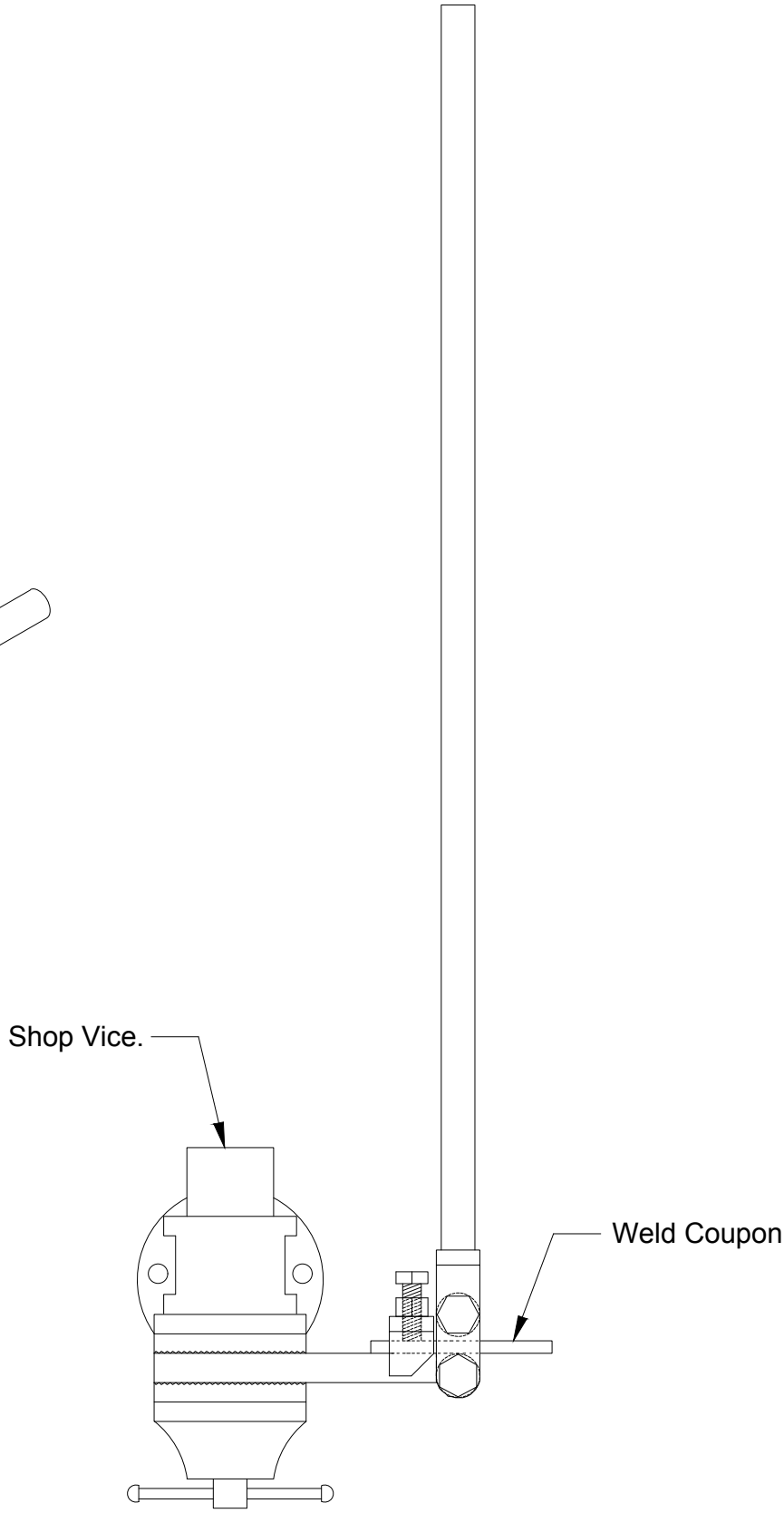
ISO VIEW IN BENDING POSITION



ISO VIEW



ISO VIEW

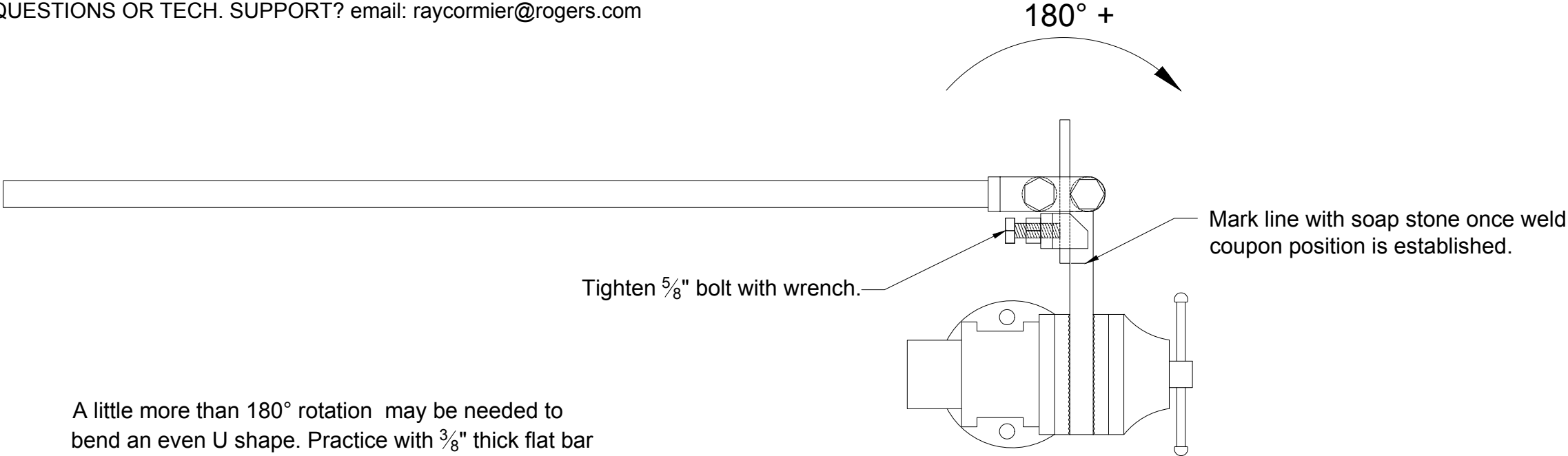


PLAN VIEW IN BENDING POSITION

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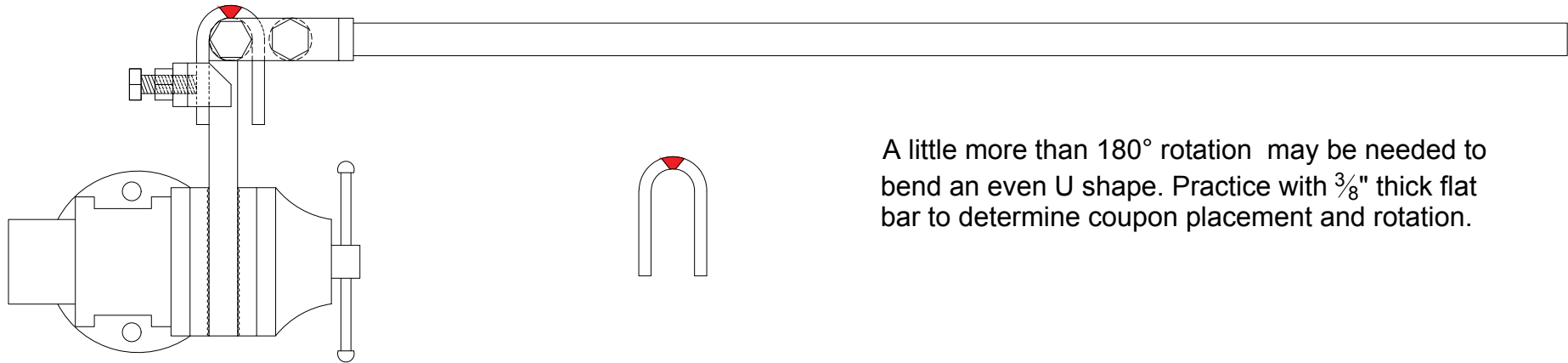
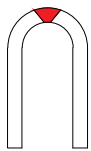
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A little more than 180° rotation may be needed to bend an even U shape. Practice with 3/8" thick flat bar the length of your weld coupon. Determine coupon placement and rotation so weld coupon will be bent properly. Mark line with soap stone.

WRAPAROUND GUIDED BEND TEST JIG IN START POSITION.



A little more than 180° rotation may be needed to bend an even U shape. Practice with 3/8" thick flat bar to determine coupon placement and rotation.

Wraparound Guided Bend Test Jig in finished position.

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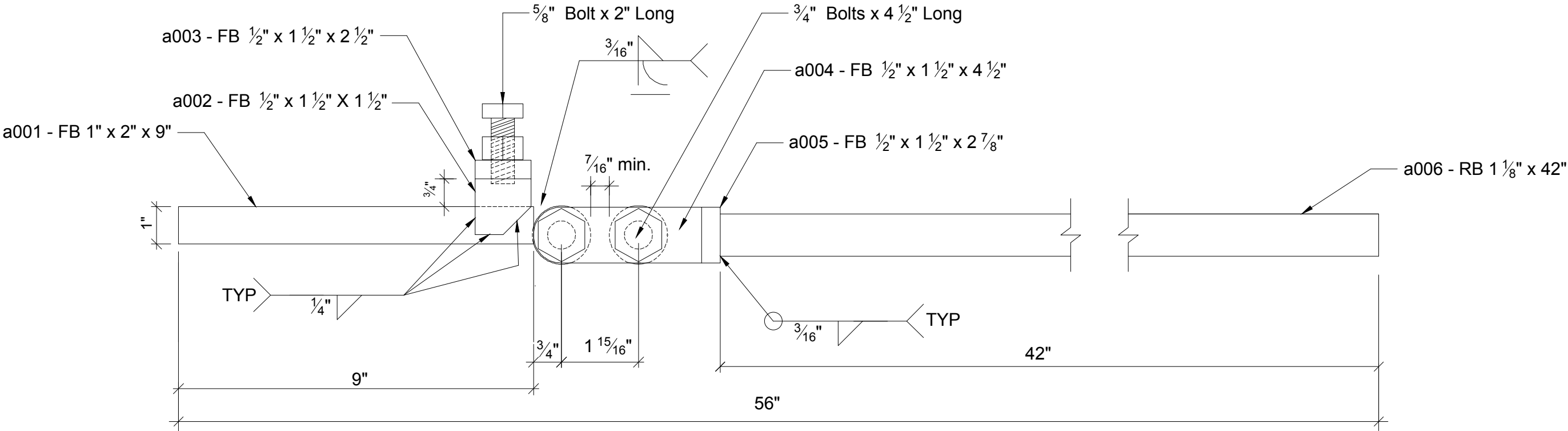
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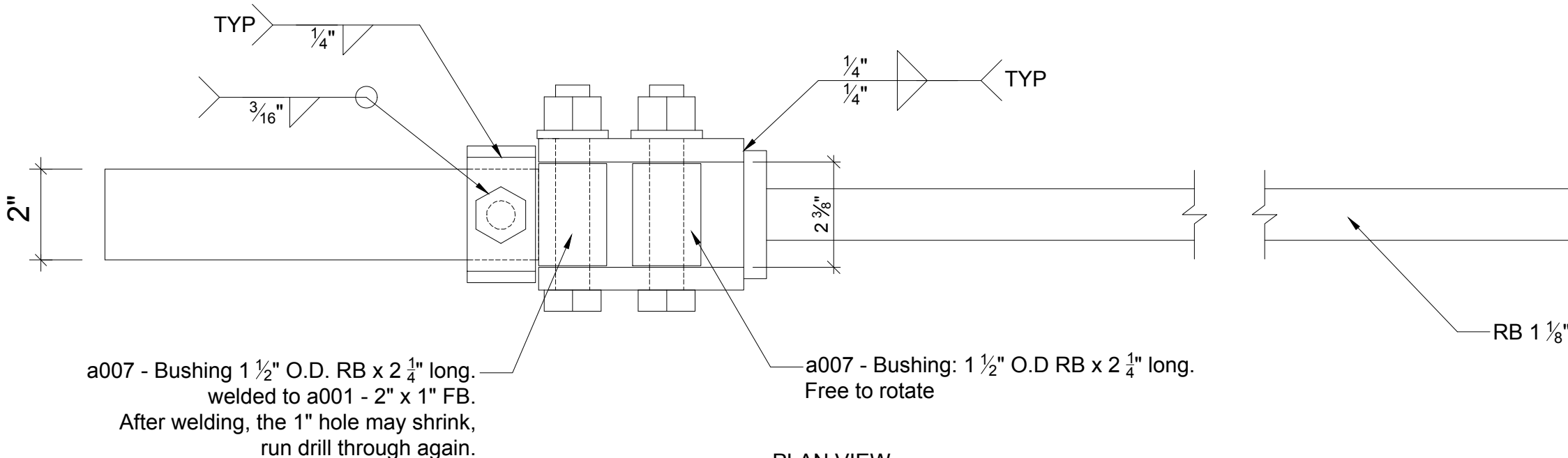
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ELEVATION VIEW



PLAN VIEW

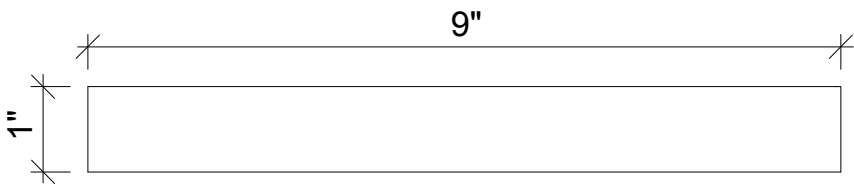
a007 - Bushing 1 1/2" O.D. RB x 2 1/4" long.
welded to a001 - 2" x 1" FB.
After welding, the 1" hole may shrink,
run drill through again.

a007 - Bushing: 1 1/2" O.D RB x 2 1/4" long.
Free to rotate

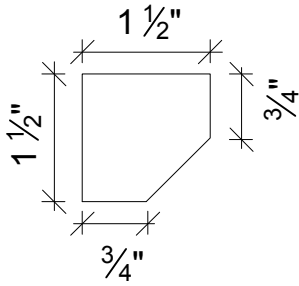
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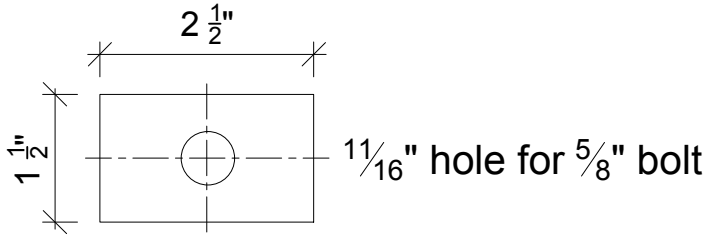
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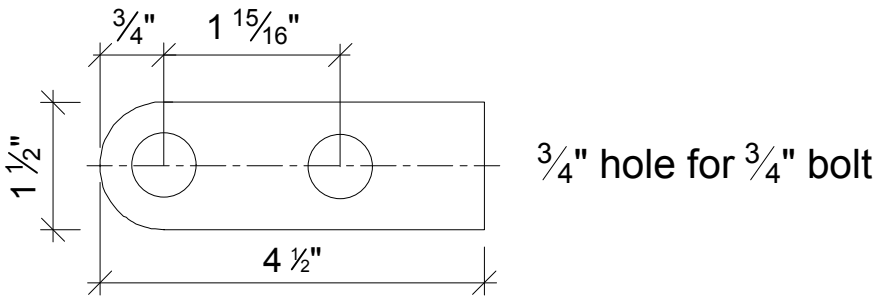
a001 - FB 1" x 2" x 9"
1 required
Material: A36, 300W



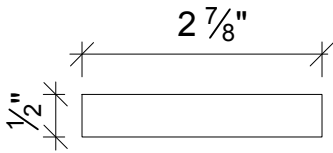
a002 - FB 1/2" x 1 1/2" X 1 1/2"
2 required
Material: A36, 300W



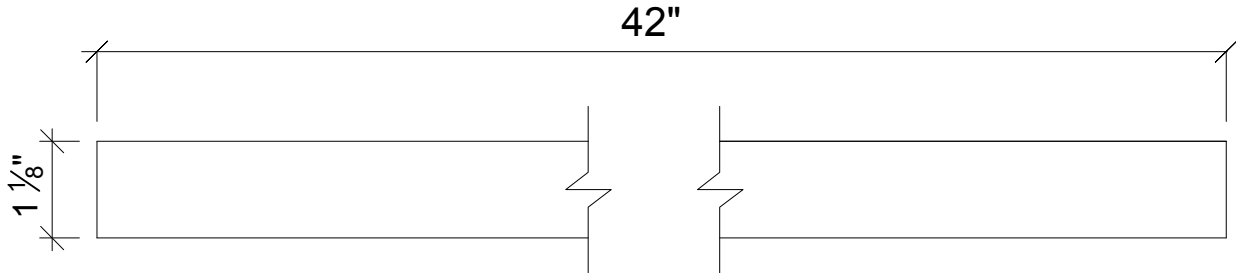
a003 - FB 1/2" x 1 1/2" x 2 1/2"
1 required
Material: A36, 300W



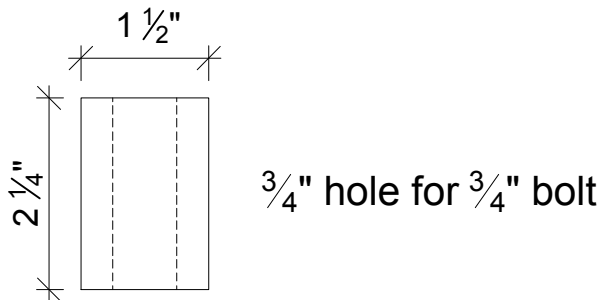
a004 - FB 1/2" x 1 1/2" x 4 1/2"
2 required
Material: A36, 300W



a005 - FB 1/2" x 1 1/2" x 2 7/8"
1 required
Material: A36, 300W



a006 - RB 1 1/8" x 42"
1 required
Material: A36, 300W



a007 - Bushing 1 1/2" O.D. RB x 2 1/4" long.
2 required
Material: A36, 300W

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