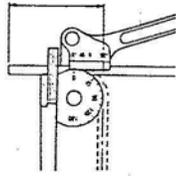
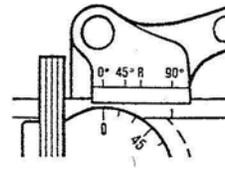


Tube Alignment for 90° Bends

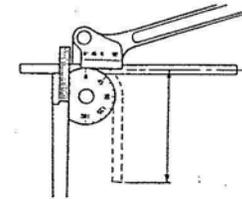
Measure and mark tubing according to the appropriate dimensions and set-up tools as outlined before.



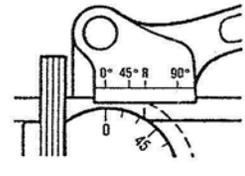
a. If the desired dimension is left of center ...



... align the MARK with the 90° DESIGNATION on the SHOE

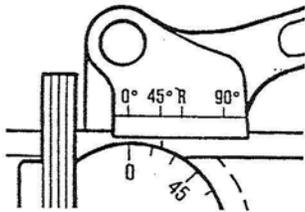


b. If the desired dimension is right of center ...



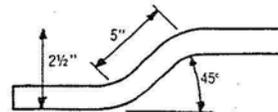
... align the MARK with the "R" DESIGNATION on the SHOE

Tube Alignment for 45° Bends



1. Measure and mark the location of the bend. Set-up tool.
2. Position the tube so that the MARK aligns with the 45° DESIGNATION on the SHOE.

45° Double Bend Offsets



1. To form an offset, measure and mark the locations of both bends before bending the tubing. - 2. The dimension separating the bend locations is always twice the offset dimension. For instance, a 2 1/2" offset requires a 5" dimension between bend locations; a 3" offset requires a 6" dimension, and so on.