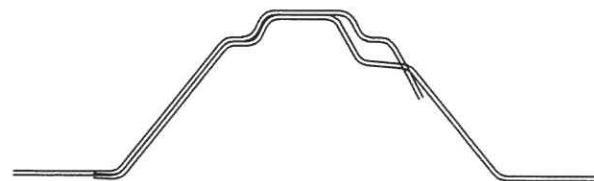
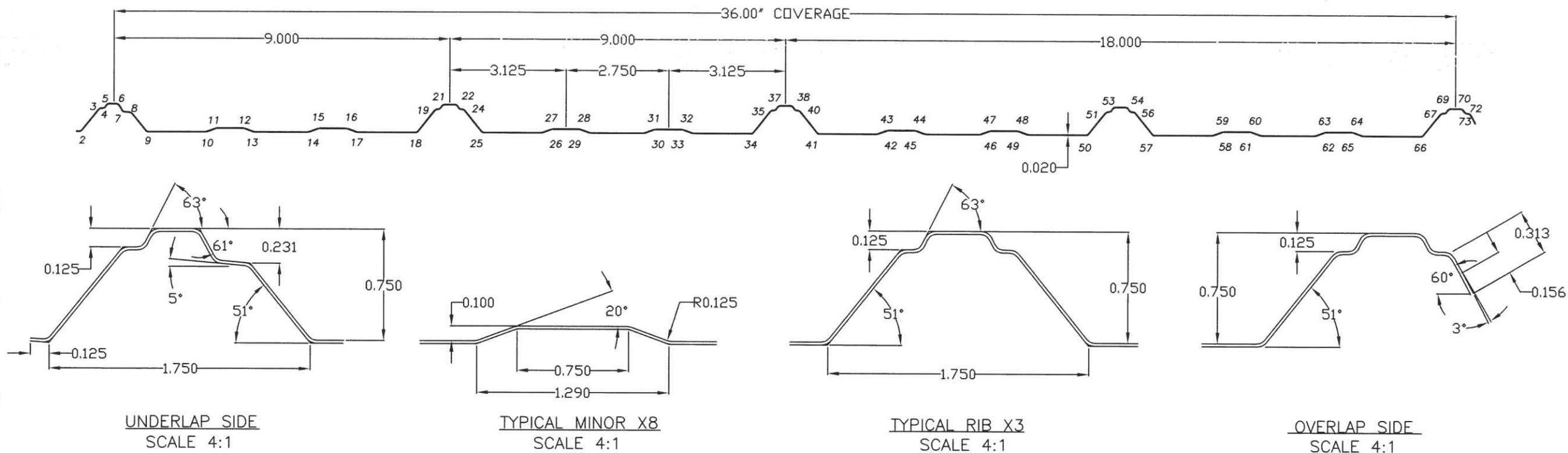


INBOARD SIDE

OUTBOARD SIDE



LAP DETAIL
SCALE: REF

NOTE:

- 1) TOOLING STANDARD GR8 PROFILE WITH 44" TOOL SPACE 3.00" BORE & 6.020" PITCH DIA.
- 2) ALL INSIDE BEND RADII ARE .062" EXCEPT WHERE NOTED
- 3) DIMENSIONS ARE BASED ON .020" MATERIAL
- 4) ALL HEIGHT DIMENSIONS ARE TOP OF SHEET TO TOP OF SHEET

OVERBENDS			
Str	Corner	Str	Corner
6	35-40	11	10-17, 58-65
7	34, 41	12	9, 18, 57, 66
8	25, 50	13	2, 3-8, 67-73
9	26-33, 42-49	14	COVERAGE PASS
10	19-24, 51-56		

TOLERANCE STANDARDS FOR THICKEST METAL:

*ACCUMULATION	-	(+ or -)	1/16in
DEPTH	-----	(+ or -)	1/32in
RADII	-----	(+ or -)	1/32in
ANGLES	-----	(+ or -)	2 degrees
CAMBER	-----	1/8in	in 10ft
SKI	-----	1/8in	in 10ft
DIVE	-----	1/8in	in 10ft

*NET VARIATION FOR COMBINED DIMENSIONS

TOOLING PROFILE NUMBER WAS TP3108/1 05/26/20 JM

APPROX. COIL WIDTH: 40-13/16 @ t=.020

THICKNESS RANGE: .015 - .020

GRADE OF MATERIAL: 80 KSI MIN

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SPOKANE, WASHINGTON

J-MAC METALS
GR8 PANEL W/ OVERLAP BREAK

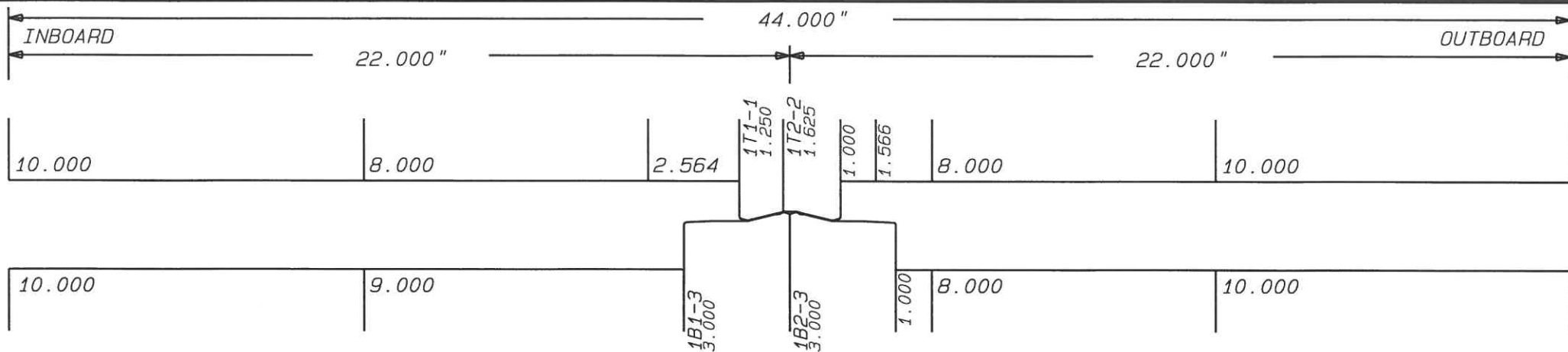
5/4/20

JM

TP3113.DWG

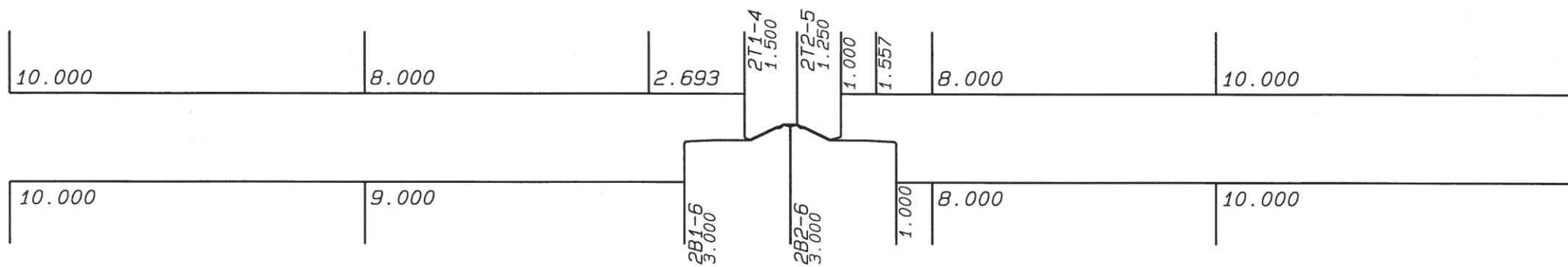
PR28589

TP3113



[18.000" To Station 2]

STATION 1 PD 6.020



[18.000" To Station 3]

STATION 2 PD 6.020

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Scale .242

INBOARD SHOULDER TO SHEET EDGE 0.00

○ DENOTES OVERBEND

JN28589.000

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SPOKANE, WASHINGTON

BORE: 3.001^{+0.001}_{-0.000}

KEYWAY: 13/32 X 5/32

04/07/21
JM /08:24
TA3113.TAR

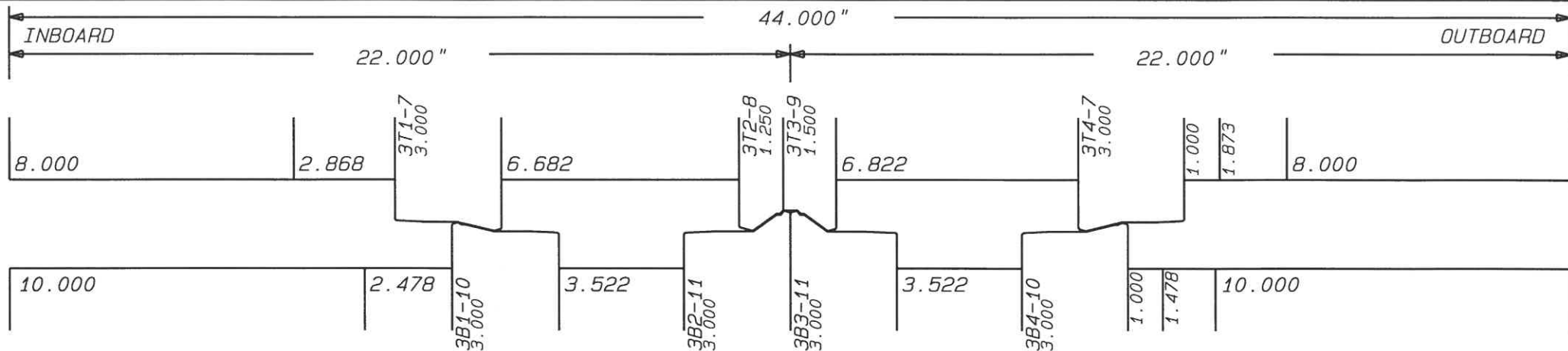
PR28589

J-MAC METALS

GR8 SPECIAL W/ 3DEG BREAK

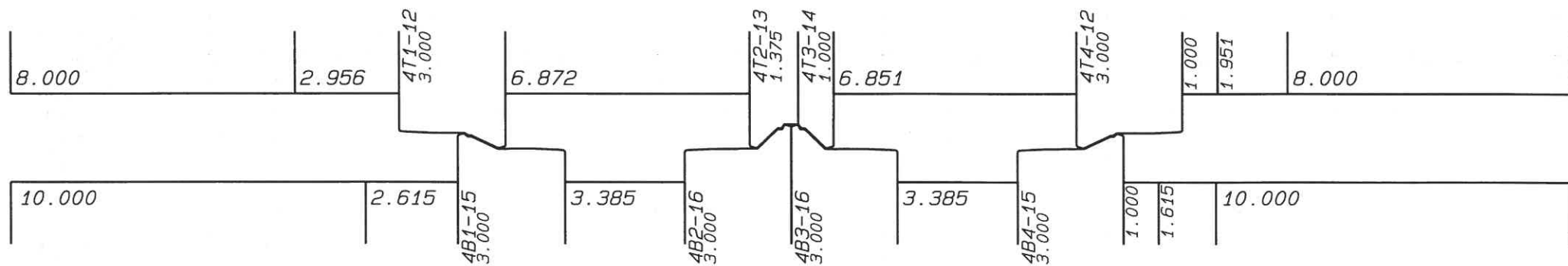
T - 3113

SHEET 1 OF 7



[18.000" To Station 4]

STATION 3 PD 6.020



[18.000" To Station 5]

STATION 4 PD 6.020

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○ DENOTES OVERBEND

JN28589.000

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SPOKANE, WASHINGTON

BORE: 3.001^{+0.001}_{-0.000}

KEYWAY: 13/32 X 5/32

04/07/21
JM /08:24
TA3113.TAR

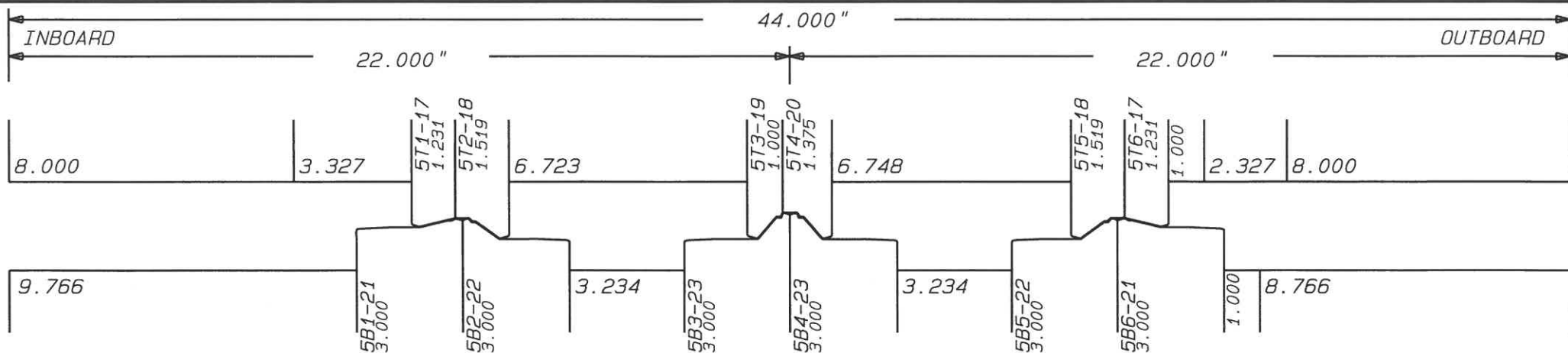
PR28589

J-MAC METALS

GR8 SPECIAL W/ 3DEG BREAK

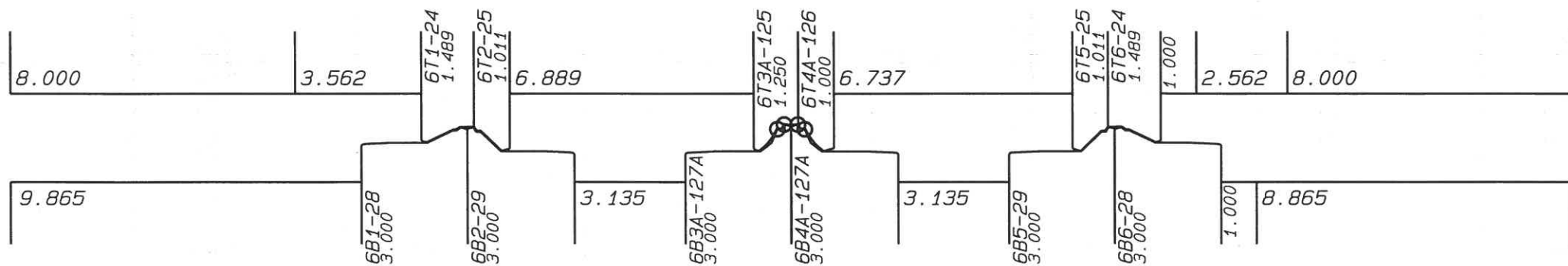
T - 3113

SHEET 2 OF 7



[18.000" To Station 6]

STATION 5 PD 6.020



[18.000" To Station 7]

STATION 6 PD 6.020

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○ DENOTES OVERBEND

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BORE: 3.001^{+0.001}_{-0.000}

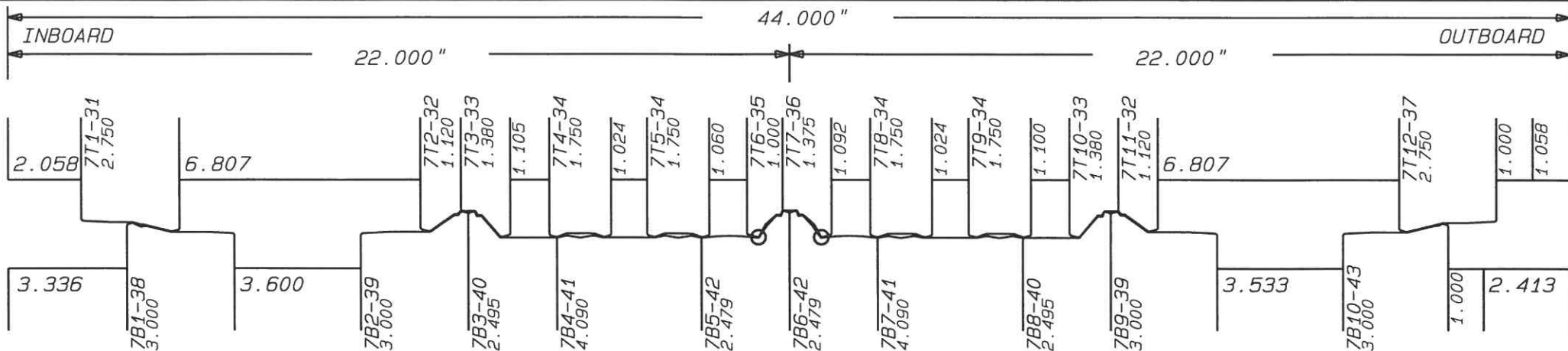
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04/07/21
JM /08: 24
TA3113.TAR

PR28589

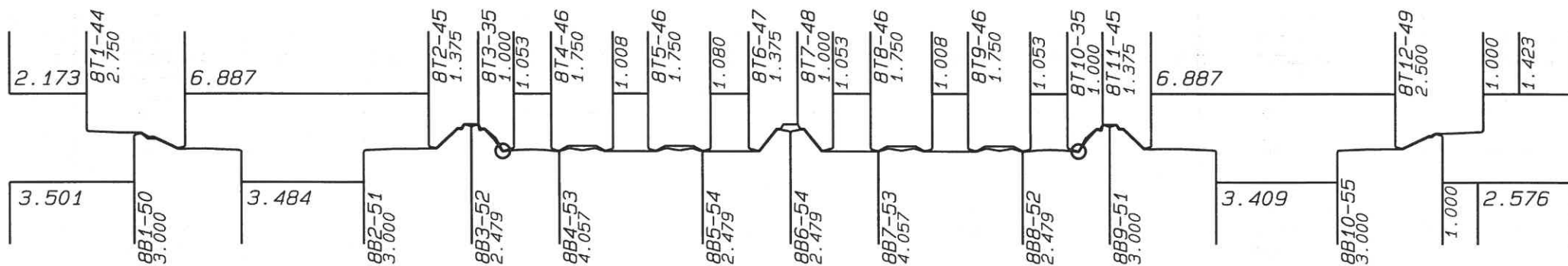
J-MAC METALS
GR8 SPECIAL W/ 3DEG BREAK

T - 3113
SHEET 3 OF 7



[18.000" To Station 8]

STATION 7 PD 6.020



[18.000" To Station 9]

STATION 8 PD 6.020

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BORE: 3.001^{+0.001}_{-0.000}

KEYWAY: 13/32 X 5/32

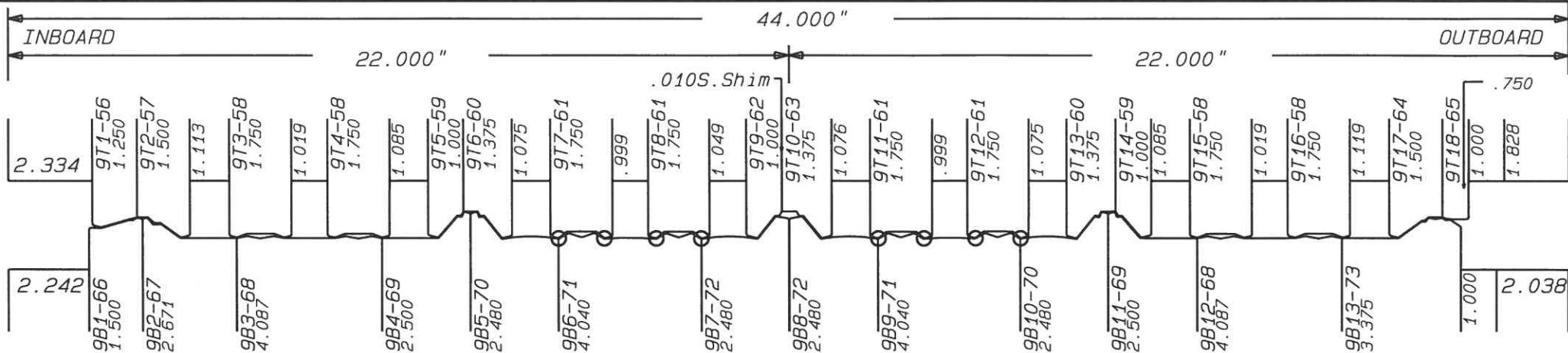
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JM /08: 24
TA3113.TAR

PR28589

J-MAC METALS
GR8 SPECIAL W/ 3DEG BREAK

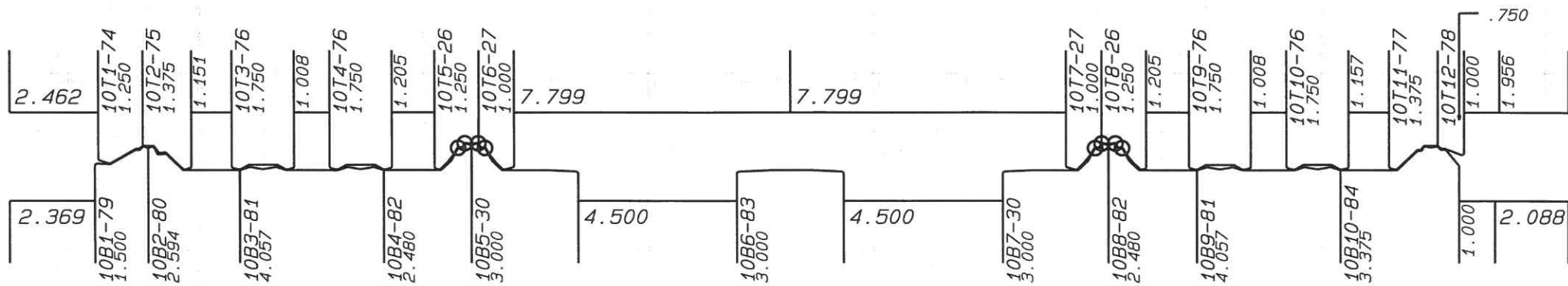
T - 3113

SHEET 4 OF 7



[18.000" To Station 10]

STATION 9 PD 6.020



[18.000" To Station 11]

STATION 10 PD 6.020

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BORE: 3.001^{+0.001}_{-0.000}

KEYWAY: 13/32 X 5/32

04/07/21
JM /08: 24
TA3113.TAR

PR28589

J-MAC METALS
GR8 SPECIAL W/ 3DEG BREAK

T - 3113

SHEET 5 OF 7

PASS SETTINGS

CUSTOMER: J-MAC METALSJOB NBR: 28589

PROFILE: GR8 PANELPR NBR: 28589

Date: 4/6/21File: SET01Coil Width: 40.875Coating: WHITE

By: SDAOStand: Thickness: .014Grade: 60

PASS NBR	INBOARD	OUTBOARD	COMMENTS
1	6-0-10	6-0-10	
2	6-0-10	6-0-10	
3	6-0-10	6-0-10	
4	6-0-10	6-0-10	
5	6-0-10	6-0-10	
6	6-0-10	6-0-10	
7	6-0-10	6-0-15	
8	6-0-20	6-0-20	
9	6-0-15	6-0-10	
10	6-0-20	6-0-20	
11	6-0-25	6-0-20	
12	6-0-30	6-0-30	
13	6-0-30	6-0-25	
14	6-0-15	6-0-15	
15			
16			
17			
18			
19			
20			
21			
22			
23			
24			