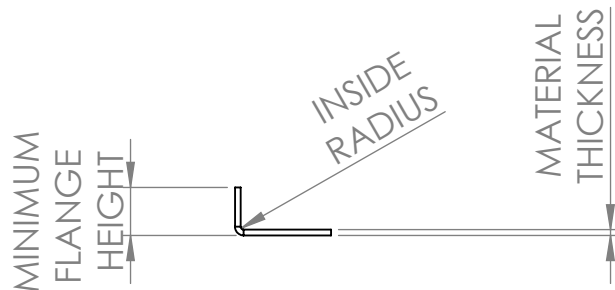


RECOMMENDED PARAMETERS FOR MATERIAL TYPE AND THICKNESS

MATERIAL TYPE	THICKNESS	INSIDE RADIUS	MINIMUM V-OPENING	MINIMUM FLANGE HEIGHT
ALUMINUM/COPPER	.032	.031	.236	.140
ALUMINUM/COPPER	.040	.031	.236	.140
ALUMINUM/COPPER	.051	.031	.315	.180
ALUMINUM/COPPER	.064	.031	.394	.220
ALUMINUM/COPPER	.081	.062	.472	.275
ALUMINUM/COPPER	.091	.062	.472	.300
ALUMINUM/COPPER	.102	.093	.551	.350
ALUMINUM/COPPER	.125	.093	.625	.360
STEEL/SST	.024	.031	.156	.140
STEEL/SST	.030	.031	.236	.140
STEEL/SST	.036	.031	.236	.180
STEEL/SST	.048	.031	.315	.180
STEEL/SST	.060	.031	.394	.220
STEEL/SST	.075	.031	.394	.220
STEEL/SST	.090	.062	.394	.245
STEEL/SST	.105	.062	.551	.300
STEEL/SST	.120	.062	.551	.320
STEEL/SST	.134	.093	.625	.350
STEEL/SST	.179	.125	.825	.460



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