

A

B

C

D

E

F

A

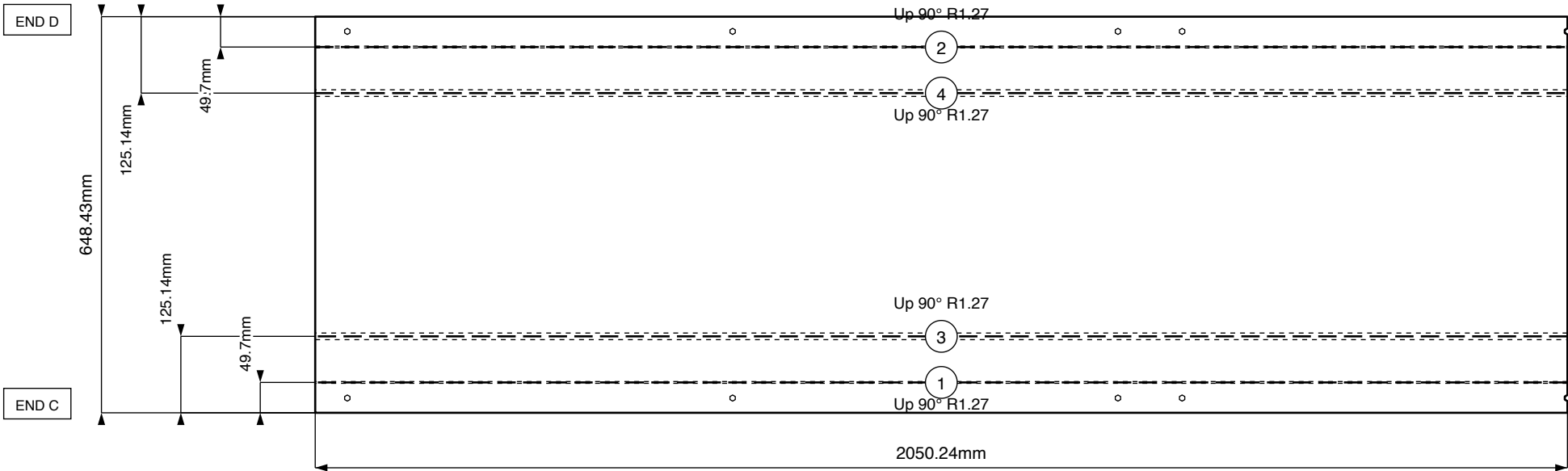
B

C

D

E

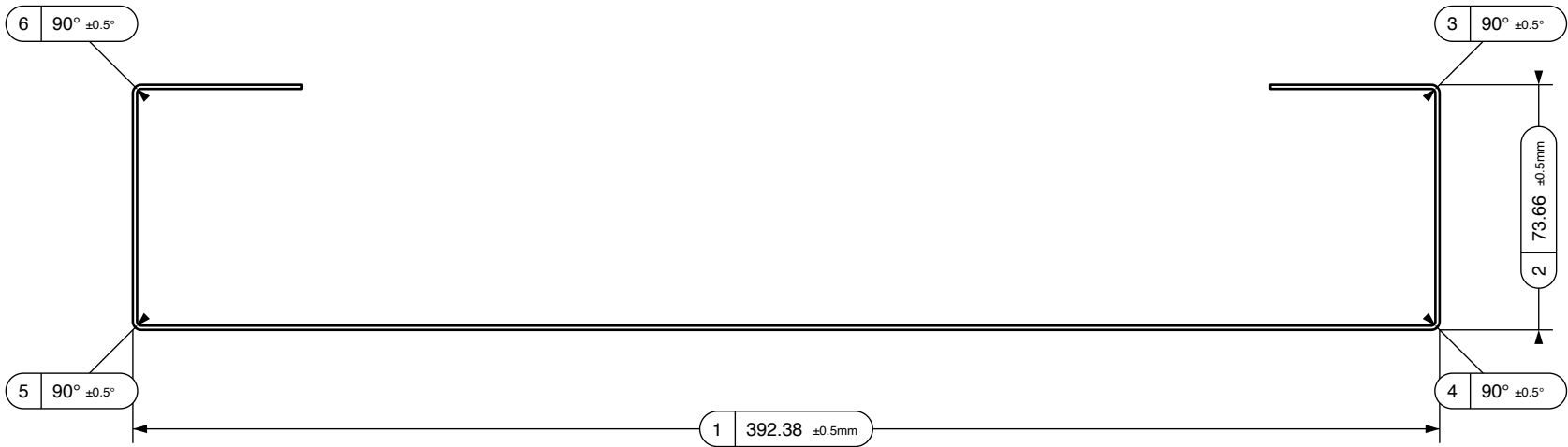
F



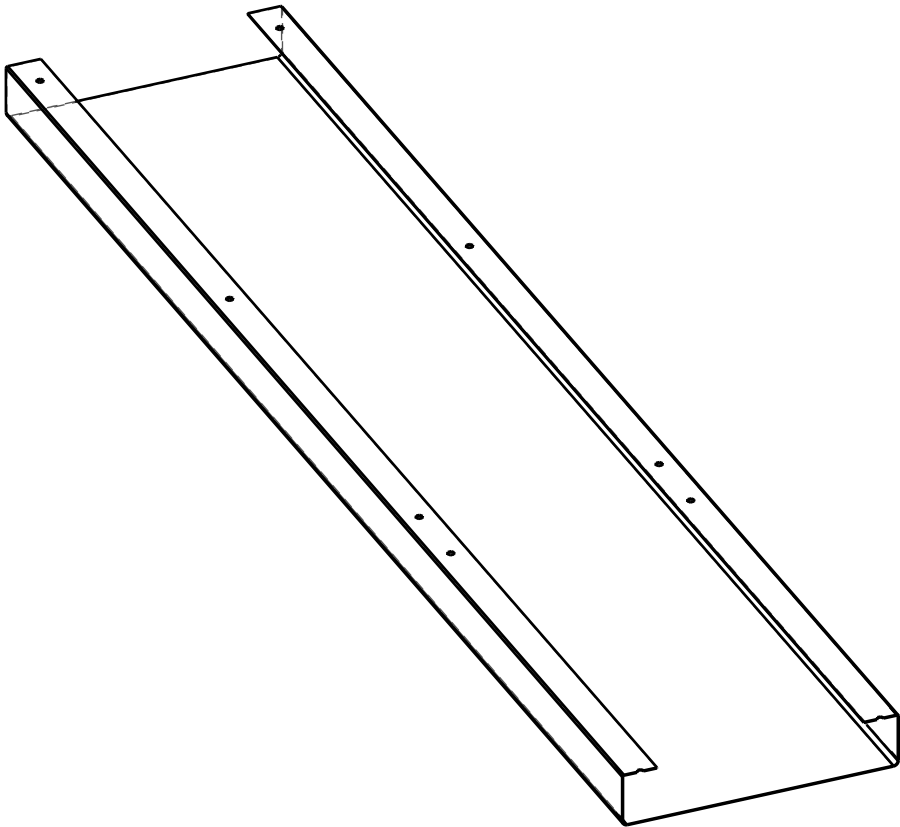
FLAT PATTERN

Bend Table					
Seq	ID	Direction	Angle	Radius	Gauge
1	1	Up	90	1.27	END C
2	2	Up	90	1.27	END D
3	3	Up	90	1.27	END C
4	4	Up	90	1.27	END D

BENDING	Bends	Bend line (mm)
Per part	4	8,200.96
× 2 parts	8	16,401.92



SECTION — FORMED



ISOMETRIC

BLANK DEVELOPED LENGTH 632.95 mm (k ASSUMED 0.50 — NOT FROM THE MODEL)

1. FORMED DIMENSIONS APPLY AFTER BENDING.
2. BEND RADII AND DIRECTIONS PER BEND TABLE.
3. PART IS TURNED END FOR END BETWEEN BENDS — SET EACH BEND FROM THE END NAMED IN THE BEND TABLE.
4. NUMBERED CHARACTERISTICS ARE THE INSPECTION CONTRACT.

5. DO NOT SCALE FROM THIS DRAWING — THE DIMENSIONS GOVERN. ENGRAVED FACE UP. THE FLAT PATTERN IS SHOWN AS THE BLANK GOES INTO THE BRAKE. BEND IN THE SEQUENCE SHOWN (1 → 2 → 3 → 4) — 90 deg and acute — outermost inward. CHECK FOR RAM AND GOOSENECK COLLISION BEFORE THE FIRST PART.

Dept. QA	Technical reference +/- 0.5mm	Created by AG 8/10/26	Weight 13.51 kg	Thickness 18ga
		Document type Inspection - Bending	Material Stainless Steel AISI 304 — 3P	
		Title Upper Cabinet Frame Frame Cover	DWG No. UC-FRA-FC	
		Rev. 1	Date of issue 08/10/2026	Sheet 1/1