



E	FOLDS ON THE BLANK					
	Fold	From END A	Fold angle	V at inner wall	Relief dia.	Joins
	F1	197.65	90°	148.6	3.8	Exterior Support Tube / Exterior Vertical Tube
	F2	1,994.35	90°	148.6	3.8	Exterior Vertical Tube / Exterior Support Tube R

HOLES				
Hole	Wall	From END A	Across	Size
H1	side 1	99.3	38.1	Ø8

1. THE TUBE IS BOUGHT. CUT IT ON THE TUBE LASER FROM THE IGS. ALL POSITIONS ARE FROM END A, ALONG THE OUTER WALL'S OUTER FACE.
2. THE OUTER WALL STAYS WHOLE AND IS BENT. EACH V NOTCH CUTS BOTH SIDE WALLS AND THE INNER WALL; THE RELIEF HOLE IS AT THE V TIP.
3. FOLD AT F1, F2 ... ON THE OUTER WALL, INSIDE RADIUS 1.9 mm, UNTIL EACH V CLOSES.

4. WELD THE CLOSED V SEAMS (SIDE WALLS AND INNER WALL). NO WELD ON THE OUTER FACE.
5. ONE BLANK FOR: Exterior Support Tube, Exterior Vertical Tube, Exterior Support Tube R.
6. NUMBERED CHARACTERISTICS ARE THE INSPECTION CONTRACT.
7. DO NOT SCALE FROM THIS DRAWING — THE DIMENSIONS GOVERN.

Dept.	Technical reference	Created by	Weight	Thickness
QA	+/- 0.5mm	AG	9/10/26	
PRODUCT INTELLIGENCE 		Document type	Material	
		Inspection - Tube fold	ASTM A500 Gr B	
		Title	DWG No.	
		Tube Frame Exterior Support Frame Fold blank		
		Rev.	Date of issue	Sheet
		1	09/10/2026	1/1