



# Metal Curving Quote Request

Today's Date: \_\_\_\_\_ Curved Metal Needed By: \_\_\_\_\_

Contact Name: \_\_\_\_\_ Company: \_\_\_\_\_

Address: \_\_\_\_\_

City: \_\_\_\_\_ State: \_\_\_\_\_ Zip Code: \_\_\_\_\_

Phone: \_\_\_\_\_ Fax: \_\_\_\_\_

Email: \_\_\_\_\_

Reference or job name \_\_\_\_\_

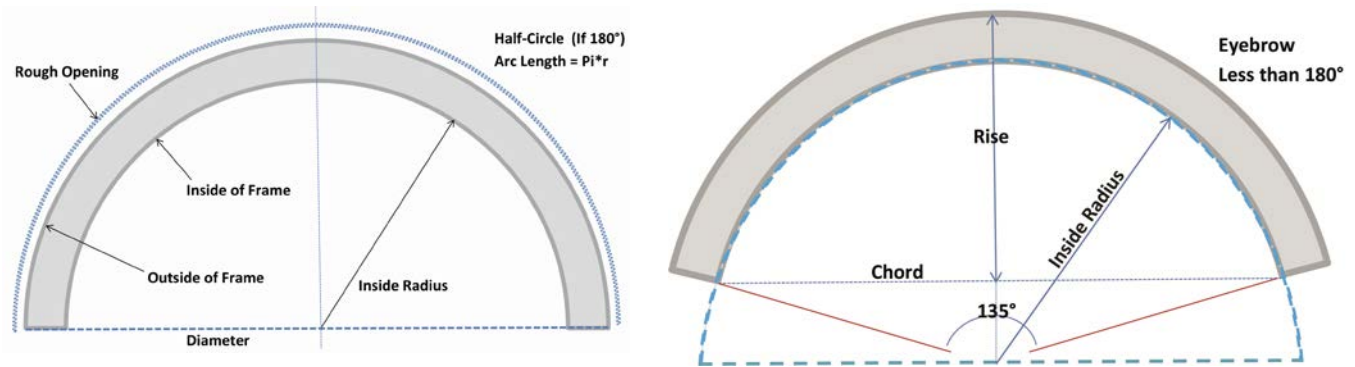
Finishing Requirements \_\_\_\_\_ Finish Code \_\_\_\_\_ Finish Name \_\_\_\_\_

Special Instructions / Additional Information \_\_\_\_\_

Alloy \_\_\_\_\_ Temper \_\_\_\_\_

Item #	Quantity	Part #	Sketch with arrow toward inside radius and provide prints	Required Information Option 1		Required Information Option 2		Finish of Material Supplied, description or other information
				Chord Length	Rise or Height	Chord Length	Radius <input type="checkbox"/> Inside <input type="checkbox"/> Outside	
1								<input type="checkbox"/> Mill Finish <input type="checkbox"/> Other _____
2								<input type="checkbox"/> Mill Finish <input type="checkbox"/> Other _____
3								<input type="checkbox"/> Mill Finish <input type="checkbox"/> Other _____
4								<input type="checkbox"/> Mill Finish <input type="checkbox"/> Other _____
5								<input type="checkbox"/> Mill Finish <input type="checkbox"/> Other _____

# Stretch Forming by Linetec Guidelines

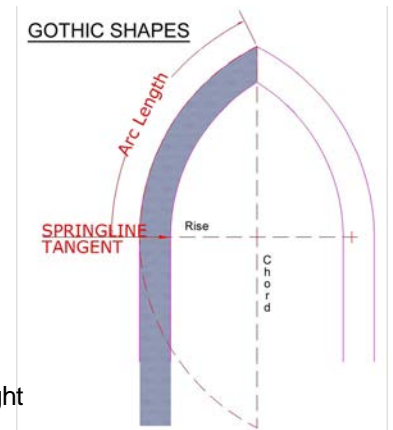


## Half-Circle or Eyebrow Openings

1. Determine at what points the curve begins and ends. These points are called the tangent points (or straight-line points). Measure the distance between these points ideally with a laser measurer. This distance is called the chord. If the opening is a complete half-circle (180°), this distance will also be the diameter, and half of this measurement is your radius.
2. From the exact center of the chord, measure straight up to the top of the arc. Do not include any straight leg. This distance is called the rise (or height). If the rise is one half of the chord, then you have a complete half circle or 180°. See "Notes" below for a comment on inside vs. outside measurements.
3. If straight legs are required, measure from the tangent point (where the curve ends) down to the lowest point needed

## Gothic Openings

1. Hang a plumb bob from the point of the Gothic opening.
2. Determine at what point along the side that the curve begins. This tangent point acts as the top of an arc that begins at the top of the pointed opening and extends through this tangent point and continues as an imaginary line until it intersects the plumb line coming straight down from the upper point. This distance on the plumb line between these points is the chord.
3. The distance from the center of the chord (on the plumb line) measured horizontally to the beginning of the curve (or tangent point) is the rise.
4. If there are straight legs, measure from the tangent point (where the curve ends) straight down to the bottom of the piece.



## Notes

- The rise, the chord and straight legs (if needed) are the only measurements Southern Stretch Forming needs to determine the arc length and provide you with a quote. We can also work with the chord and radius if your drawing provides this information.
- The above procedure gives us the outside dimensions so we will deduct the width of the material you are using to determine the inside radius. If using an inside dimension, use inside dimensions throughout, i.e. be consistent and advise which you are using.
- We will assume standard cut-length material (24') unless you tell us otherwise
- A template is needed for compound curves (having more than one radius) and will likely require a custom die