
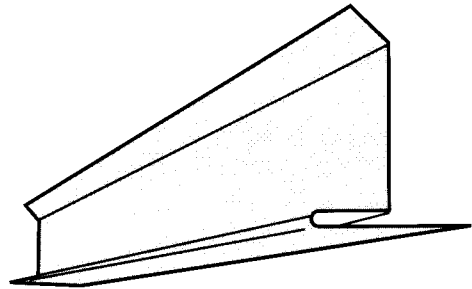


# TRADITIONAL BENDING TECHNIQUES

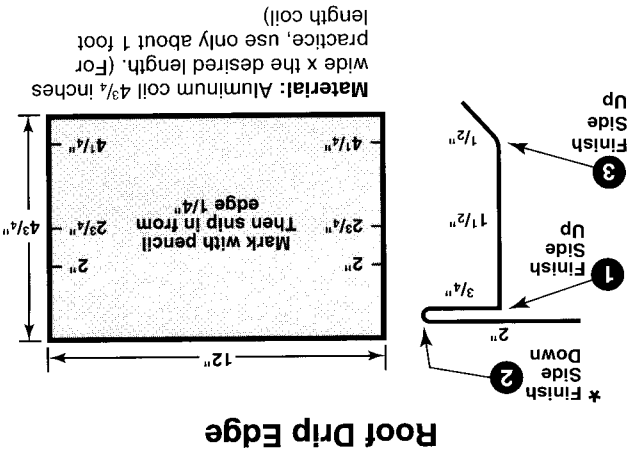
## Helpful Hints for Trim Work

1. Measure the total length of the particular trim area to be covered and divide by the length of your bender to determine the number and length of trim pieces needed.
  2. Determine the dimensions of each section of the desired trim shape by measuring that particular profile to be covered. As an aid, make a pattern out of a 1" strip of coil to get your exact profile.
  3. Transfer the dimensions in Hint #2 to each end of a piece of trim coil by making a 1/4" slit in the metal with a pair of shears. These marks now become the bending points and makes the bending marks visible from either side. On longer lengths the coil over as shown and snip both ends at once. This saves time and ensures accuracy. The Tapco Wizard was designed to make this time consuming part of your job easier and more accurate. See page 4.
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4. Lock the pre-marked coil blank into the bender with the cut marks located directly under the outer edge of the Stainless Bending Edge. Lock Bender. To cut off the coil with a razor knife, score the metal against the Stainless Bending Edge. Now bend the metal up and push back down by hand until the exposed section breaks off. It may require 2 or 3 repetitions.
5. For bending, follow the suggested sequence of bends on pages 14 and 15. For actual bending techniques see "Bending the Roof Drip Edge" below.
  6. Don't fit your trim parts too tight. This will complicate the joints where parts overlap. A one inch (1") lap joint is enough to allow for expansion and contraction. *Trim should be lapped so that laps are facing away from traffic areas.*
  7. Try to nail the trim parts on an area that will make the nails less conspicuous. Fasten at laps. When face nailing, use just enough nails to secure trim; **DO NOT DRIVE NAILS TOO TIGHT!!**
  8. *Remember*, when designing shapes you are hanging a cover over the wood parts, not laminating a skin-tight surface. This is called "Floating Your Trim". Allow for irregularities in the wood because your formed trim shapes are straighter than the wood trim moldings or boards you are covering.
  9. With practice, you'll learn to overbend or underbend certain sections to achieve a pressure fit of your trim parts which will, in turn, require fewer nails and give your job a more wood-like appearance.
  10. Hemming (making a 180° bend on the edge of a sheet) will give your shape a "Factory Edge Look" and will stiffen the entire trim piece to help eliminate "oil canning". See page 6.

## Bending the Roof Drip Edge (General instructions for all examples)



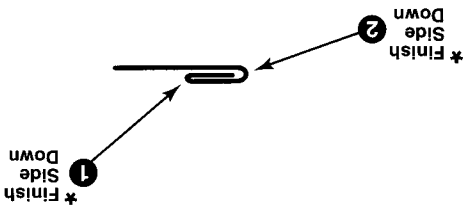
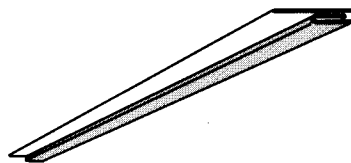
1. This shape is basic to all the other shapes contained in this manual. Practice this shape before you proceed with the other trim pieces illustrated on pages 14 and 15.
2. To begin, cut off a piece of coil 43/4 inches wide by about 1 foot long (As shown at right.)
3. Mark your coil with a pencil at 2", 23/4" and 41/4" on both ends. Then snip these marks in about 1/4" (so they will be visible on both sides of the coil).
4. Put your coil into the bender with the **Finished Side Up**. Bend 90°.
5. Remove the coil from the bender. Bend 2 will be at the 2" mark on the coil, so now put the coil into the brake with the **Finished Side Down**. Lock the brake on this 2" mark. Note that Bend 2 shows the symbol \* which means the bend is to be 180°. Bend this as far as it will go (about 165°). Then proceed to hem it in the bender as shown on Page 7 in "How to Hem and Fold".
6. Now to Bend 3 put your coil back into the bender **Finished Side Up** and lock on the 41/4" mark. Bend this approximately 45° as shown to complete the shape.



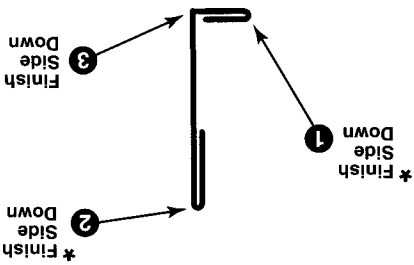
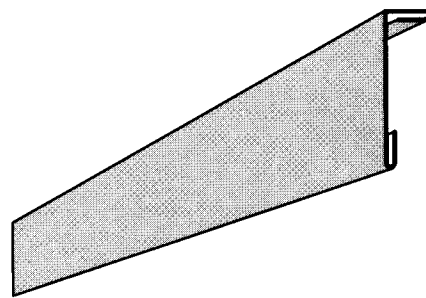
1. Numbers show the sequence of the bends; thus, 1 would be the first bend, 2 the second bend, etc.
2. "Finish Side Up" indicates that the finished or exposed side of the trim is to be put into the brake **FACING UP**.
3. "Finish Side Down" indicates that the finished or exposed side of the trim is to be put into the brake **FACING DOWN**.
4. The symbol \* means the bend is to be 180°.

# EXAMPLES OF COMMON TRIM SHAPES

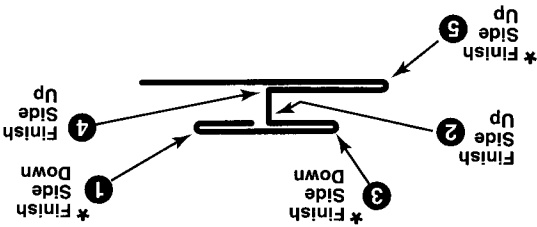
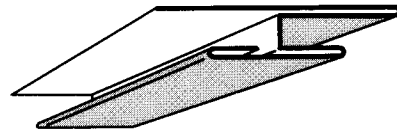
1. All Purpose Sill Trim  
 See notes on Bending the Roof or  
 Drip Edge "General Instructions  
 for All Examples" on Page 13.



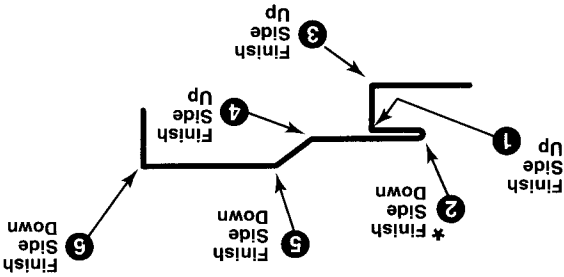
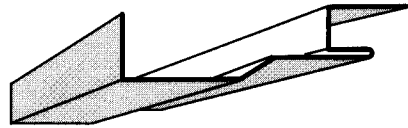
2. Facia Trim



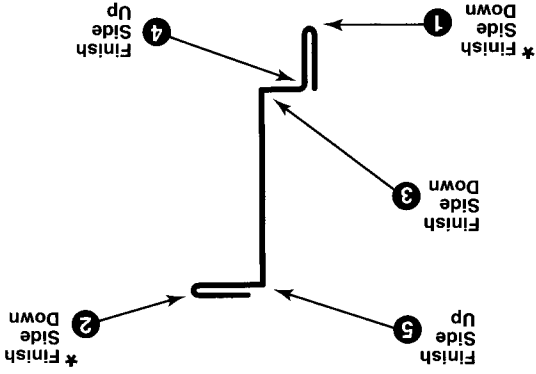
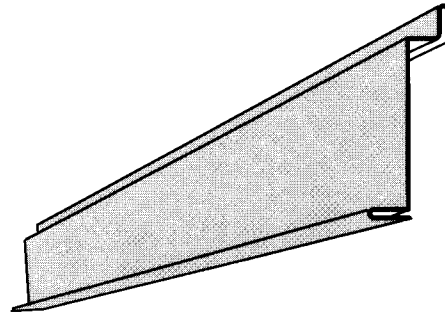
3. One Piece Soffit Mitre



4. Rake Trim with Built-in "J"-Channel



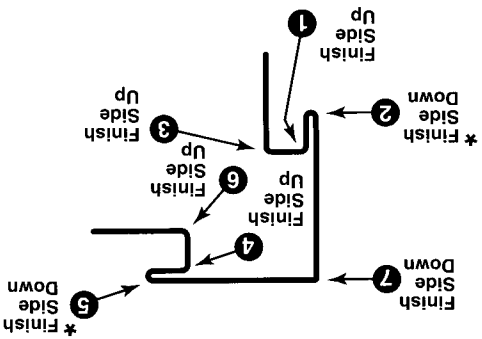
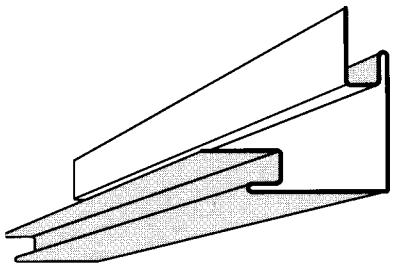
5. Soffit and Frieze



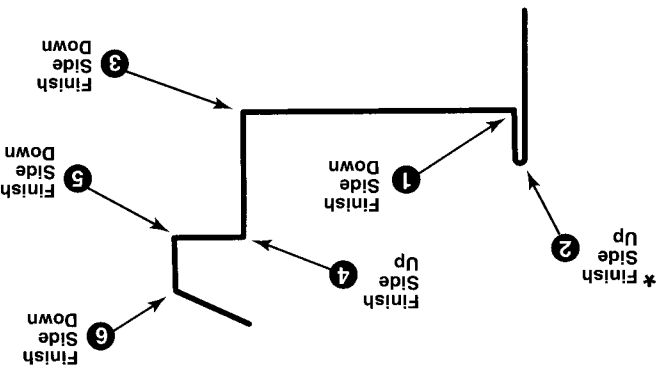
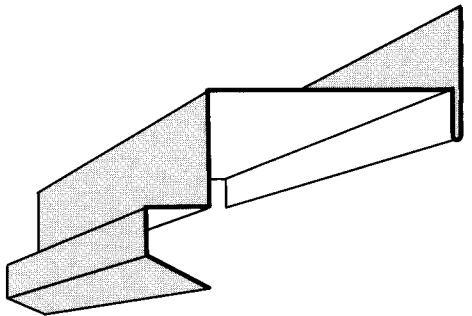
\*The bend should be 180°.

# EXAMPLES OF COMMON TRIM SHAPES

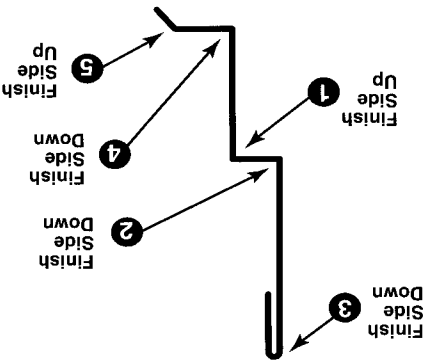
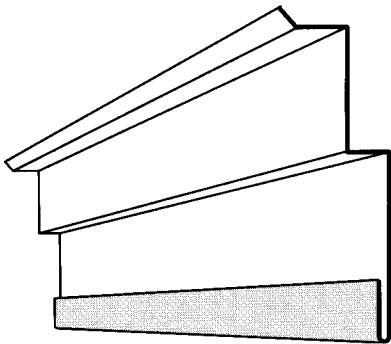
6. One Piece Outside Corner



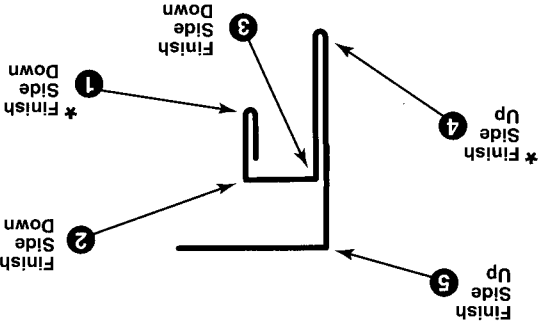
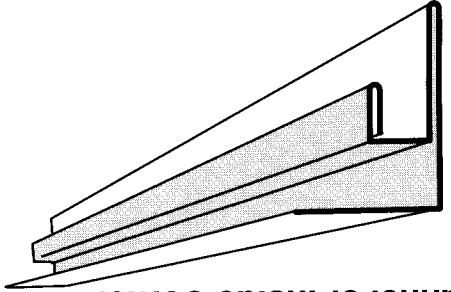
7. Overhang Trim with Built-In Undersill



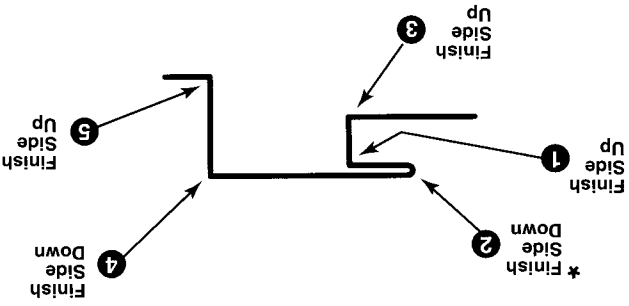
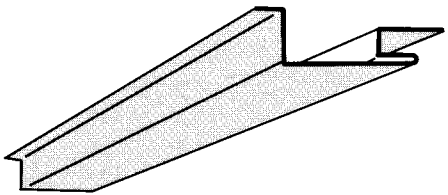
8. Brick Frieze



9. "F" Channel or Inside Corner



10. Window or Door Casing with Built-in "J" Channel



\*The bend should be 180°.