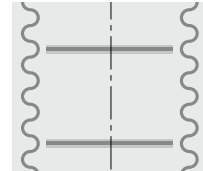


Minimum drum diameters for various profile angles

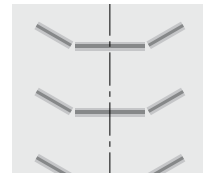
A lateral profile has a 0° angle. A longitudinal profile has a 90° angle. Assume the maximum angle for curved profiles. For V-shaped profiles take the angle existing angle. In the case of K and F profiles, the diameters that previously applied for 0° and 90° profile angles were taken as the calculation basis.

In the case of T profiles the drum diameter was calculated at 90° with maximum edge elongation of 14%.

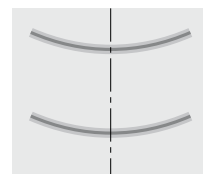
Profile	Angle in °						
	0	15	30	45	60	75	90
PVC							
K6	30	30	30	30	30	30	30
K10	50	52	53	55	57	58	60
K13	80	77	73	70	67	63	60
K15	90	85	80	75	70	65	60
K17	110	107	103	100	97	93	90
K30	180	188	197	205	213	222	230
T20	90	145	160	165	170	175	180
T60	150	330	380	410	430	450	460
F20x3	70	67	63	60	57	53	50
F30x8	120	115	110	105	100	95	90
PU							
K6	30	30	30	30	30	30	30
K10	50	52	53	55	57	58	60
K13	80	77	73	70	67	63	60
K15	90	85	80	75	70	65	60
K17	110	107	103	100	97	93	90
T20	50	125	150	160	170	175	180
T30	50	170	200	220	230	240	250
T40	50	210	250	280	295	310	320
T50	50	250	305	335	360	375	390
T60	50	290	360	400	420	445	460
F 15 x 6	70	67	63	60	57	53	50
F 30 x 8	120	115	110	105	100	95	90
PE							
K10	50	52	53	55	57	58	60
K13	80	77	73	70	67	63	60
K17	110	107	103	100	97	93	90
T10	70	90	96	99	102	103	105



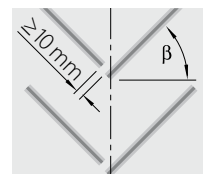
Profiles welded on in a box shape



Profiles welded on in a V shape



Profiles welded on in a curved shape



Profiles welded on in a V shape (sketch showing dimensions)