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web jan 26 2022 if the shop is using a v die to make the flange there is a minimum and maximum length that any flange can be in general the flange needs to be at least 3 though we suggest 4 times longer than the thickness of the material for sheet metal that s 0 120 thick that means a minimum flange length of 0 480 long sheet metal bending calculation basics the fabricator - Nov 30 2022

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