

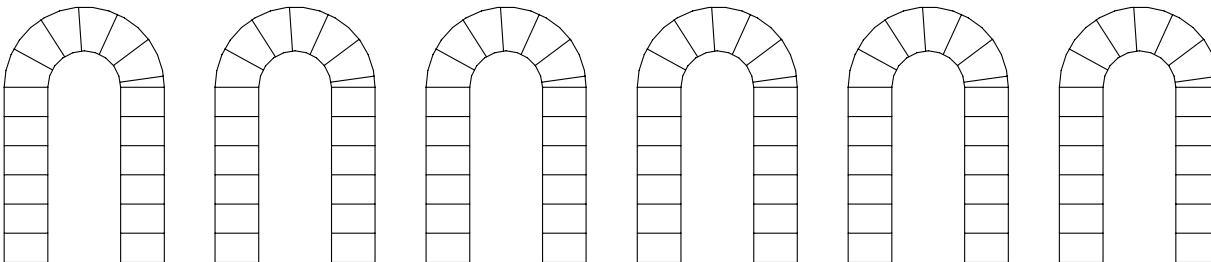
U-Bend Metal Tubing Control Sheet

Shop Name:	Work Order No.:
Project Name:	Date:
Author/Technician:	Page:

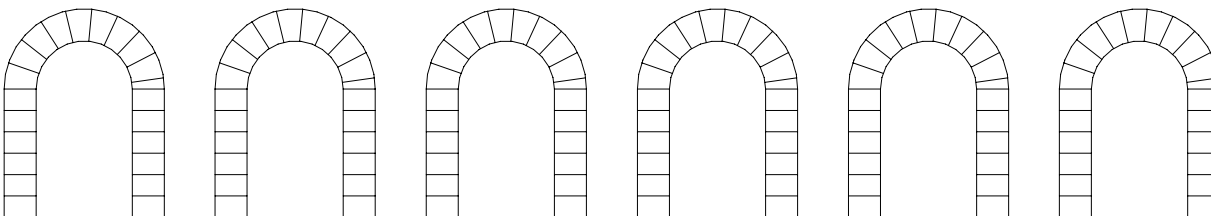
Directions for Use:

1. Upon completion of your icengineworks™-modeled exhaust header design, locate cylinder 1 and, starting at the exhaust port going downstream of flow, identify the first section of blocks with same CLR and aligned witness lines as explained in the Instructions Manual.
2. Mark and label the corresponding blocks or spaces in the drawings below according to their CLR and number of blocks used. Write the cylinder number, the section number in that runner and label which end points downstream to avoid confusion. For example: 1a, 1b, etc., denoting the first section (a) of cylinder 1 at the port, followed by the next section (b) going downstream, and so on until all sections in that runner are accounted for. Maximize the available metal in each U-Bend to minimize expenses. Depending on your band saw blade thickness, we recommend leaving one empty 'block' as buffer between each section to be cut to allow tolerance build-up.
3. Move on to the next cylinder and repeat until the entire design is tallied. Review your information before ordering the metal tubing to limit mistakes. It is wise to order an extra U-bend or two just in case something unexpected happens.
4. When cutting the actual metal tubing, remember to label each metal section as you go through all the sections to avoid confusion, particularly the flow direction. By the time all the sections are cut, many of them will look very similar. Also, bear in mind the blade thickness, as it will shorten sections if it is not considered.
5. This form is available for download as a PDF file from our site at: www.icengineworks.com/controlsheet.pdf or under the 'header fabrication tools' section at www.icengineworks.com/icewtools.com. Help yourself.

2.000"-CLR w/6" Legs



3.000"-CLR w/6" Legs



4.000"-CLR w/6" Legs

