

Must have some straight length at both ends

You must have some straight length at both ends of your part. At times a customer will not allow for enough material for the CLR.

As an example;

If a bend is 90 degrees you must have at least the CLR to define that leg.

The screenshot shows a software window titled "Document 1" with various settings and a table of bend parameters. The material is set to 1.0 and tooling to 3.0. The cut length is 19 and weight is 0. A red "Mfg Warning" box is visible. The units are set to Inches. The table shows two bends with lengths of -1 13/16 and 8 11/16, both at 90 degrees, with a CLR of 3.063 and a bend length of 4 5/8.

A	B	Length	Rotation	Angle	CLR	Bend Length
1	1	-1 13/16	0	90	3.063	4 5/8
2	2	8 11/16	0	90	3.063	4 5/8

Custom Part settings:
First Angle: 0
Number of Bends: 2
Tooling: 3.0

	Length	Rotation	Angle	Dim Type
A1	2		90	apex
A2	12		90	apex
end	8			

Notice how there is a negative value in the results area. In the above case the CLR is over 3 and the value for a 90 degree bend is at 2.