

## Using an angle level

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For guys who have NOT purchased the LRA Extension Module and want to use a dial level, please follow this thread carefully.

Bend-Tech as a default (without the LRA module) uses incremental rotations between bends. In other words, after each bend is performed that current rotation angle becomes 0 degrees.

After the 2nd bend you will need to calculate the absolute (rotations from 1st bend position) rotations.

Here is an example:

Document 1

Material: 1.25  
Tooling: 3.0

Cut Length: 48 1/2  
Weight: 0

Inches  
Millimeters

A	B	Location	Rotation	Angle	CLR
1	1	6 15/16	0	74	3.063
2	2	17	-85	74	3.063
3	3	26 3/16	0	74	3.063
4	4	36 1/4	85	74	3.063

Simulation Bend Order Setup Sheet  
Display Notes Cut Off  
Misc.  Tooling  Material

3.0

CLR 3.063 Detailed List  
Calibrated CLR 3.50 Custom CLR  
KFactor  
Loc. Offset -.75 Tool Library  
 Display Spring Angle

Custom 3D Part (Bend 1)  
Number of Bends: 4 Detailed List  
Tooling: 3.0 Custom CLR  
Dimension Type: Apex

Bend

1  
2  
3  
4  
E

to ceiling  
to left  
to front  
to back  
to right  
to floor

to ceiling  
to left  
to back  
to right  
to floor

1  
2  
3  
4

Reset

There are several types of angle levels available and many of them use different angle call outs. We are going to cover the 2 most common:

### 1) Your angle level is numbered from 0 to 360

Here are your results from our example

bend 1)  $0 = 0$  (the first one is always 0 degrees)

bend 2)  $-85 = 275$  ( $360 + -85 = 275$ )

bend 3)  $0 = 275$  ( $275+0 = 275$ )

bend 4)  $85 = 0$  ( $275+85 = 360 = 0$ )

### 2) Your angle level is numbered from 0 to 180 and 0 to -180

bend 1)  $0 = 0$  (the first one is always 0 degrees)

bend 2)  $-85 = -85$  ( $0 + -85 = -85$ )

bend 3)  $0 = -85$  ( $-85 + 0 = -85$ )

bend 4)  $85 = 0$  ( $-85 + 85 = 0$ )

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