

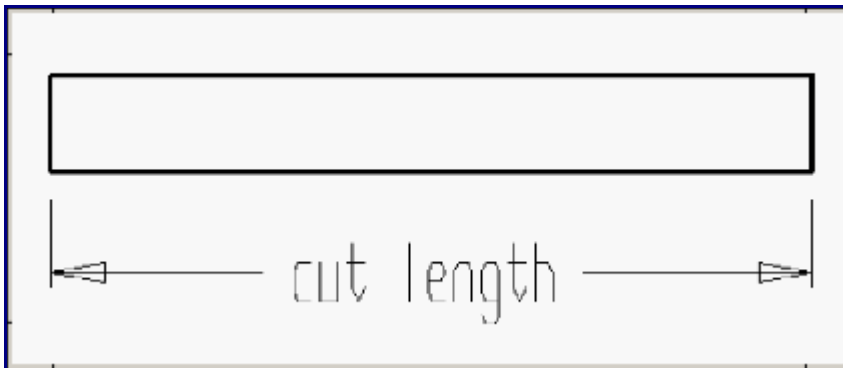
# What is Calibrated CLR?

This is the center line radius that is the mathematical radius for determining material growth through the bend

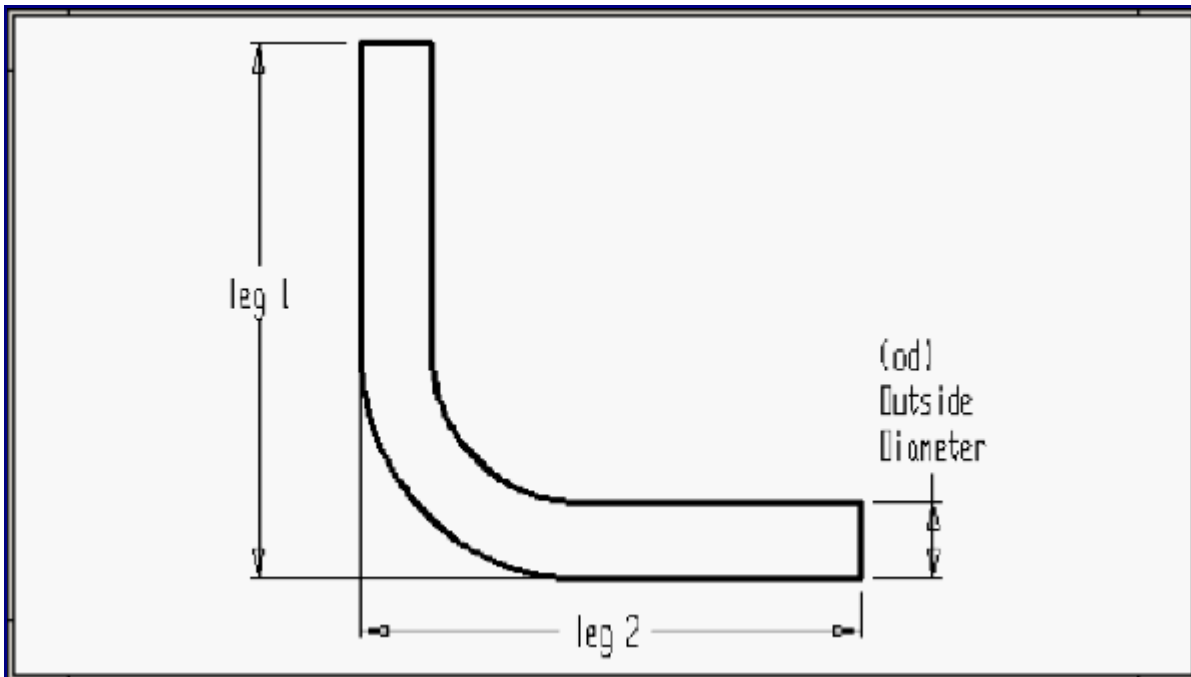
## Finding your Calibrated Centerline Radius

To find the Calibrated CLR use the following procedure:

Cut a piece of tube and measure it after the cut (cut length).



Bend it to 90 degrees such that the bend is 90 degrees after bending. The location of the bend is not needed for this formula, so you may bend it anywhere as long as there is enough material to properly go through your bender.



The OD is the outside tube diameter.

Formula: Calibrated CLR = ( leg1 + leg2 - cut length - OD) \* 2.33

**Note: You should find the Calibrated CLR to be 5 to 20% larger than the labeled CLR on your die.**