

## SUNLITE® and SUNTUF® Polycarbonate Products

TECH BRIEF: 5004

### Cold Bending Recommendations for SUNLITE® and SUNTUF®

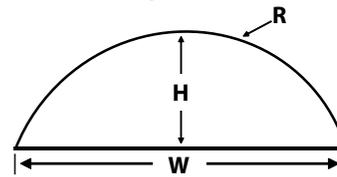
When installing polycarbonate products in a curved application, we have manufacturer's recommendations in order to facilitate a successful installation.

**Definition:**

Minimum Bending Radius = The smallest radius to which a material can be cold formed without jeopardizing the long term integrity of the material. The formula for the calculation of a radius is universal for all materials and is as follows:

All units of measure must be the same throughout the calculation.

$$R = \frac{(W/2)^2 + H^2}{2H} \quad \text{or} \quad R = \frac{H}{2} + \frac{W^2}{8H}$$

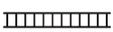


R = Radius of Arc  
W = Width of Structure  
H = Height of Arc

Sample Calculation: W = 240 inches H = 72 inches

1.  $R = \frac{(240/2)^2 + (72)^2}{2 \cdot 72}$
2.  $R = \frac{14400 + 5184}{144}$
3.  $R = \frac{19584}{144}$
4. R = 136 inches or 11.33 feet

#### SUNLITE® Minimum Bending Radii

Product	Profile	Panel Thickness	Minimum Bending Radii		
			mm	ft.	in.
Twin Wall		6 mm	1,050	3.44	41.3
		8 mm	1,400	4.59	55.1
		10 mm	1,750	5.74	68.9
Triple Wall		8 mm	1,400	4.59	55.1
		10 mm	1,750	5.74	68.9
		16 mm	2,800	9.18	110.2

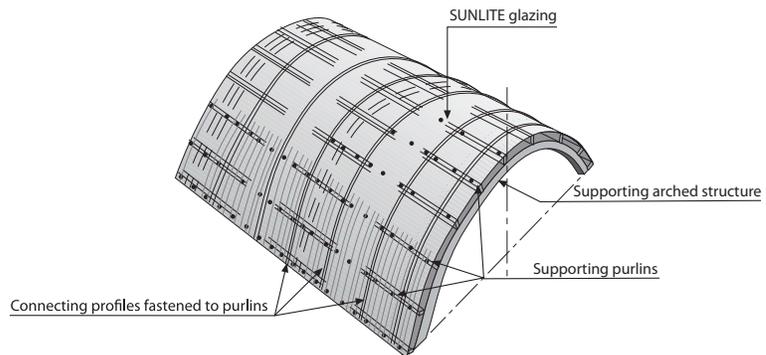
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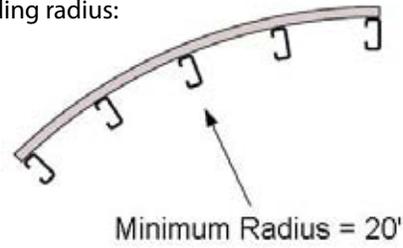
Customer Service  
9735 Commerce Cir., Kutztown, PA 19530  
Phone: 800-999-9459, +1-610-285-9918  
Fax: +1-610-285-9928  
E-Mail: sales.usa@palram.com

Technical Service  
Phone: 800-999-9459 Ext. 292  
Fax: +1-610-285-9928

www.palram.com



SUNTUF minimum bending radius:



Placing corrugations on a flat sheet increases the rigidity of the material. This allows for a thinner material to become much more rigid. Because of this increased rigidity .8mm SUNTUF has a minimum bend radius which is much larger than that of a 16mm SUNLITE sheet which is more than 16 times the thickness.

Example: 16mm Triple Wall = 9.18 ft  
vs.  
.8mm SUNTUF = 20 ft

The correct method to curve both SUNTUF and SUNLITE is to have the “flutes” or corrugations parallel to the arch (Fig. A). The sheets are not meant to be bent with the flutes or corrugations perpendicular to the arch because excessive buildup of dirt and moisture will occur (Fig. B).

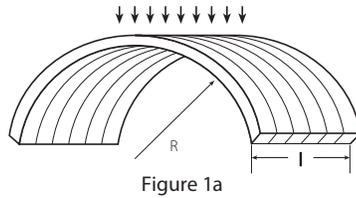


Figure 1a

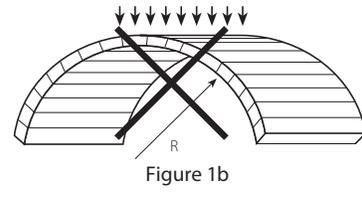


Figure 1b



SUNLITE



SUNTUF