

# BULLNOSEING & CRANKING



## *Bullnoses and Centre Cranks*

Bull nosing and centre-cranking of a profiled sheet incorporate lateral rib indentations pressed in at a uniform distance of 25mm. Standard bullnoses are made with narrow flute uppermost and the bend away from the angular inclination. Reverse bullnoses are made with the bend into the narrow flute. Bullnoses and cranks can be at the end of a sheet or at any position along the length. Bullnoses and centre cranks can be manufactured in radii ranging from 350mm to 800mm for bullnoses which are bent through 0 - 135°. High tensile material can only be bull nosed and cranked to a minimum radius of 450mm

*Larger RADII will be Classified as a Forward Crank.*

The maximum sheet length which can be bullnose is 15m, with a maximum height of 2m. The minimum run-out from the bullnose is 30mm on one side with a minimum of 500mm on the other side of the sheet. It is important to clearly identify the critical end of the bullnose in order to ensure that consistent lengths are supplied to the customer. The maximum height (after cranking) of center and off-center cranks which can be manufactured is 2m, with a limitation of 10m total sheet length, due to handling and transport limitations. (Height in this case is from ground level to highest point of bullnose sheet.)

