

June 3, 1963

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**SUPERSEDING**  
**Fed. Std. No. 187a**  
September 5, 1962

**FEDERAL STANDARD**

**IDENTIFICATION OF PRESSED BENDS, FORMS,  
SEAMS, AND JOINTS, (SHEET METAL)**

*Authority. This standard is issued pursuant to the Federal Property and Administration Services Act of 1949, as amended, and its application to the purchase of commodities referred to herein is mandatory on all Federal agencies.*

**S1. Purpose and scope.** This standard provides uniform illustrated identification of pressed bends, forms, seams, and joints commonly used in furniture, roofing, and other allied sheet-metal industries for the use of all Federal agencies to achieve the highest degree of standardization.

**S2. Standard characteristics and item identification.** The standard item shall conform to the illustrated nomenclature shown in table I.

**S3. Changes.** When a Federal agency considers that a Federal Standard does not provide for its essential needs, written request for adding to otherwise changing the standard, supported by adequate justification, shall be sent to the Administration. This justification shall explain wherein the standard does not provide for essential needs. The request shall be sent in duplicate to the General Services Administration, Federal Supply Service, Standardization Division, Washington 25, D. C. The Administration will determine the appropriate action to be taken and will notify the agency.

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**TABLE I\***

**PRESSED BENDS, FORMS, SEAMS, AND JOINTS**



90 degree Flange



30 degree Flange



Flat Fold  
Crushed Hem  
Closed fold



Tear Drop Fold  
Tear Drop Hem



Double Hem



Offset  
Open Angle Offset



Return Flange  
Panel Formed Channel Shape



Open Fold  
Open Hem  
Open Bend



Side Bead'  
Closed Curl Off Center

\* When more than one name is used for an illustration, the first is the preferred designation.

TABLE I (Contd)

10



Center Bead  
Closed Curl on Center

11



Keyhole Section

12



270 degree Coiled Bend

13



Half Bead  
Half Curl

14



Split bead  
Split Curl.

15



Square Split Bead

16



Radius Form

17



Hat Section  
Square Hat Channel

18



Zee Brace

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TABLE I (Contd)

19



Channel  
Square Channel  
U-Channel

20



Angle  
Equal Leg Angle

21



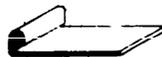
Folded Flange  
Return Flange

22



Folded V Form

23



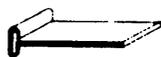
Folded Flange - reinforced

24



Folded flange &  
combined reinforcement

25



Tee

26



Tee reinforced

27



Channel Form and Flanged

TABLE I (Contd)

28



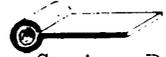
Channel form -  
reinforced

29



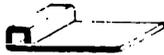
Wire Edge, Side Bead  
Wire Edge, closed curl  
off center

30



Wire Edge, Center Bead  
Wire Edge, closed curl  
on center

31



closed Square Bead

32



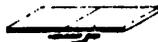
Box stiffener

33



Flush joint

34



Take-down joint

35



Malleated joint

36



Coach or blind joint

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TABLE I (Contd)

37



Common lock seam  
Hook Seam

38



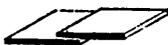
Clip joint

39



Clip joint

40



Ordinary lap seam  
Lap seam

41



Box channel

42



Flush seam  
single lock seam

43



Pittsburg lock seam

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Single copies of this standard are available without charge at the GSA Regional Offices in Boston, New York, Washington, D. C., Atlanta, Chicago, Kansas City, Mo., Dallas, Denver, San Francisco, and Auburn, Wash. Additional copies may be purchased for 5 cents each from the General Services Administration, Business Service Center, Washington 25, D. C.