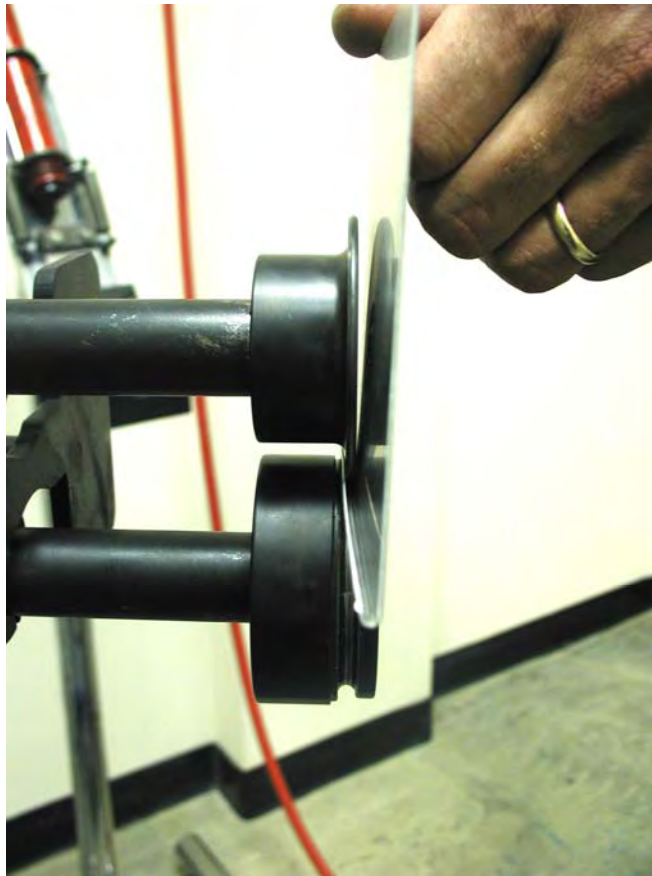
**STEP #1**

**Install Hem #1 Roll Set #201-059-S  
(Male roll on top)**

**To create 1/4" long 90-degree flange in metal edge**

**Push metal edge against edge-guide stop in female roll to create 90-degree flange.**

**Hold metal at same angle as long leg of female roll  
to prevent placing any unwanted marking on metal.**



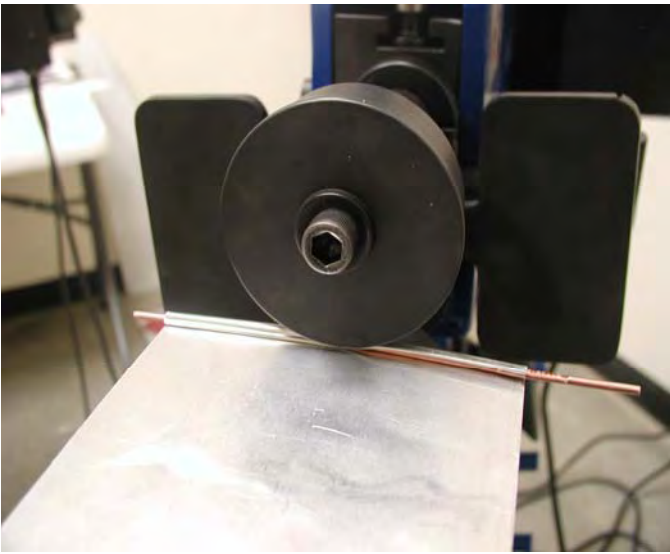
## **STEP #2**

Install J-Channel Roll Set #201-081-J  
(Male roll on top)

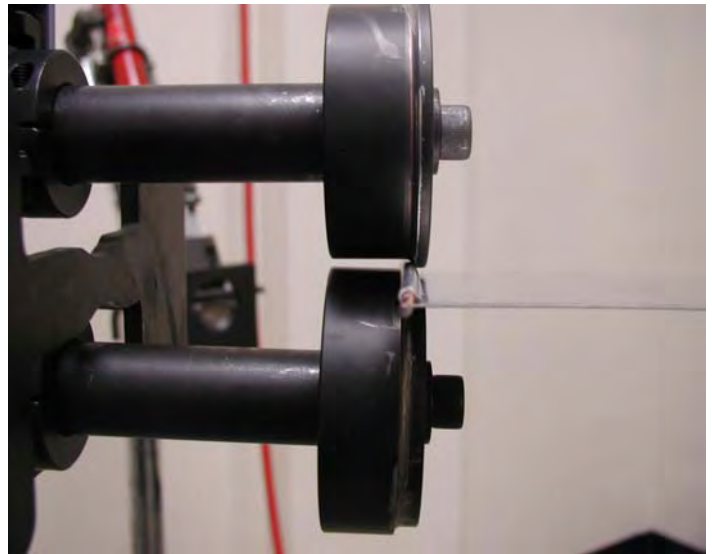
Hold metal as vertical as possible to upper male roll (see above)

Push edge of 90-degree flange against edge-guide stop in female roll  
as metal travels through roll pinch point to form J-Channel  
but leave flat outside surface

A second pass through the J-Channel rolls may help to create  
the good shape required



**STEP #3A**



**STEP #3B**

Install Wire Crimp Roll Set  
 #201-062-WB 1/16"  
 #201-125-WB 1/8"  
 (Male roll on top)

Pre-bend 1/8" OD wire to match shape (arc) of metal profile.

Place 1/8" wire into J-Channel and hold in with screwdriver  
 to nest wire into J-Channel.

Long leg of metal should be horizontal to lower female roll  
 as male roll moves the metal around the wire  
 (This should prevent any unwanted marking  
 on the front finished surface.)

A second pass may be required to get a complete wrap on the wire.

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