

# General Bending Instructions

## Important:

**All greenhouse hoops must be 12 to 30 inches wider across the base than the installed width.**

After bending the hoops, connect the sections together laying flat on the ground and measure across the base. Example if your bending a 12 ft wide hoop using any of our 12 ft benders, then the hoop must measure at between 13 to 15 feet across the base, when the two sections are connected and laying flat on the ground, if your building a 16 ft. or 20 ft wide hoop using any of our 20 ft benders, your loose measurement must be at least 17 to 18 feet across for the 16 ft. wide hoop and at least 21 to 23 feet across for the 20 ft wide hoop. This extra width is necessary because the hoops must be compressed inward to install into the ground anchor tubes. This is referred to as “post tension” which strengthens and smooths out the hoops.

**To start with purchase only enough tubing to build one or two test hoops.**

The reason for this is simple; some tubing these days, is made from a softer base metal. Because tubing springs back (rebounds) after being bent, tubing made from softer metal than normally used, it does not spring back as much after bending, which can result in a hoop that is under size. EXAMPLE: If your hoop is to be a 12 ft wide hoop. As discussed on the previous page, your finished width after bending must be between 13 and 15 feet wide.

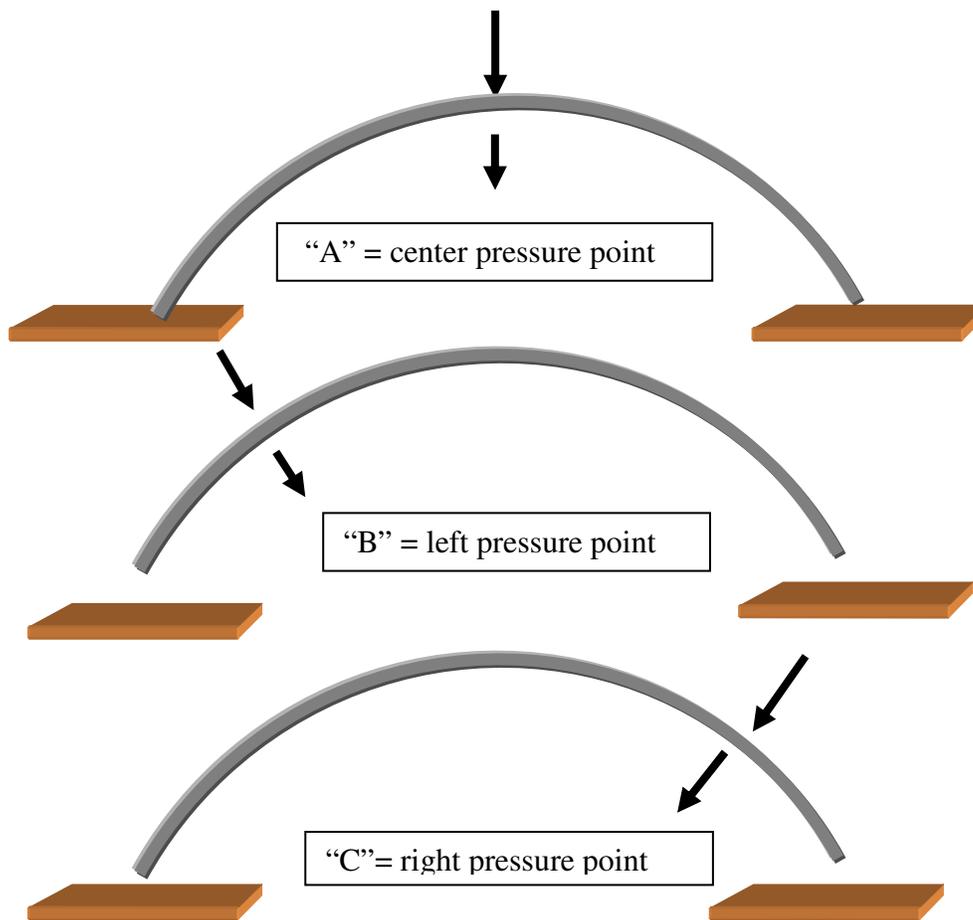
The extra foot or two will be compressed inward when installed into the post anchors. Let's say you bent the hoop and its 11 feet wide. The hoop must never be pulled outward to install, it must always be compressed. So what do you do about this problem?

Actually there is a fast and simple method to get the hoop out to the 13 foot width so it can then be compressed and installed as the required 12 ft hoop. We refer to this method of resizing as “Tune Out” it has been proven to work every time and produce good hoops. Never attempt to resize a hoop by any other method other than the following method.

The hoop tune out method is the same regardless of number of hoop sections in your hoop, one hoop section is 10'6" long. Ten and twelve wide hoops will have 2 sections the sixteen ft wide has 2 ½ sections and the twenty ft wide has 3 sections.

If you assembled your sections and the measurement is too narrow. Take the sections apart and spring out each section as follows. Place two small wood planks or thick cardboard on the ground so that each is positioned under the ends of a hoop section. While holding the

section at the center (point “A”) shown below, push the center of section down about two inches and release. The wood planks allow the hoop to slide outward as you push downward. Now move to point “B” on the same section, pushing downward about two inches, at the angle shown by arrows. Now move to point”C” and repeat this step again. Resize each section. Reassemble the sections and measure the width. The hoop will be wider now, if it still is a little narrow repeat the three point spring out steps above, reassemble and check hoop width. When the target width is achieved mark this hoop and use it as a pattern for the remaining hoops. Remember that none of the rest of the hoops need to match the pattern exactly, just as long as they or close, within a few inches. When all are compressed and installed they will all look exactly the same.



The three pressure points are the same on all 10' 6" long hoop sections. Applying pressure at these three points on each section and by allowing the ends to slide freely when pushing down, each section will uniformly be resized into wider hoops.