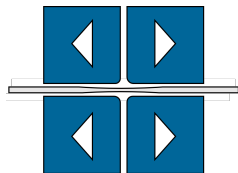
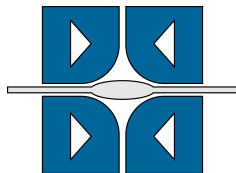


Stretching



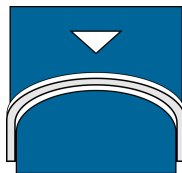
(a)

Shrinking



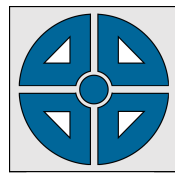
(b)

Finish Forming



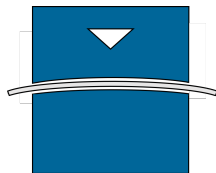
(c)

Flattening



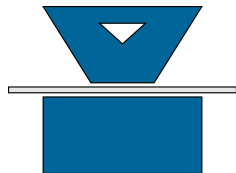
(d)

Doming



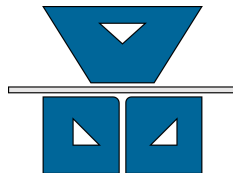
(e)

Planishing



(f)

Straightening



(g)

Edging



(h)



Sheet



Tooling



Motion of Tooling