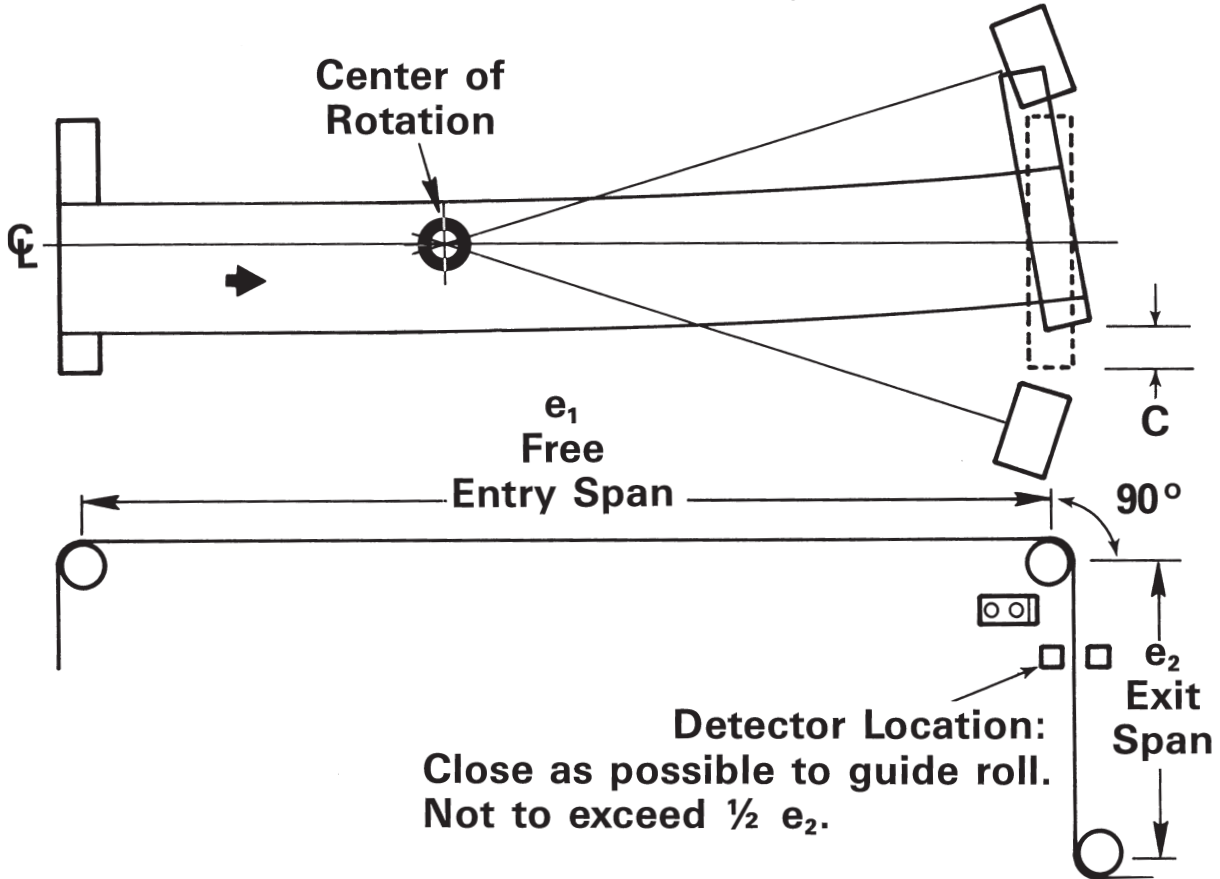


**STEERING GUIDE PRINCIPLE OF OPERATION  
for the Metals Industry**



**Formula (A)**

$$\pm C = \frac{9.0T}{tE} \left( \frac{e_1}{W} \right)^2$$

**Formula (B)**

$$e_1 = \frac{W}{3} \sqrt{\frac{C t E}{T}}$$

**NOMENCLATURE**

**C = Correction ability, adjust-guides (± inches)**

**T = Maximum total tension (pounds)**

**t = Web or strip thickness (inches)**

**W = Web or strip width (inches)**

**E = Modulus of elasticity (psi)**

**e<sub>1</sub> = Entry span length (inches)**

**e<sub>2</sub> = Exit span length (inches)**