



Sizes & Tolerances

| SIZE RANGE AND RESPECTIVE TOLERANCES OF FINISHED COMPONENTS | | | | | | | | | | | | | | |
|---|-----------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|----------------|-----------------|
| INNER DIAMETER | .825" | 1.00" | 1.25" | 1.50" | 1.75" | 2.00" | 2.25" | 2.50" | 3.00" | 4.00" | 5.00" | 6.00" | 7.00" - 15.00" | 16.00" - 24.00" |
| WALL THICKNESS (min.) | .006" | .008" | .008" | .010" | .012" | .015" | .015" | .015" | .015" | .020" | .025" | .025" | .030" | .050" |
| WALL THICKNESS (max.) | .062" | .100" | .125" | .130" | .145" | .155" | .200" | .225" | .275" | .375" | .500" | .500" | .500" | .500" |
| MAXIMUM LENGTH | 24" | 36" | 48" | 60" | 72" | 84" | 84" | 84" | 15 ft. | 18 ft. | 20 ft. | 24 ft. | 24 ft. | 24 ft. |
| INSIDE DIAMETER | ± .002" | ± .002" | ± .002" | ± .002" | ± .002" | ± .002" | ± .002" | ± .002" | ± .003" | ± .003" | ± .003" | ± .004" | ± .005" | ± .005" |
| WALL THICKNESS | ± .001" | ± .001" | ± .001" | ± .001" | ± .001" | ± .001" | ± .002" | ± .002" | ± .003" | ± .003" | ± .004" | ± .004" | ± .005" | ± .005" |
| ROUNDNESS (max.) | .002" | .002" | .003" | .002" | .003" | .003" | .003" | .003" | .003" | .004" | .004" | .006" | .008" | .010" |
| CONCENTRICITY (max.) | .001" | .001" | .001" | .001" | .001" | .002" | .002" | .002" | .002" | .002" | .002" | .002" | .002" | .003" |
| STRAIGHTNESS | .001"/ft. | .001"/ft. | .001"/ft. | .001"/ft. | .001"/ft. | .001"/ft. | .001"/ft. | .001"/ft. | .001"/ft. | .001"/ft. | .001"/ft. | .001"/ft. | .001"/ft. | .001"/ft. |
| INT. SURFACE FINISH (μinch) | 8 | 8 | 8 | 8 | 8 | 8 | 16 | 16 | 16 | 16 | 16 | 16 | 16 | 16 |
| EXT. SURFACE FINISH (μinch) | 16 | 16 | 16 | 16 | 16 | 16 | 32 | 32 | 32 | 32 | 32 | 32 | 32 | 32 |

Note: This matrix is offered as a basic point of reference for dimensional accuracies off the flowforming equipment. The specified minimum and maximum wall thicknesses for a given diameter range, as well as other shown limits, are not fixed and can be varied to meet your requirements. It should be noted, however, that the degree of dimensional accuracy is highly dependent on the component's material, size and/or thickness, as well as possible distortion caused by any required post-forming heat treatment. As such, applicability of dimensional tolerances is on a case by case basis.