### Flex Tubing

#### Low Carbon Steel

<table>
<thead>
<tr>
<th>Length</th>
<th>10'</th>
<th>15'</th>
<th>17'</th>
</tr>
</thead>
<tbody>
<tr>
<td>Gauge</td>
<td>16</td>
<td>17</td>
<td>15</td>
</tr>
<tr>
<td>Thickness</td>
<td>.042</td>
<td>.054</td>
<td>.065</td>
</tr>
</tbody>
</table>

#### Bendable 409 Stainless Steel Tubing

<table>
<thead>
<tr>
<th>Length</th>
<th>10'</th>
</tr>
</thead>
<tbody>
<tr>
<td>Gauge</td>
<td>14</td>
</tr>
<tr>
<td>OD</td>
<td></td>
</tr>
<tr>
<td>2</td>
<td></td>
</tr>
<tr>
<td>2¼</td>
<td></td>
</tr>
<tr>
<td>2½</td>
<td></td>
</tr>
<tr>
<td>3</td>
<td></td>
</tr>
<tr>
<td>4</td>
<td></td>
</tr>
<tr>
<td>5</td>
<td></td>
</tr>
</tbody>
</table>

**Note:** Bending characteristics of stainless steel tubing are substantially different than low carbon steel tubing. Listed below are important factors in successfully bending stainless steel tubing.

1. Wing die (back) pressure may need to be increased to prevent backwall collapse.
2. The tube weld seam should be located 90° from the inside and outside of any severe bends.
3. Wing dies must be in good condition and in alignment throughout the entire bending arc.
4. Bends should be made in one continuous operation at a slow rate of speed.
5. Bends should not be made tighter than two times pipe diameter.
6. Equipment must be in proper operating condition.

### Standard Straight Tubing

#### Non-Bendable

<table>
<thead>
<tr>
<th>Length</th>
<th>Standard Thickness</th>
<th>H.D. Thickness</th>
<th>Standard Thickness</th>
<th>H.D. Thickness</th>
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</thead>
<tbody>
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<td>1</td>
<td>10'</td>
<td>10'</td>
<td>10'</td>
<td>10'</td>
</tr>
<tr>
<td>1¼</td>
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<td>10'</td>
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<td>10'</td>
<td>10'</td>
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<tr>
<td>2½</td>
<td>10'</td>
<td>10'</td>
<td>10'</td>
<td>10'</td>
</tr>
<tr>
<td>3</td>
<td>10'</td>
<td>10'</td>
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<td>4</td>
<td>10'</td>
<td>10'</td>
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<td>5</td>
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<td>10'</td>
</tr>
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<td>6</td>
<td>10'</td>
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<td>10'</td>
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</tbody>
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### Comparison of Gauge to Decimal

<table>
<thead>
<tr>
<th>Gauge</th>
<th>Decimal</th>
</tr>
</thead>
<tbody>
<tr>
<td>13</td>
<td>0.082</td>
</tr>
<tr>
<td>14</td>
<td>0.069/0.075</td>
</tr>
<tr>
<td>15</td>
<td>0.065</td>
</tr>
<tr>
<td>16</td>
<td>0.055/0.060</td>
</tr>
<tr>
<td>17</td>
<td>0.050/0.054</td>
</tr>
<tr>
<td>18</td>
<td>0.042</td>
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</tbody>
</table>