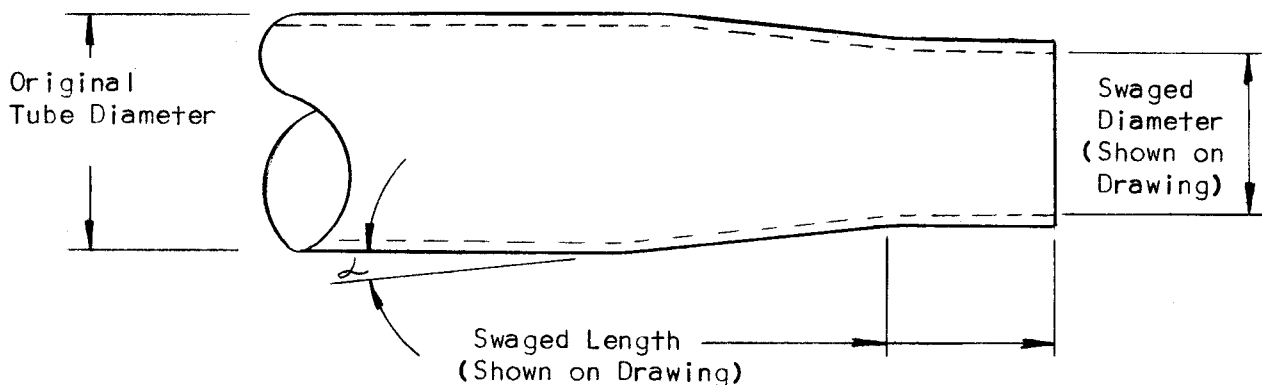


STANDARDS SHEET



Requirements for Swaged Tubing

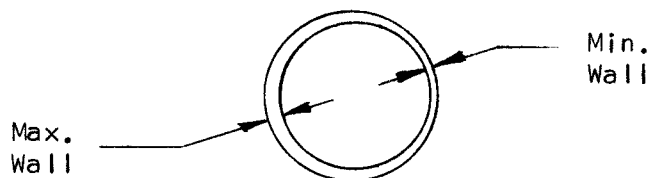
For all swaged tubing the angle α shall be 5° unless design requirements dictate otherwise.

When outside and inside diameters are specified, the allowable deviation in wall thickness at any point (eccentricity) shall not be more than plus or minus 10 percent of the mean wall thickness.

When only the inside diameter is specified, the mean wall thickness is the average of the maximum and minimum wall thickness measurements.

The swaged minimum wall thickness shall never be less than the nominal (purchased) wall thickness. Standard tubing tolerance of 10% of nominal wall thickness applicable to the minimum swaged wall thickness.

If not specified otherwise, machining is permissible to produce the inside diameter. No steps are to occur in the machined area, the machining shall be carried through to the tapered portion of the swage unless otherwise specified.



DRAWN	D. SHAW	CLASSIFICATION	STANDARD
CHECKED	D. SHAW	TUBE - SWAGED	DS 51
STRESSED	J. THOMPSON		
APPROVED	G. LUSBY		

REVISED

S. SHATTNER

18.4.68

(A)