Hydra-Tool

Recommended Flaring Pressures For Metric Tube

Size (mm)	Material	Tube Wall Thickness 1.0	1.5	2.0	2.5	3.0	Min. Straight Length to Start of Bend
6	SS	400	700	1100			1-5/8
	Steel	300	500	800			
	Copper	150	200	350			
	Aluminum	150	200	350			
8	SS	500	800	1300			1-5/8
	Steel	400	600	1000			
	Copper	150	250	400			
	Aluminum	150	250	400			
10	SS	600	900	1500			1-5/8
	Steel	500	700	1100			
	Copper	200	300	500			
	Aluminum	200	300	500			
12	SS	800	1200	2000	2500		2-3/16
	Steel	600	900	1500	1900		
	Copper	250	350	600	750		
	Aluminum	250	350	600	750		
16	SS	900	2000	2500	2800	3000	2-5/16
	Steel	680	1500	1900	2100	2300	
	Copper	275	600	750	800	900	
	Aluminum	275	600	750	800	900	
18	SS	1000	1700	2500	3100	3500	2-5/16
	Steel	750	1300	1900	2300	2700	
	Copper	300	500	750	900	1100	
	Aluminum	300	500	750	900	1100	
20	SS		1500	2400	3000	3400	2-7/16
	Steel		1100	1800	2300	2600	
	Copper		500	700	900	1000	
	Aluminum		500	700	900	1000	
25	SS			2400	3000	3400	2-7/16
	Steel			1800	2300	2600	
	Copper			700	900	1000	
	Aluminum			700	900	1000	
30	SS			2800	3400	4000	2-1/2
	Steel			2100	2600	3000	
	Copper			800	1000	1200	
	Aluminum			800	1000	1200	
32	SS				4000	4500	2-7/8
	Steel				3000	3400	
	Copper				1200	1300	
	Aluminum				1200	1300	
38	SS				4500	5800	2-7/8
	Steel				3400	4400	
	Copper				1300	1700	
	Aluminum				1300	1700	
42	SS				4700	6500	2-7/8
	Steel				3600	5200	
	Copper				1500	1900	
	Aluminum				1500	1900	
50	SS				5200	7200	2-7/8
	Steel				3900	6100	
	Copper				1900	2300	
	Aluminum				1900	2300	

Table V17 — Recommended Flaring Pressures, Metric Tube

Dimensions and pressures for reference only, subject to change.