

Approximate Tube Inside Diameters Before & After Roller Expansion (mm)

Tube Inside Diameters As Manufactured																
Wall Thickness		Tube OD														
		3/8	1/2	5/8	3/4	7/8	1	1 1/8	1 1/4	1 3/8	1 1/2	1 5/8	1 3/4	2	2 1/4	2 1/2
BWG	Decimal	9.53	12.70	15.88	19.05	22.23	25.40	28.58	31.75	34.93	38.10	41.28	44.45	50.80	57.15	63.50
8	4.19	1.14	4.32	7.49	10.67	13.84	17.02	20.19	23.37	26.54	29.72	32.89	36.07	42.42	48.77	55.12
9	3.76	2.01	5.18	8.36	11.53	14.71	17.88	21.06	24.23	27.41	30.58	33.76	36.93	43.28	49.63	55.98
10	3.40	2.72	5.89	9.07	12.24	15.42	18.59	21.77	24.94	28.12	31.29	34.47	37.64	43.99	50.34	56.69
11	3.05	3.43	6.60	9.78	12.95	16.13	19.30	22.48	25.65	28.83	32.00	35.18	38.35	44.70	51.05	57.40
12	2.77	3.99	7.16	10.34	13.51	16.69	19.86	23.04	26.21	29.39	32.56	35.74	38.91	45.26	51.61	57.96
13	2.41	4.70	7.87	11.05	14.22	17.40	20.57	23.75	26.92	30.10	33.27	36.45	39.62	45.97	52.32	58.67
14	2.11	5.31	8.48	11.66	14.83	18.01	21.18	24.36	27.53	30.71	33.88	37.06	40.23	46.58	52.93	59.28
15	1.83	5.87	9.04	12.22	15.39	18.57	21.74	24.92	28.09	31.27	34.44	37.62	40.79	47.14	53.49	59.84
16	1.65	6.22	9.40	12.57	15.75	18.92	22.10	25.27	28.45	31.62	34.80	37.97	41.15	47.50	53.85	60.20
17	1.47	6.58	9.75	12.93	16.10	19.28	22.45	25.63	28.80	31.98	35.15	38.33	41.50	47.85	54.20	60.55
18	1.25	7.04	10.21	13.39	16.56	19.74	22.91	26.09	29.26	32.44	35.61	38.79	41.96	48.31	54.66	61.01
19	1.07	7.39	10.57	13.74	16.92	20.09	23.27	26.44	29.62	32.79	35.97	39.14	42.32	48.67	55.02	61.37
20	0.89	7.75	10.92	14.10	17.27	20.45	23.62	26.80	29.97	33.15	36.32	39.50	42.67	49.02	55.37	61.72
21	0.81	7.90	11.07	14.25	17.42	20.60	23.77	26.95	30.12	33.30	36.47	39.65	42.82	49.17	55.52	61.87
22	0.71	8.10	11.28	14.45	17.63	20.80	23.98	27.15	30.33	33.50	36.68	39.85	43.03	49.38	55.73	62.08
23	0.64	8.26	11.43	14.61	17.78	20.96	24.13	27.31	30.48	33.66	36.83	40.01	43.18	49.53	55.88	62.23
24	0.56	8.41	11.58	14.76	17.93	21.11	24.28	27.46	30.63	33.81	36.98	40.16	43.33	49.68	56.03	62.38

Tube Inside Diameters After Roller Expansion																
Wall Thickness		Tube OD														
		3/8	1/2	5/8	3/4	7/8	1	1 1/8	1 1/4	1 3/8	1 1/2	1 5/8	1 3/4	2	2 1/4	2 1/2
BWG	Decimal	9.53	12.70	15.88	19.05	22.23	25.40	28.58	31.75	34.93	38.10	41.28	44.45	50.80	57.15	63.50
8	4.19	1.98	5.16	8.33	11.51	14.68	17.86	21.03	24.21	27.38	30.56	33.73	36.91	43.26	49.61	55.96
9	3.76	2.76	5.93	9.11	12.28	15.46	18.63	21.81	24.98	28.16	31.33	34.51	37.68	44.03	50.38	56.73
10	3.40	3.40	6.57	9.75	12.92	16.10	19.27	22.45	25.62	28.80	31.97	35.15	38.32	44.67	51.02	57.37
11	3.05	4.04	7.21	10.39	13.56	16.74	19.91	23.09	26.26	29.44	32.61	35.79	38.96	45.31	51.66	58.01
12	2.77	4.54	7.72	10.89	14.07	17.24	20.42	23.59	26.77	29.94	33.12	36.29	39.47	45.82	52.17	58.52
13	2.41	5.18	8.36	11.53	14.71	17.88	21.06	24.23	27.41	30.58	33.76	36.93	40.11	46.46	52.81	59.16
14	2.11	5.73	8.91	12.08	15.26	18.43	21.61	24.78	27.96	31.13	34.31	37.48	40.66	47.01	53.36	59.71
15	1.83	6.23	9.41	12.58	15.76	18.93	22.11	25.28	28.46	31.63	34.81	37.98	41.16	47.51	53.86	60.21
16	1.65	6.55	9.73	12.90	16.08	19.25	22.43	25.60	28.78	31.95	35.13	38.30	41.48	47.83	54.18	60.53
17	1.47	6.87	10.05	13.22	16.40	19.57	22.75	25.92	29.10	32.27	35.45	38.62	41.80	48.15	54.50	60.85
18	1.25	7.28	10.46	13.63	16.81	19.98	23.16	26.33	29.51	32.68	35.86	39.03	42.21	48.56	54.91	61.26
19	1.07	7.60	10.78	13.95	17.13	20.30	23.48	26.65	29.83	33.00	36.18	39.35	42.53	48.88	55.23	61.58
20	0.89	7.92	11.10	14.27	17.45	20.62	23.80	26.97	30.15	33.32	36.50	39.67	42.85	49.20	55.55	61.90
21	0.81	8.06	11.24	14.41	17.59	20.76	23.94	27.11	30.29	33.46	36.64	39.81	42.99	49.34	55.69	62.04
22	0.71	8.25	11.42	14.60	17.77	20.95	24.12	27.30	30.47	33.65	36.82	40.00	43.17	49.52	55.87	62.22
23	0.64	8.38	11.56	14.73	17.91	21.08	24.26	27.43	30.61	33.78	36.96	40.13	43.31	49.66	56.01	62.36
24	0.56	8.52	11.69	14.87	18.04	21.22	24.39	27.57	30.74	33.92	37.09	40.27	43.44	49.79	56.14	62.49

NOTE: TUBE INSIDE DIAMETERS AFTER ROLLER EXPANSION ARE ESTIMATED ASSUMING A 10% WALL THICKNESS LOSS, FORMULA = [(OD - 2 * (WT * 0.9)]

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