



TABLE ACCOMPANYING FIGURE 8

Nominal tube O.D.	Hole DIA D (mm)	Hole DIA D (in)
1/8 in .....	3.96	0.156
5/32 in .....	4.75	0.187
3/16 in .....	5.54	0.218
1/4 in .....	7.14	0.281
5/16 in .....	8.71	0.343
3/8 in .....	10.31	0.406
1/2 in .....	13.49	0.531
5/8 in .....	16.66	0.656
3/4 in .....	20.32	0.800
6 mm .....	6.80	0.268
8 mm .....	8.80	0.346
10 mm .....	10.80	0.425
12 mm .....	12.80	0.504
16 mm .....	16.80	0.661

**S12.8 Low temperature flexibility test.**

(a) Utilize a cylinder having a radius of six times the nominal outside diameter of the tubing.

(b) Condition the tubing in an air oven at 230 °F for 24 hours. Remove from the oven and cool at room temperature for 30 minutes.

(c) Condition the cylinder and the tubing in an environmental chamber at minus 40 °F for four hours.

(d) With the tubing and test cylinder at minus 40 °F, bend the tubing 180 degrees around the cylinder at a steady rate in a period of 4 to 8 seconds.

**S12.9 High temperature flexibility test.**

(a) Utilize a cylinder having a radius of two times the nominal outside diameter of the tubing.

(b) Bend the tubing 180 degrees around the cylinder and hold in place with a clamp or other suitable support, applying only enough force on the tubing to hold it in position.

(c) Condition the tubing and cylinder in an air oven at 230 °F for 72 hours. Remove the tubing and cylinder from the oven and cool at room temperature for two hours.

(d) Remove the clamps or supports from the tubing and straighten the tubing at a steady rate in a period of 4 to 8 seconds.

(e) Rebend the tubing 180 degrees around the mandrel, at the same point