

Diameter to Radius Ratio	Anticipated reduction in wall thickness (from actual starting thickness)
2.0D (Radius / OD)	18.0%
2.0D (Radius / NB)	20.0%
2.5D (Radius / OD)	16.0%
2.5D (Radius / NB)	17.0%
3.0D (Radius / OD)	15.0%
3.0D (Radius / NB)	16.0%
4.0D (Radius / OD)	9.0%
4.0D (Radius / NB)	10.0%
5.0D (Radius / OD)	8.0%
5.0D (Radius / NB)	8.0%
6.0D (Radius / OD)	6.0%
6.0D (Radius / NB)	6.0%



Diameter to Radius Ratio	Anticipated Ovality ((Maximum OD – minimum OD) / nominal OD) * 100							
	OD / WT = '10'	OD / WT = '20'	OD / WT = '30'	OD / WT = '40'	OD / WT = '50'	OD / WT = '60'	OD / WT = '70'	OD / WT = '80'
2.0D (Radius / OD)	3.7%	4.7%	5.7%					
2.0D (Radius / NB)	4.0%	5.1%	6.2%					
2.5D (Radius / OD)	3.2%	3.8%	4.7%	5.5%				
2.5D (Radius / NB)	3.5%	4.1%	5.1%	6.0%				
3.0D (Radius / OD)	2.8%	3.4%	4.2%	4.8%	5.5%			
3.0D (Radius / NB)	3.0%	3.7%	4.6%	5.2%	6.0%			
4.0D (Radius / OD)	2.3%	2.8%	3.3%	3.8%	4.3%	4.8%		
4.0D (Radius / NB)	2.5%	3.0%	3.6%	4.1%	4.7%	5.3%		
5.0D (Radius / OD)	2.1%	2.5%	2.8%	3.3%	3.7%	4.1%	4.5%	
5.0D (Radius / NB)	2.3%	2.7%	3.0%	3.6%	4.0%	4.6%	4.9%	
6.0D (Radius / OD)	1.8%	2.3%	2.6%	2.8%	3.3%	3.6%	3.8%	4.4%
6.0D (Radius / NB)	2.0%	2.5%	2.8%	3.0%	3.6%	3.9%	4.1%	4.9%

