

3.10.2. Grooves for hydraulic expanding

The current edition of the TEMA Standards requires grooves for hydraulic expanding to be 6.35 mm wide. Although this width is suitable for most materials, use Eq. 2 to optimize the groove width.

$$W = 1.56\sqrt{Rt} \quad (2)$$

In this equation, W is the optimal width, R is the mean tube radius, and t is the tube wall thickness.