The forming of a flat steel circle into any head shape entails displacement of metal. It is not possible during forming to maintain complete uniformity of thickness in the finished head. Areas of critical forming, such as the radius, will thin out slightly. Minimum thickness therefore, should be specified as the thickness required at the thinnest point in the head after forming. To determine the allowance which must be made to maintain minimum gage, refer to the following table.

OUTSIDE DIAMETER 2:1 ELLIPTICAL **ONLY**

	1-1/2" SF		**2"SF**																										
Thickness	6-5/8 OD	8-5/8 OD	10-3/4 OD	12-3/4 OD	14 OD	16 OD	18 OD	20 OD	22 OD	24 OD	26 OD	28 OD	30 OD	32 OD	34 OD	36 OD	38 OD	40 OD	42 OD	44 OD	46 OD	48 OD	50 OD	52 OD	54 OD	56 OD	58 OD	60 OD	66 OD	72 OD
1/4"	0.215	0.215	0.215	0.221	0.221	0.226	0.226	0.226	0.226	0.226	0.226	0.226	0.226	0.226	N/A	0.226	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A
5/16"	0.262	0.262	0.262	0.262	0.29	0.29	0.29	0.29	0.29	0.29	0.29	0.29	0.29	0.29		0.3														
3/8"	0.328	0.328	0.328	0.328	0.328	0.328	0.328	0.34	0.34	0.34	0.34	0.34	0.34	0.34	0.34	0.34	0.34	0.34	0.34	0.34	0.34	0.34								
1/2"	0.39	0.4	0.439	0.439	0.44	0.45	0.46	0.46	0.46	0.46	0.46	0.46	0.46	0.46	0.46	0.46	0.46	0.46	0.46	0.46	0.46	0.46	0.46	0.46	0.46	0.46	0.46	0.46		
5/8"	0.53	0.55	0.55	0.555	0.555	0.555	0.564	0.564	0.564	0.564	0.565	0.565	0.587	0.587	0.587	0.596	0.596	0.596	0.596	0.596	0.596	0.596	0.596	0.596	0.596	0.596	0.596	0.596	0.596	
3/4"	0.562	0.613	0.64	0.667	0.667	0.667	0.67	0.686	0.69	0.69	0.69	0.7	0.7	0.7	0.7	0.709	0.709	0.709	0.709	0.709	0.71	0.71	0.71	0.71	0.71	0.71	0.71	0.71	0.71	0.71
7/8"	0.692	0.692	0.758	0.76	0.77	0.77	0.79	0.812	0.82	0.82	0.825	0.83	0.83	0.837	0.837	0.837	0.84	0.84	0.84	0.84	0.84	0.84	0.84	0.84	0.84	0.84	0.84	0.84	0.84	
1"	0.75	0.82	0.825	0.86	0.875	0.89	0.91	0.917	0.917	0.917	0.917	0.917	0.917	0.917	0.95	0.95	0.95	0.95	0.95	0.95	0.95	0.95	0.95	0.95	0.95	0.95	0.95	0.95	0.95	
1-1/8"		N/A	0.916	0.916	0.916	1	1	1.003	1.003	1.007	1.007	1.03	1.03	1.03	1.03	1.03	1.03	1.053	1.053	1.053	1.053	1.053	1.053	1.053	1.053	1.053	1.053	1.053		
1-1/4"		1.002	1.053	1.06	1.06	1.06	1.125	1.14	1.14	1.145	1.15	1.17	1.178	1.178	1.178	1.18	1.2	1.2	1.2	1.2	1.2	1.2	1.2	1.2	1.2	0.12	1.2	1.2		
1-3/8"			1.062	1.062	1.062	1.23	1.25	1.25	1.27	1.28	1.28	1.28	1.28	1.3	1.28	1.28	1.28	1.3	1.3	1.3	1.3	1.33	1.33	1.33	1.33	1.33	1.33	1.33		
1-1/2"			1.07	1.1	1.13	1.27	1.3	1.33	1.33	1.34	1.35	1.375	1.375	1.39	1.375	1.41	1.41	1.41	1.41	1.41	1.41	1.41	1.41	1.41	1.41	1.41	1.41	1.41		
1-5/8"	N/A			1.25	1.25	1.25	1.4	1.4	1.4	1.4	1.4	1.4	1.5	1.5	1.5	1.53	1.53	1.53	1.53	1.53	1.53	1.53	1.53	1.53	1.53	1.53	1.53	1.53	N/A	N/A
1-3/4"		N/A		1.38	1.39	1.5	1.52	1.54	1.55	1.56	1.56	1.56	1.6	1.6	1.6	1.62	1.62	1.636	1.669	1.669	1.688	1.688	1.688	1.688	1.688	1.688	1.688	1.688		
2"			N/A		1.62	1.625	1.7	1.75	1.75	1.75	1.83	1.83	1.83	1.83	1.83	1.875	1.875	1.875	1.875	1.875	1.875	1.875	1.875	1.875	1.875	1.875	1.875	1.875		
2-1/4"				N/A	1.72	1.8	1.81	1.85	1.9	2	2	2	2.05	2.05	2.05	2.095	2.095	2.095	2.095	2.095	2.095	2.16	2.16	2.16	2.16	2.16	2.16	2.16		
2-1/2"					1.875	1.892	1.9	2.043	2.062	2.156	2.156	2.156	2.156	2.156	2.156	2.156	2.33	2.33	2.33	2.33	2.33	2.33	2.33	2.33	2.33	2.33	2.33	2.33		
3"					N/A	N/A	N/A	2.284	2.284	2.284	2.54	2.54	2.54	2.54	2.54	2.87	2.87	2.87	2.87	2.87	2.87	2.87	2.87	2.87	2.87	2.87	2.87	2.87		

INSIDE DIAMETER 2:1 ELLIPTICAL **ONLY**

	2"SF																	
Thickness	24 ID	30 ID	36 ID	42 ID	48 ID	54 ID	60 ID	61 ID	62 ID	63 ID	64 ID	65 ID	66 ID	67 ID	72 ID	78 ID	84 ID	90 ID	96 ID
1/4"	0.226	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A
3/8"	0.34	0.34	0.34	0.34	0.34														
1/2"	0.46	0.46	0.46	0.46	0.46	0.46	0.46												
5/8"	0.564	0.587	0.596	0.596	0.596	0.596	0.596						0.596						
3/4"	0.69	0.7	0.709	0.709	0.71	0.71	0.71	0.71	0.71	3710	0.71	0.71	0.7	0.71	0.71	0.71			
7/8"	0.82	0.83	0.837	0.84	0.84	0.84	0.84	0.84	0.84	0.84	0.84	0.84	0.84	0.84	0.84	N/A			
1"	0.917	0.917	0.95	0.95	0.95	0.95	0.95	0.95	0.95	0.95	0.95	0.95	0.95	0.95	0.95	0.95	0.95	0.95	0.95
1-1/8"	1.007	1.03	1.03	1.053	1.053	1.053	1.053	1.053	1.053	1.053	1.053	1.053	1.053	1.053	1.053	1.053	1.053	1.053	1.053
1-1/4"	1.145	1.178	1.18	1.2	1.2	1.2	1.2	1.2	1.2	1.2	1.2	1.2	1.2	1.2	1.2	1.2	1.2	1.2	1.2
1-3/8"	1.28	1.28	1.28	1.3	1.33	1.33	1.33	1.33	1.33	1.33	1.33	1.33	1.33	1.33	1.33	1.33	1.33	1.33	1.33
1-1/2"	1.34	1.375	1.41	1.41	1.41	1.41	1.41	1.41	1.41	1.41	1.41	1.41	1.41	1.41	1.41	1.41	1.41	1.41	1.41
1-5/8"	1.4	1.5	1.53	1.53	1.53	1.53	1.53	1.53	1.53	1.53	1.53	1.53	1.53	1.53	1.53	1.53	1.53	1.53	1.688
1-3/4"	1.56	1.6	1.62	1.669	1.688	1.688	1.688	1.688	1.688	1.688	1.688	1.688	1.688	1.688	1.688	1.688	1.688	1.688	
2"	1.83	1.83	1.875	1.875	1.875	1.875	1.875	1.875	1.875	1.875	1.875	1.875	1.875	1.875	1.875	1.875	1.875	1.875	
2-1/4"	2	2.05	2.095	2.095	2.16	2.16	2.16	2.16	2.16	2.16	2.16	2.16	2.16	2.16	2.16	2.16	2.16	2.16	N/A
2-1/2"	2.156	2.156	2.156	2.33	2.33	2.33	2.33	2.33	2.33	2.33	2.33	2.33	2.33	2.33	2.33	2.33	2.33	2.33	
3"	2.284	2.87	2.87	2.87	2.87	2.87	2.87	2.87	2.87	2.87	2.87	2.87	2.87	2.87	2.87	2.87	2.87	2.87	

All Minimum thicknesses shown are subject to change without notice.

All heads requiring a minimum thickness must be ordered to that minimum thickness.

Please inquire if your dimensions are in our range but not listed.

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