

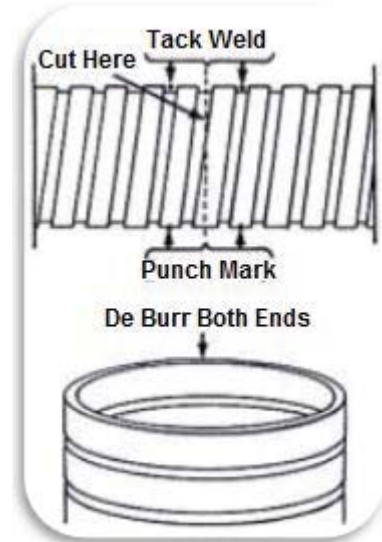
Manufacturer's Flex Cutting Process

Cutting, or Altering flex from Grand Rock will void warranty.

Flex tubing can twist and or unravel when cut, causing its diameter to change and making installation difficult. This occurs because flex tubing must maintain flexibility in order to function properly, and therefore, cannot be tightly wound in the manufacturing process. However, flex tubing can be managed for trouble-free installation by following these guidelines.

CUTTING INSTRUCTIONS

1. **Preparation:** Put a tack weld between the convolutions on each side of the area to be cut, this will keep the ends from unraveling or twisting.
When a welder is not used, insert a backup pipe or mandrel inside the tubing and use a punch to mark directly onto the convolutions on each side of the area being cut.
2. **Cutting:** Use a vise to hold the tubing securely. Cut with a hacksaw with a blade with 32 teeth per inch or a metal cutting band saw.
3. **Trim:** Each side of the cut will now have a spiral "tail" that must be removed to the point at which it is attached. Bend each tail until it breaks or bend and use a cutting shear to remove.
4. **DE burring:** Completely de burr both cut surfaces either with a drum sander or by filing.



The function of flexible tubing is to prevent excessive stresses on exhaust system components. Flexible tubing absorbs vibration and thermal expansion that could cause the exhaust systems components to break or shake loose.

Flexible tubing should be installed in a half extended state for retaining its flexibility. To meet this need, place the middle of the tube over an edge of a work bench, pushing down on both halves and bend as far as possible.



After extending, place the whole piece of tubing on a work bench and push the end down until the tubing is completely straightened. The tubing will now be at half extension.

WE PROVIDE THE ANSWER WITH PROPERLY PRE-CUT AND EXTENDED FLEXIBLE INTERLOCKED TUBING IN VARIOUS PRE-CUT, EXTENDED LENGTHS.

ATTENTION: DO NOT USE FLEX TUBING TO FORM AN EXHAUST PIPE BEND. ALWAYS USE AN ELBOW.



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Exhaust Solutions