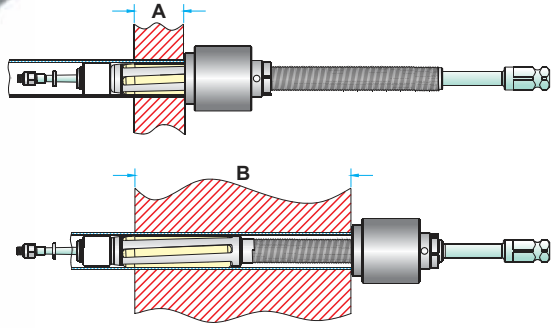


1200-5 SERIES FIVE ROLL FOR THIN WALL TUBES

$\frac{3}{4}$ " - $1\frac{1}{2}$ "
 O.D.

1200-5 SERIES



FOR TUBES INTERNAL DIAMETER
 FROM (14.8 mm) .584" TO (36.3 mm) 1.43"

| | TUBE EXPANDERS FITTED WITH ROLLER LENGTH | FOR TUBE SHEET ADJUSTABLE RANGE | |
|-----------------|--|------------------------------------|-------------------|
| | | MINIMUM A | MAXIMUM B |
| (38.1mm) 1.1/2" | STD. REACH | (38.1mm) 1.1/2" | (152.4mm) 6" |
| | "A" REACH | (38.1mm) 1.1/2" | (203.2mm) 8" |
| | "B" REACH | (38.1mm) 1.1/2" | (253.8mm) 10" |
| | "C" REACH | (38.1mm) 1.1/2" | (304.6mm) 12" |
| (57.1mm) 2.1/4" | STD. REACH | (57.1mm) 2.1/4" | (171.4mm) 6.3/4" |
| | "A" REACH | (57.1mm) 2.1/4" | (222.1mm) 8.3/4" |
| | "B" REACH | (57.1mm) 2.1/4" | (272.8mm) 10.3/4" |
| | "C" REACH | (57.1mm) 2.1/4" | (323.6mm) 12.3/4" |

- Use : Highly recommended for use on thin walled tubes (19 thru 22 gage walls) of Stainless Steel, Titanium, Incoloy and other exotic materials in thick tube sheets.
- Advantages : Gives a more concentric and even expansion when expanding thin walled tubes vs. a conventional 3 roll expander and reduces tube spring back effect.
- Expanders for tube sizes not listed below are also available. Please enquire.

| Tube O.D. (mm) inch | Tube Thickness | | | Tube I.D. | | Minimum I.D. Tool Enters | | Maximum Expansion of Tool | | EXPANDER with (38.10 mm) 1.1/2" Long Rollers | | | EXPANDER with (57.15) 2.1/4" Long Rollers | | |
|---------------------------|----------------|------|------|-----------|-------|-----------------------------|-------|------------------------------|-------|---|----------------|---------------------|--|----------------|---------------------|
| | bwg | mm | inch | mm | inch | mm | inch | mm | inch | Complete Tool No. | Mandrel No. | Rollers Set. No. | Complete Tool No. | Mandrel No. | Rollers Set. No. |
| 3/4 (19.05) | 14 | 2.10 | .083 | 14.8 | .584 | 14.5 | .574 | 16.2 | .639 | 1223-5 | 1224-5 | R-6-5 | 1224-5 | 1224-5 | R-6-A-5 |
| | 15 | 1.82 | .072 | 15.3 | .606 | 14.9 | .590 | 16.7 | .661 | 1225-5 | 1226-5 | R-7-5 | 1226-5 | 1226-5 | R-7-A-5 |
| | 16 | 1.65 | .065 | 15.7 | .620 | 15.3 | .605 | 17.4 | .685 | 1227-5 | M-63 | R-7-5 | 1228-5 | M-63 | R-7-A-5 |
| | 17 | 1.47 | .058 | 16.1 | .634 | 15.7 | .619 | 17.8 | .699 | 1230-5 | 1230-5 | R-7-5 | 1230-5 | 1230-5 | R-7-A-5 |
| | 18 | 1.24 | .049 | 16.5 | .652 | 15.7 | .619 | 17.8 | .699 | 1229-5 | 1230-5 | R-7-5 | 1230-5 | 1230-5 | R-7-A-5 |
| | 19 | 1.06 | .042 | 16.9 | .666 | 16.3 | .642 | 18.5 | .722 | 1231-5 | M-63 | R-9-5 | 1232-5 | M-63 | R-9-A-5 |
| | 20 | 0.88 | .035 | 17.2 | .680 | 16.3 | .642 | 18.5 | .722 | 1231-5 | M-63 | R-9-5 | 1232-5 | M-63 | R-9-A-5 |
| | 21 | 0.81 | .032 | 17.4 | .686 | 16.3 | .642 | 18.5 | .722 | 1231-5 | M-63 | R-9-5 | 1232-5 | M-63 | R-9-A-5 |
| 1 (25.40) | 14 | 2.10 | .083 | 21.1 | .834 | 20.5 | .810 | 23.0 | .909 | 1249-5 | 1250-5 | R-12-5 | 1250-5 | 1250-5 | R-12-A-5 |
| | 15 | 1.82 | .072 | 21.7 | .856 | 21.2 | .837 | 23.7 | .936 | 1251-5 | 1251-5 | R-13-5 | 1252-5 | 1251-5 | R-13-A-5 |
| | 16 | 1.65 | .065 | 22.0 | .870 | 21.2 | .837 | 23.7 | .936 | 1251-5 | 1251-5 | R-13-5 | 1252-5 | 1251-5 | R-13-A-5 |
| | 17 | 1.47 | .058 | 22.4 | .884 | 21.9 | .865 | 24.4 | .964 | 1255-5 | 1256-5 | R-13-5 | 1256-5 | 1256-5 | R-13-A-5 |
| | 18 | 1.24 | .049 | 22.9 | .902 | 21.9 | .865 | 24.4 | .964 | 1255-5 | 1256-5 | R-13-5 | 1256-5 | 1256-5 | R-13-A-5 |
| | 19 | 1.06 | .042 | 23.2 | .916 | 21.9 | .865 | 24.4 | .964 | 1255-5 | 1256-5 | R-13-5 | 1256-5 | 1256-5 | R-13-A-5 |
| | 20 | 0.88 | .035 | 23.6 | .930 | 21.9 | .865 | 24.4 | .964 | 1255-5 | 1256-5 | R-13-5 | 1256-5 | 1256-5 | R-13-A-5 |
| | 21 | 0.81 | .032 | 23.8 | .936 | 22.4 | .883 | 24.9 | .982 | 1257-5 | M-71-3/8 | R-15-5 | 1258-5 | M-71-3/8 | R-15-A-5 |
| 1.1/8 (28.58) | 12 | 2.76 | .109 | 23.0 | .907 | 22.4 | .883 | 24.9 | .982 | 1257-5 | M-71-3/8 | R-15-5 | 1258-5 | M-71-3/8 | R-15-A-5 |
| | 15 | 1.82 | .072 | 24.9 | .981 | 24.4 | .962 | 27.2 | 1.071 | 1263-5 | 1263-5 | R-18-5 | - | - | - |
| | 16 | 1.65 | .065 | 25.2 | .995 | 24.4 | .962 | 27.2 | 1.071 | 1263-5 | 1263-5 | R-18-5 | - | - | - |
| 1.1/2 (38.10) | 17 | 1.47 | .058 | 35.1 | 1.384 | 33.8 | 1.331 | 37.3 | 1.472 | 1299-5 | 1299-5 | R-29-5 | 1300-5 | 1299-5 | R-29-A-5 |
| | 18 | 1.24 | .049 | 35.6 | 1.402 | 33.8 | 1.331 | 37.3 | 1.472 | 1299-5 | 1299-5 | R-29-5 | 1300-5 | 1299-5 | R-29-A-5 |
| | 19 | 1.06 | .042 | 36.0 | 1.416 | 33.8 | 1.331 | 37.3 | 1.472 | 1299-5 | 1299-5 | R-29-5 | 1300-5 | 1299-5 | R-29-A-5 |
| | 20 | 0.89 | .035 | 36.3 | 1.430 | 33.8 | 1.331 | 37.3 | 1.472 | 1299-5 | 1299-5 | R-29-5 | 1300-5 | 1299-5 | R-29-A-5 |

For best results a 'Thin Wall Thrust Collar' should be used when rolling 19 thru 22 gauge wall tubes. (See Pg. 5)
 Model 1223-5 - 1258-5 expanders come with 3/8" square mandrel drives and Model 1263-5 - 1300-5 expanders come with 1/2" square mandrel drives.

www.tubeexpanders.com