



LEVER TUBE EXPANDING INSTRUCTION

LEVER TUBE EXPANDING

Item No.	Specification	
ST - 100A	ST - 100A+ST - 532	For Inch: 3/8", 1/2", 5/8", 3/4", 7/8", 1", 1 - 1/8" O.D.Tubing
ST - 100M	ST - 100M+ST - 532	For Metric: 10,12,16,19,22,25,28mm O.D.Tubing



New Spare Expander Heads


型 号	英 制	型 号	公 制
N100A - 01	For inch:3/8"	N100M - 01	For metric:10mm
N100A - 02	For inch:1/2"	N100M - 02	For metric:12mm
N100A - 03	For inch:5/8"	N100M - 03	For metric:16mm
N100A - 04	For inch:3/4"	N100M - 04	For metric:19mm
N100A - 05	For inch:7/8"	N100M - 05	For metric:22mm
N100A - 06	For inch:1"	N100M - 06	For metric:25mm
N100A - 07	For inch:1 - 1/8"	N100M - 07	For metric:28mm



Suit For:
ST-100A ST-100M



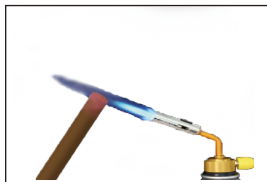
PREMIUM REFRIGERATION TOOL SERIES

Thanks for purchasing  products. for safe and correct using, please read this user instruction carefully before using the product.

USER INSTRUCTION

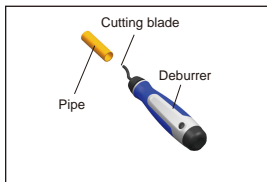
1. Prepare before expanding-anneal the hard tube

For hard tubes, we need to anneal the tubes before expanding. If not, the tubes may cracking after be expanded;



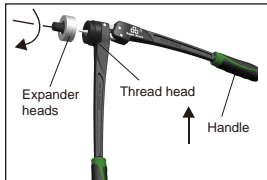
2. Prepare before expanding-deburr

Put deburrer inside the tube and rotate it in clockwise smoothly to deburr the tube.



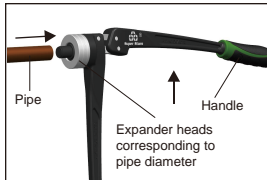
3. Prepare before expanding-put on the expander head

Pull out the expander levers before put on the expander head. Choose a correct size expander head and Rotate it in clockwise to put it on tube expander.



4. Prepare before expanding-put on the tubing;

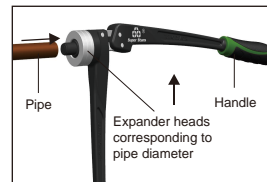
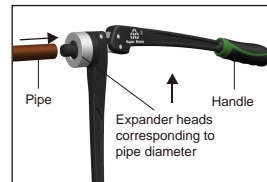
First, insert the expander head into tubing at a depth of 2-3mm. push the expander levers lightly to expand the tube a little bit, then insert the expander head in tube. If the tube is distorted badly and you can not insert expander head in it completely, follow the steps below:



- 1) Remove the tubing - remove the tubing from the expander head;
- 2) Remove the expander head - rotate the expander head in anticlockwise to remove the expander head from tube expander;
- 3) Put on the expander head - put on a smaller size expander head on the tube expander in clockwise (for example, if a 19mm O.D. tubing will be expanded, put a 16mm expander head on the tube expander.)
- 4) Put on and expand tubing - put the tubing on expander head completely and push the levers until the tubing is expanded completely;
- 5) Put on a correct size expander head - remove the smaller expander head first and put on the correct size one in clockwise on the tube expander.
- 6) Put on the tubing - put the tubing on expander head completely;

5. Start expand tubing-push the handle

Push the handle until the tubing is expanded completely;



6. Remove pipe after expanding - pull handle

Pull handles of tube expander, return expander pin and take the pipe out.

