



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

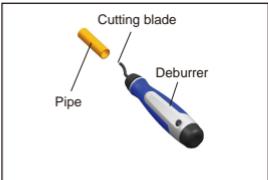
1. Prepare before expanding—anneal the hard tube

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



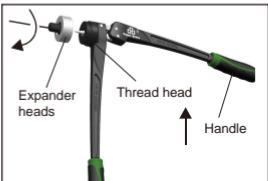
2. Prepare before expanding—deburr

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



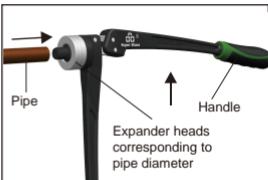
3. Prepare before expanding—put on the expander head

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.

