



HYDRAULIC TUBE EXPANDER INSTRUCTION

HYDRAULIC TUBE EXPANDER

Item No.	Specification	
ST - 300AL	ST-300A+ST-650 +ST-207	For Inch: 3/8", 1/2", 5/8", 3/4", 7/8", 1", 1-1/8", 1-1/4", 1-3/8", 1-1/2" & 1-5/8" O.D.Tubing
ST - 300ML	ST-300M+ST-650 +ST-207	For Metric: 10,12,16,19,22,25,28,32,35,38,42mm O.D.Tubing
ST - 300A	ST-300A+ST-650 +ST-207	For Inch: 3/8", 1/2", 5/8", 3/4", 7/8", 1", 1-1/8" O.D.Tubing
ST - 300M	ST-300M+ST-650 +ST-207	For Metric: 10,12,16,19,22,25,28mm O.D.Tubing



New Spare Expander Heads

Item No.	Inch	Item No.	Metric
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
N100A-08	For inch: 1-1/4"	N100M-08	For metric: 32mm
N100A-09	For inch: 1-3/8"	N100M-09	For metric: 35mm
N100A-10	For inch: 1-1/2"	N100M-10	For metric: 38mm
N100A-11	For inch: 1-5/8"	N100M-11	For metric: 42mm



Suit For:
ST-300AL ST-300A
ST-300ML ST-300M



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

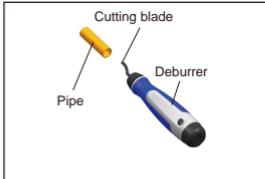
1. Prepare before expanding—anneal the hard tube

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.



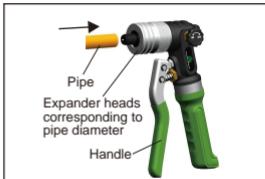
3. Prepare before expanding—put on the expander head;

First, rotate counterclockwise to loose knob, return expand pin, turn the expander head clockwise into the connecting thread head;



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;

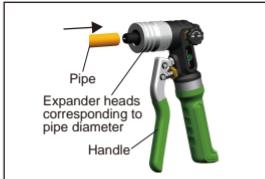
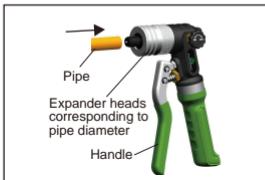
2) Remove the expander head - rotate the expander head in anticlockwise to remove the expander head from tube expander;

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;

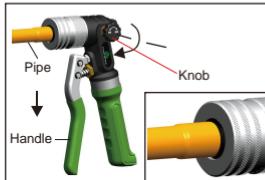
5) Put on a correct size expander head - remove the smaller expander head first and put on the correct size one in clockwise on the tube expander.

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—open knob

Open the valve and rotate knob counterclockwise, return expand pin and take the pipe out

