



# 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"
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**

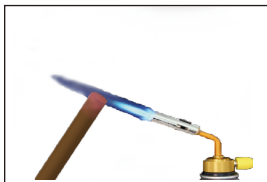
PREMIUM REFRIGERATION TOOL SERIES

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

## USER INSTRUCTION

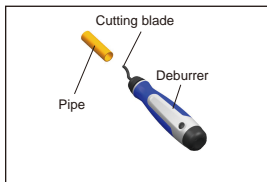
### 1. Prepare before expanding-anneal the hard tube

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



### 2. Prepare before expanding-deburr

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



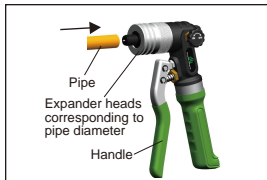
### 3. Prepare before expanding-put on the expander head;

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

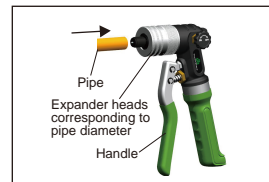
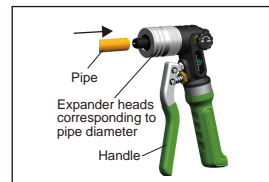


### 4. Prepare before expanding-put on the tubing;

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:

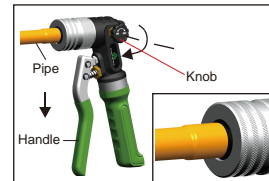


- 1) Remove the tubing - remove the tubing from the expander head;
- 2) Remove the expander head - rotate the expander head in anticlockwise to remove the expander head from tube expander;
- 3) Put on the expander head - put on a smaller size expander head on the tube expander in clockwise (for example, 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 expander pin and take the pipe out

