

Airetool Condenser Expanders

Selection Guide G-800 Series Heat Exchanger and Condenser Tube Expanders



Airetool®

G-800 Series – 3-Roll

O.D. Range:

1/2 – 1-1/2 Inches
12.7 – 38.1 mm

- Expanders with 1-1/2 in. (38.1 mm) long rolls will accommodate tube sheet thicknesses of 1/2 in. to 1-1/2 in. (12.7 mm to 38.1 mm)
- Expanders with 2-1/4 in. (57.1mm) long rolls will accommodate tube sheet thicknesses from 1-1/4 in. to 2-1/4 in. (31.7 mm to 57.1 mm)

New Reversible Thrust Collar Design

- One expander allows flush and 1/8 in.recess tube rolling.

Tube O.D. In. (mm)	Tube Gauge bwg In. (mm)		Tube I.D. In. (mm)	Tube Sheet Thickness				Min. I.D. Tool Enters In. (mm)	Max. Expan. of Tool In. (mm)	Mandrel No. (Part No.) 3/8 in. Sq. Dr. / 9.5 mm	Recommended Controlled Rolling Motors			
				1/2 in. to 1-1/2 in. (12.7 mm to 38.1 mm)		1-1/4 in. to 2-1/4 in. (31.7 mm to 57.1 mm)					Airetrol	Electric Control		
				Tool No. (Part No.)	Roll Set No. (Part No.)	Tool No. (Part No.)	Roll Set No. (Part No.)							
1/2 (12.7)	14	.083 (2.10)	.334 (8.4)	797 (5005780)	797 (5512194)			.324 (8.2)	.374 (9.5)	797 (2131300)	720-550-B (8405391)			
	15	.072 (1.82)	.356 (9.0)	799 (5005782)	R-1 (5284800)			.348 (8.8)	.398 (10.1)	799 (2131900)				
	16	.065 (1.65)	.370 (9.4)	801 (5005800)		R-2 (5285000)			.360 (9.1)	.410 (10.4)	M-1 (2511800)	720-1800-B-3/8 (8405512)		
	17	.058 (1.47)	.384 (9.7)	803 (5005900)				.374 (9.5)	.424 (10.7)					
	18	.049 (1.24)	.402 (10.2)	805 (5006000)	R-3 (5285200)				.392 (9.9)	.447 (11.3)	M-2 (2512100)			
	20	.035 (.88)	.430 (10.9)	807 (5006100)	R-4 (5285400)				.420 (10.7)	.480 (12.1)	M-3 (2512400)			
5/8 (15.8)	12	.109 (2.76)	.407 (10.3)	805 (5006000)	R-3 (5285200)			.392 (9.9)	.447 (11.3)	M-2 (2512100)	850-600-A (8405398)			
	13	.095 (2.41)	.435 (11.0)	807 (5006100)	R-4 (5285400)			.420 (10.7)	.480 (12.1)	M-3 (2512400)				
	14	.083 (2.10)	.459 (11.6)	809 (5006200)		810 (5006300)	R-4-A (5285500)			.449 (11.4)		.509 (12.9)	M-4 (2512700)	
	15	.072 (1.82)	.481 (12.2)	811 (5006400)	R-5 (5285800)	812 (5006500)	R-5-A (5285900)			.471 (11.9)		.536 (13.6)		
	16	.065 (1.65)	.495 (12.5)	813 (5006600)	R-6 (5286200)	814 (5006700)	R-6-A (5286300)			.485 (12.3)	.550 (13.9)	M-5 (2513000)	850-1250-A (8405399)	
	17	.058 (1.47)	.509 (12.9)	815 (5006800)		816 (5006900)				.499 (12.6)	.564 (14.3)			
	18	.049 (1.24)	.527 (13.3)	817 (5007000)	R-7 (5286600)	818 (5007100)	R-7-A (5286700)			.517 (13.1)	.582 (14.8)	M-6 (2513300)		
	19	.042 (1.06)	.541 (13.7)	819 (5007200)										
	20	.035 (.88)	.555 (14.1)			820 (5007300)								
	21	.032 (.81)	.561 (14.2)											
22	.028 (.71)	.569 (14.4)												
								.531 (13.5)	.596 (15.1)	M-8 (2513900)				

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Selection Guide G-800 Series Heat Exchanger and Condenser Tube Expanders – continued

Tube O.D. In. (mm)	Tube Gauge bwg In. (mm)		Tube I.D. In. (mm)	Tube Sheet Thickness				Min. I.D. Tool Enters In. (mm)	Max. Expan. of Tool In. (mm)	Mandrel No. (Part No.) 3/8 in. Sq. Dr. / 9.5 mm	Recommended Controlled Rolling Motors	
				1/2 in. to 1-1/2 in. (12.7 mm to 38.1 mm)		1-1/4 in. to 2-1/4 in. (31.7 mm to 57.1 mm)						
				Tool No. (Part No.)	Roll Set No. (Part No.)	Tool No. (Part No.)	Roll Set No. (Part No.)				Airetrol	Electric Control
3/4 (19.0)	.134 (3.40)	.482 (12.2)	811 (5006400)	R-5 (5285800)	812 (5006500)	R-5-A (5285900)	.471 (11.9)	.536 (13.6)	M-5 (2513000)	850-600-A (8405398)		
	.120 (3.04)	.510 (12.9)	815 (5006800)	R-6 (5286200)	816 (5006900)	R-6-A (5286300)	.499 (12.6)	.564 (14.3)	M-6 (2513300)			
	.109 (2.76)	.532 (13.5)	817 (5007000)	R-7 (5286600)	818 (5007100)	R-7-A (5286700)	.517 (13.1)	.582 (14.8)	M-8 (2513900)			
	.095 (2.41)	.560 (14.2)	821 (5007400)	R-8 (5287000)	822 (5007500)	R-8-A (5287100)	.550 (13.9)	.615 (15.6)				
	.083 (2.10)	.584 (14.8)	823 (5007600)	R-9 (5287400)	824 (5007700)	R-9-A (5287500)	.574 (14.5)	.639 (16.2)				
	.072 (1.82)	.606 (15.3)	825 (5007800)	R-10 (5287800)	826 (5007900)	R-10-A (5287900)	.596 (15.1)	.661 (16.7)				
	.065 (1.65)	.620 (15.7)	827 (5008000)	R-10 (5287800)	828 (5008100)	R-10-A (5287900)	.605 (15.3)	.685 (17.4)	M-9 (2514200)	850-1250-A (8405399)		
	.058 (1.47)	.634 (16.1)	829 (5008200)	R-11 (5288200)	830 (5008300)	R-11-A (5288300)	.619 (15.7)	.699 (17.7)				
	.049 (1.24)	.652 (16.5)	831 (5008400)	R-12 (5288600)	832 (5008500)	R-12-A (5288700)	.642 (16.3)	.722 (18.3)				
	.042 (1.06)	.666 (16.9)										
	.035 (.88)	.680 (17.2)										
	.032 (.81)	.686 (17.4)										
7/8 (22.2)	.134 (3.40)	.607 (15.4)	825 (5007800)	R-10 (5287800)	826 (5007900)	R-10-A (5287900)	.596 (15.1)	.661 (16.7)	M-8 (2513900)	850-600-A (8405398)		
	.120 (3.04)	.635 (16.1)	829 (5008200)	R-11 (5288200)	830 (5008300)	R-11-A (5288300)	.619 (15.7)	.699 (17.7)	M-9 (2514200)			
	.109 (2.76)	.657 (16.6)	831 (5008400)	R-12 (5288600)	832 (5008500)	R-12-A (5288700)	.642 (16.3)	.722 (18.3)	M-10 (2514500)			
	.095 (2.41)	.685 (17.4)	833 (5008600)	R-13 (5289000)	834 (5008700)	R-13-A (5289100)	.670 (17.0)	.750 (19.0)				
	.083 (2.10)	.709 (18.0)	835 (5008800)	R-14 (5289400)	836 (5008900)	R-14-A (5289500)	.685 (17.4)	.774 (19.6)			M-11 (2514800)	
	.072 (1.82)	.731 (18.5)	837 (5009000)	R-15 (5289800)	838 (5009100)	R-15-A (5289900)	.712 (18.0)	.801 (20.3)	M-12 (2515100)		850-1250-A (8405399)	
	.065 (1.65)	.745 (18.9)	839 (5009200)		840 (5009300)	R-15-A (5289900)	.726 (18.4)	.815 (20.7)				
	.058 (1.47)	.759 (19.2)	843 (5009600)	R-16 (5290200)	844 (5009700)	R-16-A (5290300)	.740 (18.8)	.829 (21.0)				
.049 (1.24)	.777 (19.7)											
1 (25.4)	.165 (4.19)	.670 (17.0)	841 (5009400)	R-13 (5289000)	842 (5009500)	R-13-A (5289100)	.655 (16.6)	.735 (18.6)	M-9 (2514200)	1050-400-A (8404200)		
	.148 (3.75)	.704 (17.8)	835 (5008800)	R-14 (5289400)	836 (5008900)	R-14-A (5289500)	.685 (17.4)	.774 (19.6)	M-11 (2514800)			
	.134 (3.40)	.732 (18.5)	837 (5009000)	R-15 (5289800)	838 (5009100)	R-15-A (5289900)	.712 (18.0)	.801 (20.3)				
	.120 (3.04)	.760 (19.3)	843 (5009600)	R-16 (5290200)	844 (5009700)	R-16-A (5290300)	.740 (18.8)	.829 (21.0)			M-12 (2515100)	
	.109 (2.76)	.782 (19.8)	845 (5009800)	R-17 (5290600)	846 (5009900)	R-17-A (5290700)	.763 (19.3)	.852 (21.6)				
	.095 (2.41)	.810 (20.5)	847 (5010000)	R-18 (5291000)	848 (5010100)	R-18-A (5291100)	.791 (20.0)	.880 (22.3)	M-13 (2515400)		850-600-A (8405398)	
	.083 (2.10)	.834 (21.1)	849 (5010200)	R-18 (5291000)	850 (5010300)	R-18-A (5291100)	.810 (20.5)	.909 (23.0)				
	.072 (1.82)	.856 (21.7)	851 (5010400)	R-19 (5291400)	852 (5010500)	R-19-A (5291500)	.837 (21.2)	.936 (23.7)				
	.065 (1.65)	.870 (22.1)										
	.058 (1.47)	.884 (22.4)	855 (5010800)	R-21 (5292200)	856 (5010900)	R-21-A (5292300)	.865 (21.9)	.964 (24.4)			850-1250-A (8405399)	
.049 (1.24)	.902 (22.9)											

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Tube O.D. In. (mm)	Tube Gauge bwg In. (mm)		Tube I.D. In. (mm)	Tube Sheet Thickness				Min. I.D. Tool Enters In. (mm)	Max. Expan. of Tool In. (mm)	Mandrel No. (Part No.) 1/2 in. Sq. Dr. / 12.7 mm	Recommended Controlled Rolling Motors	
				1/2 in. to 1-1/2 in. (12.7 mm to 38.1 mm)		1-1/4 in. to 2-1/4 in. (31.7 mm to 57.1 mm)					Airetrol	Electric Control
				Tool No. (Part No.)	Roll Set No. (Part No.)	Tool No. (Part No.)	Roll Set No. (Part No.)					
1 (25.4)	19	.042 (1.06)	.916 (23.2)	855 (5010800)	R-21 (5292200)	856 (5010900)	R-21-A (5292300)	.865 (21.9)	.964 (24.4)	M-13 *(2515400)	850-1250-A (8405399)	979-C-650/ ATC-900
	20	.035 (.88)	.930 (23.6)									
1-1/8 28.5	8	.165 (4.19)	.795 (20.1)	853 (5010600)	R-20 (5291800)	854 (5010700)	R-20-A (5291900)	.776 (19.7)	.875 (22.2)	M-13 *(2515400)	1050-400 (8404200)	979-C-300/ ATC-900
	9	.148 (3.75)	.829 (21.0)	849 (5010200)	R-18 (5291000)	850 (5010300)	R-18-A (5291100)	.810 (20.5)	.909 (23.0)			
	10	.134 (3.40)	.857 (21.7)	851 (5010400)	R-19 (5291400)	852 (5010500)	R-19-A (5291500)	.837 (21.2)	.936 (23.7)			
	11	.120 (3.04)	.885 (22.4)	855 (5010800)	R-21 (5292200)	856 (5010900)	R-21-A (5292300)	.865 (21.9)	.964 (24.4)			
	12	.109 (2.76)	.907 (23.0)	857 (5011000)	R-21 (5292200)	858 (5011100)	R-21-A (5292300)	.883 (22.4)	.982 (24.9)	M-14 (2515700)		
	13	.095 (2.41)	.935 (23.7)	859 (5011200)	R-22 (5292600)	860 (5011300)	R-22-A (5292700)	.916 (23.2)	1.015 (25.7)	M-15 (2516000)		
	14	.083 (2.10)	.959 (24.3)	861 (5011400)	R-23 (5293000)	862 (5011500)	R-23-A (5293100)	.935 (23.7)	1.044 (26.5)			
	15	.072 (1.82)	.981 (24.9)	863 (5011600)	R-24 (5293400)	864 (5011700)	R-24-A (5293500)	.962 (24.4)	1.071 (27.2)	M-16 (2516300)		
	16	.065 (1.65)	.995 (25.2)									
	17	.058 (1.47)	1.009 (25.6)	867 (5012000)	R-26 (5294200)	868 (5012100)	R-26-A (5293500)	.990 (25.1)	1.099 (27.9)	M-16 (2516300)		
18	.049 (1.24)	1.027 (26.0)										
1-1/4 31.7	8	.165 (4.19)	.920 (23.3)	865 (5011800)	R-25 (5293800)	866 (5011900)	R-25-A (5293900)	.901 (22.8)	1.010 (25.6)	M-15 (2516000)	1550-250 (8404280)	979-C-650/ ATC-900
	9	.148 (3.75)	.954 (24.2)	861 (5011400)	R-23 (5293000)	862 (5011500)	R-23-A (5293100)	.935 (23.7)	1.044 (26.5)			
	10	.134 (3.40)	.982 (24.9)	863 (5011600)	R-24 (5293400)	864 (5011700)	R-24-A (5293500)	.962 (24.4)	1.071 (27.2)			
	11	.120 (3.04)	1.010 (25.6)	867 (5012000)	R-26 (5294200)	868 (5012100)	R-26-A (5294300)	.990 (25.2)	1.099 (27.9)	M-16 (2516300)		
	12	.109 (2.76)	1.032 (26.2)	869 (5012200)	R-27 (5294600)	870 (5012300)	R-27-A (5294700)	1.013 (25.7)	1.122 (28.5)			
	13	.095 (2.41)	1.060 (26.9)	871 (5012400)	R-28 (5295000)	872 (5012500)	R-28-A (5295100)	1.041 (26.4)	1.150 (29.2)	M-17 (2516600)		
	14	.083 (2.10)	1.084 (27.5)	873 (5012600)	R-29 (5295400)	874 (5012700)	R-29-A (5295500)	1.060 (26.9)	1.169 (29.6)			
	15	.072 (1.82)	1.106 (28.0)	875 (5012800)	R-30 (5295800)	876 (5012900)	R-30-A (5295900)	1.087 (27.6)	1.196 (30.3)			
	16	.065 (1.65)	1.120 (28.4)									
	17	.058 (1.47)	1.134 (28.8)	879 (5013200)	R-30 (5295800)	880 (5013300)	R-30-A (5295900)	1.115 (28.3)	1.224 (31.0)	M-18 (2516900)		
18	.049 (1.24)	1.152 (29.2)										
1-3/8 34.9	8	.165 (4.19)	1.045 (26.5)	877 (5013000)	R-31 (5296200)	878 (5013100)	R-31-A (5296300)	1.026 (26.0)	1.135 (28.8)	M-17 (2516600)	1550-900 (8404290)	979-C-210/ ATC-900
	9	.148 (3.75)	1.079 (27.4)	873 (5012600)	R-29 (5295400)	874 (5012700)	R-29-A (5295500)	1.060 (26.9)	1.169 (29.6)			
	10	.134 (3.40)	1.107 (28.1)	875 (5012800)	R-30 (5295800)	876 (5012900)	R-30-A (5295900)	1.087 (27.6)	1.196 (30.3)			
	11	.120 (3.04)	1.135 (28.8)	879 (5013200)	R-30 (5295800)	880 (5013300)	R-30-A (5295900)	1.115 (28.3)	1.224 (31.0)	M-18 (2516900)		
	12	.109 (2.76)	1.157 (29.3)	881 (5013400)	R-32 (5296600)	882 (5013500)	R-32-A (5296700)	1.133 (28.7)	1.242 (31.5)			
	13	.095 (2.41)	1.185 (30.1)	883 (5013600)	R-33 (5297000)	884 (5013700)	R-33-A (5297100)	1.160 (29.4)	1.275 (32.3)	M-19 (2517200)		
	14	.083 (2.10)	1.209 (30.7)	885 (5013800)	R-34 (5297400)	886 (5013900)	R-34-A (5297500)	1.179 (29.9)	1.294 (32.8)	M-20 (2517500)		
	15	.072 (1.82)	1.231 (31.2)									
16	.065 (1.65)	1.245 (31.6)	887 (5014000)	R-35 (5297800)	888 (5014100)	R-35-A (5297900)	1.206 (30.6)	1.321 (33.5)				

*3/8 in. Square Drive / 9.5 mm

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Tube O.D. In. (mm)	Tube Gauge bwg In. (mm)		Tube I.D. In. (mm)	Tube Sheet Thickness				Min. I.D. Tool Enters In. (mm)	Max. Expan. of Tool In. (mm)	Mandrel No. (Part No.) 1/2 in. Sq. Dr. / 12.7 mm	Recommended Controlled Rolling Motors	
				1/2 in. to 1-1/2 in. (12.7 mm to 38.1 mm)		1-1/4 in. to 2-1/4 in. (31.7 mm to 57.1 mm)					Airetrol	Electric Control
				Tool No. (Part No.)	Roll Set No. (Part No.)	Tool No. (Part No.)	Roll Set No. (Part No.)					
1-1/2 (38.1)	8	.165 (4.19)	1.170 (29.7)	889 (5014200)	R-34 (5297400)	890 (5014300)	R-34-A (5297500)	1.145 (29.0)	1.260 (32.0)	M-19 (2517200)	1550-250 (8404280)	979-C-210/ ATC-900
	9	.148 (3.75)	1.204 (30.5)	885 (5013800)	R-34 (5297400)	886 (5013900)	R-34-A (5297500)	1.177 (29.9)	1.294 (32.8)	M-20 (2517500)		
	10	.134 (3.40)	1.232 (31.2)	887 (5014000)	R-35 (5297800)	888 (5014100)	R-35-A (5297900)	1.206 (30.6)	1.321 (33.5)			
	11	.120 (3.04)	1.260 (32.0)	891 (5014400)	R-36 (5298200)	892 (5014500)	R-36-A (5298300)	1.235 (31.3)	1.350 (34.2)			
	12	.109 (2.76)	1.282 (32.5)	893 (5014600)	R-37 (5298600)	894 (5014700)	R-37-A (5298700)	1.257 (31.9)	1.372 (34.8)	M-21 (2517800)	1550-900 (8404290)	979-C-300/ ATC-900
	13	.095 (2.41)	1.310 (33.2)	895 (5014800)	R-37 (5298600)	896 (5014900)	R-37-A (5014900)	1.285 (32.6)	1.400 (35.5)			
	14	.083 (2.10)	1.334 (33.8)									
	15	.072 (1.82)	1.356 (34.4)	897 (5015000)	R-38 (5299000)	898 (5015100)	R-38-A (5299100)	1.331 (33.8)	1.446 (36.7)			
	16	.065 (1.65)	1.370 (34.8)									
	17	.058 (1.47)	1.384 (35.1)	899 (5015120)	R-38 (5299000)	900 (5015150)	R-38-A (5299100)	1.331 (33.8)	1.472 (37.3)	M-22 (2518100)		
	18	.049 (1.24)	1.402 (35.6)									
	19	.042 (1.06)	1.416 (35.9)									
20	.035 (.88)	1.430 (36.3)										