

Airetool Condenser Expanders

Selection Guide G-800 Type Five-Roll Expanders



Airetool®

G-800 Series – 5-Roll

O.D Range:
5/8 – 1-1/2 Inches
15.8 – 38.1 mm

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

NOTE: For best results the Airetool Five-Roll expander should be fitted with a thin wall thrust collar when being used to roll tubing with 20 BWG .035" (0.9 mm).

Sizes not listed available upon request.

Tube O.D. In. (mm)	Tube Gauge 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)					Airetool	Electric Control
				Tool No. (Part No.)	Roll Set No. (Part No.)	Tool No. (Part No.)	Roll Set No. (Part No.)					
5/8 (15.8)	17	.058 (1.47)	.509 (12.9)	815-5 (5517135)	R-4-5 (5513832)	816-5 (5519516)	R-4-A-5 (5517897)	.499 (12.6)	.564 (14.3)	816-5 (2975477)	850-1250-A (8405399)	
	18	.049 (1.24)	.527 (13.4)	817-5 (5514294)	R-4-5 (5513832)		R-4-A-5 (5517897)	.517 (13.1)	.576 (14.6)	M-9 (2514200)		
	19	.042 (1.07)	.541 (13.7)									
	20	.035 (0.89)	.555 (14.1)	819-5 (5514295)	R-4-5 (5513832)	820-5 (5515647)	R-4-A-5 (5517897)	.531 (13.5)	.596 (15.1)	M-11 (2514800)		
	21	.032 (0.81)	.561 (14.2)									
	22	.028 (0.71)	.569 (14.5)									
3/4 (19.0)	13	.095 (2.41)	.560 (14.2)	821-5 (5513230)	R-5-5 (5513231)	822-5 (5514482)	R-5-A-5 (5518189)	.550 (14.0)	.615 (15.6)	822-5 (2973154)	850-600-A (8405398)	979-C-650/ ATC-900
	14	.083 (2.11)	.584 (14.8)	823-5 (5515375)	R-6-5 (5518187)	824-5 (5514171)	R-6-A-5 (5517898)	.574 (14.6)	.629 (15.9)	824-5 (2976194)		
	15	.072 (1.83)	.606 (15.4)	825-5 (5522104)	R-7-5 (5514393)	826-5 (5518376)	R-7-A-5 (5517899)	.590 (15.0)	.661 (16.8)	826-5 (2985022)		
	16	.065 (1.65)	.620 (15.7)	827-5 (5513799)	R-7-5 (5514393)	828-5 (5513542)	R-7-A-5 (5517899)	.605 (15.4)	.680 (17.2)	M-13 (2515400)	850-1250-A (8405399)	
	17	.058 (1.47)	.634 (16.1)	829-5 (5513426)	R-7-5 (5514393)	830-5 (5513413)	R-7-A-5 (5517899)	.619 (15.7)	.699 (17.8)	830-5 (2972695)		
	18	.049 (1.24)	.652 (16.6)									
	19	.042 (1.07)	.666 (16.9)									
	20	.035 (0.89)	.680 (17.3)	831-5 (5513427)	R-9-5 (5517888)	832-5 (5513264)	R-9-A-5 (5517900)	.642 (16.3)	.729 (18.5)	M-13 (2515400)		
	21	.032 (0.81)	.666 (17.4)									
	22	.028 (0.71)	.694 (17.6)									
7/8 (22.2)	13	.095 (2.41)	.685 (17.4)	833-5 (5517076)	R-9-5 (5517888)	834-5 (5514704)	R-9-A-5 (5517900)	.670 (17.0)	.747 (18.9)	M-14-3/8 (2972840)	850-600-A (8405398)	979-C-650/ ATC-900
	14	.083 (2.11)	.709 (18.0)	835-5 (5517735)	R-10-5 (5518191)	836-5 (5515680)	R-10-A-5 (5517901)	.685 (17.4)	.774 (19.6)	M-15-3/8 (2977108)		
	16	.065 (1.65)	.745 (18.9)	839-5 (5518154)	R-11-5 (5517889)	840-5 (5514564)	R-11-A-5 (5517902)	.685 (17.4)	.750 (19.0)			
	17	.058 (1.47)	.759 (19.3)	843-5 (5517922)	R-11-5 (5517889)	844-5 (5517923)	R-11-A-5 (5517902)	.740 (18.8)	.824 (20.9)	M-17-3/8 (2983632)	850-1250-A (8405399)	
	18	.049 (1.24)	.777 (19.7)									
	19	.042 (1.07)	.791 (20.1)	845-5 (5513810)	R-11-5 (5517889)	846-5 (5517924)	R-11-A-5 (5517902)	.763 (19.4)	.851 (21.6)	M-18-3/8 (2983633)		

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Selection Guide G-800 Type Five-Roll Expanders – continued

Tube O.D. In. (mm)	Tube Gauge 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 *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.)					
7/8 (22.2)	20	.035 (0.89)	.805 (20.4)	845-5 (5513810)	R-11-5 (5517889)	846-5 (5515924)	R-11-A-5 (5517902)	.763 (19.4)	.851 (21.6)	M-18-3/8 (2983633)	850-1250-A (8405399)	
	21	.032 (0.81)	.811 (20.6)									
	22	.028 (0.71)	.819 (20.8)									
1 (25.4)	12	.109 (2.77)	.782 (19.9)	845-5 (5513810)	R-11-5 (5517889)	846-5 (5517924)	R-11-A-5 (5517902)	.763 (19.4)	.852 (21.6)	M-18-3/8 (2983633)	850-600-A (8405398)	
	13	.095 (2.41)	.810 (20.6)	847-5 (5513379)	R-13-5 (5513741)	848-5 (5517099)	R-13-A-5 (5517903)	.791 (20.1)	.880 (22.4)			
	14	.083 (2.11)	.834 (21.2)	849-5 (5514922)	R-12-5 (5517890)	850-5 (5513331)	R-12-A-5 (5515825)	.810 (20.6)	.909 (22.3)			850-5 (2973500)
	15	.072 (1.83)	.856 (21.7)	851-5 (5513778)	R-13-5 (5513741)	852-5 (5513330)	R-13-A-5 (5517903)	.837 (21.3)	.936 (23.7)	M-20 (2517500)		
	16	.065 (1.65)	.870 (22.1)									
	17	.058 (1.47)	.884 (22.5)	855-5 (5515194)	R-13-5 (5513741)	856-5 (5513745)	R-13-A-5 (5517903)	.865 (22.0)	.965 (24.5)	856-5 (2974859)		850-1250-A (8405399)
	18	.049 (1.24)	.902 (22.9)									
	19	.042 (1.07)	.916 (23.3)									
	20	.035 (0.89)	.930 (23.6)									
	21	.032 (0.81)	.936 (23.8)	857-5 (5513825)	R-15-5 (5513833)	858-5 (5515935)	R-15-A-5 (5517907)	.883 (22.4)	.997 (25.3)	M-21 (2517800)		
22	.028 (0.71)	.944 (24.0)										
1-1/8 (28.5)	12	.109 (2.77)	.907 (23.0)	857-5 (5513825)	R-15-5 (5513833)	858-5 (5515935)	R-15-A-5 (5517907)	.883 (22.4)	.997 (25.3)	M-21 (2517800)	1050-400 (8404200)	979-C-300/ ATC-900
	13	.095 (2.41)	.935 (23.7)	859-5 (5514397)	R-16-5 (5518056)	860-5 (5513392)	R-16-A-5 (5517904)	.916 (23.3)	1.000 (25.4)	860-5 *(2975673)		
	14	.083 (2.11)	.959 (24.1)	861-5 (5513325)	R-17-5 (5517891)	862-5 (5513747)	R-17-A-5 (5517905)	.935 (23.7)	1.043 (26.4)	862-5 *(2974860)		
1-1/4 (31.8)	15	.072 (1.83)	1.106 (28.1)	875-5 (5513884)	R-21-5 (5517887)	876-5 (5519970)	R-21-A-5 (5513291)	1.087 (27.6)	1.196 (30.4)	880-5 *(2968789)	1050-400 (8404200)	979-C-650/ ATC-900
	16	.065 (1.65)	1.120 (28.4)									
	17	.058 (1.47)	1.134 (28.8)									
	18	.049 (1.24)	1.152 (29.3)									
	19	.042 (1.07)	1.166 (29.6)	879-5 (5513993)	R-21-5 (5517887)	880-5 (5512151)	R-21-A-5 (5513291)	1.115 (28.3)	1.231 (31.3)			
	20	.042 (0.80)	1.180 (30.0)									
	21	.032 (0.81)	1.186 (30.1)									
22	.028 (0.71)	1.194 (30.3)										
1-3/8 (34.9)	12	.109 (2.77)	1.154 (29.3)	881-5 (5516001)	R-21-5 (5517887)	882-5 (5514657)	R-21-A-5 (5513291)	1.133 (28.8)	1.242 (31.5)	882-5 *(2973230)	1550-250 (8404280)	979-C-210/ ATC-900
	14	.083 (2.11)	1.209 (30.7)	885-5 (5513252)	R-23-5 (5517892)	886-5 (5515778)	R-23-A-5 (5518192)	1.179 (29.9)	1.296 (32.9)			
1-1/2 (38.1)	17	.058 (1.47)	1.384 (35.2)	899-5 (5513850)	R-29-5 (5517893)	900-5 (5517605)	R-29-A-5 (5517906)	1.331 (33.8)	1.489 (37.8)	900-5 *(2975232)	1550-900 (8404290)	979-C-300/ ATC-900
	18	.049 (1.24)	1.402 (35.2)									
	19	.042 (1.07)	1.416 (36.0)									
	20	.035 (0.89)	1.430 (36.3)									
	21	.032 (0.81)	1.436 (36.5)									
	22	.028 (0.71)	1.444 (36.7)									