

# Airetool Condenser Expanders

## G-1200 Series Heat Exchanger and Condenser Tube Expanders



NOTE: Step expanding becomes necessary if the tube sheet thickness exceeds the length of the roll. Longer reaches available upon request in 6 inch (50.8 mm) increments.

# Airetool®

### G-1200 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 as follows:  
 STD. REACH 1/2" to 5" (12.7 mm to 127.0 mm)  
 "A" REACH 1/2" to 7" (12.7 mm to 177.8 mm)  
 "C" REACH 7/8" to 11" (22.2 mm to 279.4 mm)
- Expanders with 2-1/4 in. (57.1 mm) long rolls will accommodate tube sheet thicknesses as follows:  
 STD. REACH 1-1/4" to 5-3/4" (31.7 mm to 146.0 mm)  
 "A" REACH 1-1/4" to 7-3/4" (31.7 mm to 196.8 mm)  
 "C" REACH 1-5/8" to 11-3/4" (41.3 mm to 298.4 mm)

### New Reversible Thrust 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 5 in. (12.7 mm to 133.3 mm)		1-1/4 in. to 5-3/4 in. (31.7 mm to 152.4 mm)					Airetool	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)	1197 (5017460)	797 (5512194)			.324 (8.2)	.374 (9.5)	1197 (2165300)	720-550-B (8405391)	
	15	.072 (1.82)	.356 (9.0)	1199 (5056204)	R-1 (5284800)			.348 (8.8)	.398 (10.1)	1199 (2166400)		
	16	.065 (1.65)	.370 (9.4)	1201 (5017500)				.360 (9.1)	.410 (10.4)	M-51 (2521100)		
	17	.058 (1.47)	.384 (9.7)	1203 (5017900)	R-2 (5285000)			.374 (9.5)	.424 (10.7)		720-1800-B (8405512)-3/8	
	18	.049 (1.24)	.402 (10.2)	1205 (5018300)	R-3 (5285200)			.392 (9.9)	.447 (11.3)	M-52 (2522000)		
	20	.035 (0.88)	.430 (10.9)	1207 (5018700)	R-4 (5285400)			.420 (10.7)	.480 (12.1)	M-53 (2522900)		
5/8 (15.8)	12	.109 (2.76)	.407 (10.3)	1205 (5018300)	R-3 (5285200)			.392 (9.9)	.447 (11.3)	M-52 (2522000)	850-600-A (8405398)	
	13	.095 (2.41)	.435 (11.0)	1207 (5018700)	R-4 (5285400)			.420 (10.7)	.480 (12.1)	M-53 (2522900)		
	14	.083 (2.10)	.459 (11.6)	1209 (5019100)		1210 (5019500)	R-4-A (5285500)	.449 (11.4)	.509 (12.9)	M-54 (2523800)		
	15	.072 (1.82)	.481 (12.2)	1211 (5019900)	R-5 (5285800)	1212 (5020300)	R-5-A (5285900)	.471 (11.9)	.536 (13.6)			
	16	.065 (1.65)	.495 (12.5)	1213 (5020700)	R-6 (5286200)	1214 (5021100)	R-6-A (5286300)	.485 (12.3)	.550 (13.9)	M-55 (2524700)	850-1250-A (8405399)	
	17	.058 (1.47)	.509 (12.9)	1215 (5021500)		1216 (5021900)			.499 (12.6)	.564 (14.3)		M-56 (2525600)
	18	.049 (1.24)	.527 (13.3)	1217 (5022300)			1218 (5022700)		.517 (13.1)	.582 (14.8)		
	19	.042 (1.06)	.541 (13.7)		R-7 (5286600)		R-7-A (5286700)				M-58 (2527400)	
	20	.035 (0.88)	.555 (14.1)	1219 (5023100)		1220 (5023500)			.531 (13.5)	.596 (15.1)		
	21	.032 (0.81)	.561 (14.2)									
22	.028 (0.71)	.569 (14.4)										
3/4 (19.0)	10	.134 (3.40)	.482 (12.2)	1211 (5019900)	R-5 (5285800)	1212 (5020300)	R-5-A (5285900)	.471 (11.9)	.536 (13.6)	M-55 (2524700)	850-600-A (8405398)	979-C-650/ ATC-900
	11	.120 (3.04)	.510 (12.9)	1215 (5021500)	R-6 (5286200)	1216 (5021900)	R-6-A (5286300)	.499 (12.6)	.564 (14.3)	M-56 (2525600)		
	12	.109 (2.76)	.532 (13.5)	1217 (5022300)	R-7 (5286600)	1218 (5022700)	R-7-A (5286700)	.517 (13.1)	.582 (14.8)			
	13	.095 (2.41)	.560 (14.2)	1221 (5023900)	R-8 (5287000)	1222 (5024300)	R-8-A (5287100)	.550 (13.9)	.615 (15.6)			
	14	.083 (2.10)	.584 (14.8)	1223 (5024700)	R-9 (5287400)	1224 (5025100)	R-9-A (5287500)	.574 (14.5)	.639 (16.2)			

# Airetool Condenser Expanders

## G-1200 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 5-1/4 in. (12.7 mm to 133.3 mm)		1-1/4 in. to 6 in. (31.7 mm to 152.4 mm)					Airetrol	Electric Control		
				Tool No. (Part No.)	Roll Set No. (Part No.)	Tool No. (Part No.)	Roll Set No. (Part No.)							
3/4 (19.0)	15	.072 (1.82)	.606 (15.3)	1225 (5025500)	R-10 (5287800)	1226 (5025900)	R-10-A (5287900)	.596 (15.1)	.661 (16.7)	M-58 (2527400)	850-600-A (8405398)	979-C-650/ ATC-900		
	16	.065 (1.65)	.620 (15.7)	1227 (5026300)		1228 (5026700)								
	17	.058 (1.47)	.634 (16.1)	1229 (5027100)	R-11 (5288200)	1230 (5027500)	R-11-A (5288300)	.619 (15.7)	.699 (17.7)					
	18	.049 (1.24)	.652 (16.5)	1231 (5027900)		1232 (5028300)		R-12 (5288600)	R-12-A (5288700)				.642 (16.3)	.722 (18.3)
	19	.042 (1.06)	.666 (16.9)	1233 (5028700)	R-15 (5289800)	1234 (5029100)	R-15-A (5289900)						.670 (17.0)	.750 (19.0)
	20	.035 (0.88)	.680 (17.2)	1235 (5029500)		1236 (5029900)		R-14-A (5289500)	R-14-A (5289500)				.685 (17.4)	.774 (19.6)
	21	.032 (0.81)	.686 (17.4)	1237 (5030300)		1238 (5030700)							R-15-A (5289900)	R-15-A (5289900)
	22	.028 (0.71)	.694 (17.6)	1239 (5031100)		1240 (5031500)		R-16-A (5290200)	R-16-A (5290300)					
7/8 (22.2)	10	.134 (3.40)	.607 (15.4)	1225 (5025500)	R-10 (5287800)	1226 (5025900)	R-10-A (5287900)			.596 (15.1)	.661 (16.7)	M-58 (2527400)	850-600-A (8405398)	979-C-650/ ATC-900
	11	.120 (3.04)	.635 (16.1)	1229 (5027100)	R-11 (5288200)	1230 (5027500)	R-11-A (5288300)	.619 (15.7)	.699 (17.7)					
	12	.109 (2.76)	.657 (16.6)	1231 (5027900)	R-12 (5288600)	1232 (5028300)	R-12-A (5288700)	.642 (16.3)	.722 (18.3)	M-59 (2528300)				
	13	.095 (2.41)	.685 (17.4)	1233 (5028700)	R-13 (5289000)	1234 (5029100)	R-13-A (5289100)	.670 (17.0)	.750 (19.0)					
	14	.083 (2.10)	.709 (18.0)	1235 (5029500)	R-14 (5289400)	1236 (5029900)	R-14-A (5289500)	.685 (17.4)	.774 (19.6)	M-60 (2529200)				
	15	.072 (1.82)	.731 (18.5)	1237 (5030300)	R-15 (5289800)	1238 (5030700)	R-15-A (5289900)	.712 (18.0)	.801 (20.3)					
	16	.065 (1.65)	.745 (18.9)	1239 (5031100)		1240 (5031500)		R-16-A (5290200)	R-16-A (5290300)	.726 (18.4)	.815 (20.7)			
	17	.058 (1.47)	.759 (19.2)	1243 (5032700)	R-16 (5290200)	1244 (5033100)	R-16-A (5290300)			.740 (18.8)	.829 (21.0)	M-61 (2530100)		
18	.049 (1.24)	.777 (19.7)	1245 (5033500)	R-17 (5290600)	1246 (5033900)	R-17-A (5290700)	.763 (19.3)	.852 (21.6)						
1 (25.4)	8	.165 (4.19)	.670 (17.0)	1241 (5031900)	R-13 (5289000)	1242 (5032300)	R-13-A (5289100)	.665 (16.8)	.735 (18.6)	M-59 (2528300)	1050-400 (8404200)	979-C-300/ ATC-900		
	9	.148 (3.75)	.704 (17.8)	1235 (5029500)	R-14 (5289400)	1236 (5029900)	R-14-A (5289500)	.685 (17.4)	.774 (19.6)					
	10	.134 (3.40)	.732 (18.5)	1237 (5030300)	R-15 (5289800)	1238 (5030700)	R-15-A (5289900)	.712 (18.0)	.801 (20.3)	M-61 (2530100)				
	11	.120 (3.04)	.760 (19.3)	1243 (5032700)	R-16 (5290200)	1244 (5033100)	R-16-A (5290300)	.740 (18.8)	.829 (21.0)					
	12	.109 (2.76)	.782 (19.8)	1245 (5033500)	R-17 (5290600)	1246 (5033900)	R-17-A (5290700)	.763 (19.3)	.852 (21.6)	M-62 (2531000)				
	13	.095 (2.41)	.810 (20.5)	1247 (5034300)	R-18 (5291000)	1248 (5034700)	R-18-A (5291100)	.791 (20.0)	.880 (22.3)					
	14	.083 (2.10)	.834 (21.1)	1249 (5035100)		1250 (5035500)		R-19-A (5291500)	R-19-A (5291500)	.810 (20.5)			.909 (23.0)	
	15	.072 (1.82)	.856 (21.7)	1251 (5035900)	R-19 (5291400)	1252 (5036300)	R-19-A (5291500)			.837 (21.2)			.936 (23.7)	M-63 (2531900)
	16	.065 (1.65)	.870 (22.1)	1255 (5037500)	R-21 (5292200)	1256 (5037900)	R-21-A (5292300)	.865 (21.9)	.964 (24.4)					
	17	.058 (1.47)	.884 (22.4)	1253 (5036700)		R-20 (5291800)		1254 (5037100)	R-20-A (5291900)	.776 (19.7)			.875 (22.2)	
	18	.049 (1.24)	.902 (22.9)	1249 (5035100)		R-18 (5291000)		1250 (5035500)	R-18-A (5291100)	.810 (20.5)			.909 (23.0)	
	19	.042 (1.06)	.916 (23.2)	1251 (5035900)		R-19 (5291400)		1252 (5036300)	R-19-A (5291500)	.837 (21.2)			.936 (23.7)	
20	.035 (0.88)	.930 (23.6)	1255 (5037500)	R-21 (5292200)	1256 (5037900)	R-21-A (5292300)	.865 (21.9)	.964 (24.4)						
1-1/8 (28.5)	8	.165 (4.19)	.795 (20.1)	1253 (5036700)	R-20 (5291800)	1254 (5037100)	R-20-A (5291900)	.776 (19.7)	.875 (22.2)	M-63 (2531900)	1050-400 (8404200)	979-C-300/ ATC-900		
	9	.148 (3.75)	.829 (21.0)	1249 (5035100)	R-18 (5291000)	1250 (5035500)	R-18-A (5291100)	.810 (20.5)	.909 (23.0)					

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## G-1200 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.) 1/2 in. Sq. Dr. / 21.7 mm	Recommended Controlled Rolling Motors	
					1/2 in. to 5-1/4 in. (12.7 mm to 133.3 mm)		1-1/4 in. to 6 in. (31.7 mm to 152.4 mm)					Airetrol	Electric Control
					Tool No. (Part No.)	Roll Set No. (Part No.)	Tool No. (Part No.)	Roll Set No. (Part No.)					
1-1/8 (28.5)	10	.134 (3.40)	.857 (21.7)	1251 (5035900)	R-19 (5291400)	1252 5036300	R-19-A (5291500)	.837 (21.2)	.936 (23.7)	M-63* (2531900)	1050-400 (8404200)	979-C-300/ ATC-900	
	11	.120 (3.04)	.885 (22.4)	1255 (5037500)	R-21 (5292200)	1256 (5037900)	R-21-A (5292300)	.865 (21.9)	.964 (24.4)				
	12	.109 (2.76)	.907 (23.0)	1257 (5038300)	R-21 (5292200)	1258 (5038700)	R-21-A (5292300)	.883 (22.4)	.982 (24.9)	M-64 (2532800)			
	13	.095 (2.41)	.935 (23.7)	1259 (5039100)	R-22 (5292600)	1260 (5039500)	R-22-A (5292700)	.916 (23.2)	1.015 (25.7)				
	14	.083 (2.10)	.959 (24.3)	1261 (5039900)	R-23 (5292600)	1262 (5040300)	R-23-A (5293100)	.935 (23.7)	1.044 (26.4)	M-65 (2533700)			
	15	.072 (1.82)	.981 (24.9)	1263 (5040700)	R-24 (5293400)	1264 (5041100)	R-24-A (5293500)	.962 (24.4)	1.071 (27.2)				
	16	.065 (1.65)	.995 (25.2)	1267 (5042300)	R-26 (5294200)	1268 (5042700)	R-26-A (5294300)	.990 (25.1)	1.099 (27.9)	M-66 (2534600)			
	17	.058 (1.47)	1.009 (25.6)	1265 (5041500)	R-25 (5293800)	1266 (5041900)	R-25-A (5293900)	.901 (22.8)	1.010 (25.6)				
1-1/4 (31.7)	8	.165 (4.19)	.920 (23.3)	1261 (5039900)	R-23 (5293000)	1262 (5041900)	R-23-A (5293100)	.935 (23.7)	1.044 (26.5)	M-65 (2533700)	1550-250 (8404250)	979-C-300/ ATC-900	
	9	.148 (3.75)	.954 (24.2)	1263 (5040700)	R-24 (5293400)	1264 (5041100)	R-24-A (5293500)	.962 (24.4)	1.071 (27.2)				
	10	.134 (3.40)	.982 (24.9)	1267 (5042300)	R-26 (5294200)	1268 (5042700)	R-26-A (5294300)	.990 (25.1)	1.099 (27.9)	M-66 (2534600)			
	11	.120 (3.04)	1.010 (25.6)	1269 (5043100)	R-27 (5294600)	1270 (5043500)	R-27-A (5294700)	1.013 (25.7)	1.122 (28.5)				
	12	.109 (2.76)	1.032 (26.2)	1271 (5043900)	R-28 (5295000)	1272 (5044300)	R-28-A (5295100)	1.041 (26.4)	1.150 (29.2)	M-67 (2535500)			
	13	.095 (2.41)	1.060 (26.9)	1273 (5044700)	R-29 (5295400)	1274 (5045100)	R-29-A (529500)	1.060 (26.9)	1.169 (29.6)				
	14	.083 (2.10)	1.084 (27.5)	1275 (5045500)	R-30 (5295800)	1276 (5045900)	R-30-A (5295900)	1.087 (27.6)	1.196 (30.3)	M-68 (2536400)			
	15	.072 (1.82)	1.106 (28.0)	1279 (5047100)	R-30 (5295800)	1280 (5047500)		1.115 (28.3)	1.224 (31.0)				
1-3/8 (34.9)	8	.165 (4.19)	1.045 (26.5)	1277 (5046300)	R-31 (5296200)	1278 (5046700)	R-31-A (5295900)	1.026 (26.0)	1.135 (28.8)	M-67 (2535500)	1550-250 (8404280)	979-C-210/ ATC-900	
	9	.148 (3.75)	1.079 (27.4)	1273 (5044700)	R-29 (5295400)	1274 (5045100)	R-29-A (5295500)	1.060 (26.9)	1.169 (29.6)				
	10	.134 (3.40)	1.107 (28.1)	1275 (5045500)	R-30 (5295800)	1276 (5045900)	R-30-A (5295900)	1.087 (27.6)	1.196 (30.3)	M-68 (2536400)			
	11	.120 (3.04)	1.135 (28.8)	1279 (5047100)		1280 (5047500)		1.115 (28.3)	1.224 (31.0)				
	12	.109 (2.76)	1.157 (29.3)	1281 (5047900)	R-32 (5295800)	1282 (5048300)	R-32-A (5296700)	1.133 (28.7)	1.242 (31.5)	M-69 (2537300)			
	13	.095 (2.41)	1.185 (30.1)	1283 (5048700)	R-33 (5297000)	1284 (5049100)	R-33-A (5297100)	1.160 (29.4)	1.275 (32.3)				
	14	.083 (2.10)	1.209 (30.7)	1285 (5049500)	R-34 (5297400)	1286 (5049900)	R-34-A (5297500)	1.179 (29.9)	1.294 (32.8)	M-70 (2538200)			
	15	.072 (1.82)	1.231 (31.2)	1287 (5050300)	R-35 (5297800)	1288 (5050700)	R-35-A (5297900)	1.206 (30.6)	1.321 (33.5)				
1-1/2 (38.1)	8	.165 (4.19)	1.170 (29.7)	1289 (5051100)	R-34 (5297400)	1290 (5051500)	R-34-A (5297500)	1.145 (29.0)	1.260 (32.0)	M-69 (2537300) M-70 (2538200)	1550-250 (8404280)	979-C-210/ ATC-900	
	9	.148 (3.75)	1.204 (30.5)	1285 (5049500)	R-34 (5297400)	1286 (5049900)	R-34-A (5297500)	1.179 (29.9)	1.294 (32.8)				

\* 3/8 square drive / 4.5 mm

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## G-1200 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.) 1/2 in. Sq. Dr. / 21.7 mm	Recommended Controlled Rolling Motors		
				1/2 in. to 5-1/4 in. (12.7 mm to 133.3 mm)		1-1/4 in. to 6 in. (31.7 mm to 152.4 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)	10	.134 (3.40)	1.232(31.2)	1287 (5050300)	R-35 (5297800)	1288 (5050700)	R-35-A (5297900)	1.206 (30.6)	1.321 (35.5)	M-70 (2538200)	1550-250 (8404280)	979-C-210/ ATC-900	
	11	.120 (3.04)	1.260(32.0)	1291 (5051900)	R-36 (5297800)	1292 (5052300)	R-36-A (5298300)	1.235 (31.3)	1.350 (34.2)				
	12	.109 (2.76)	1.282(32.5)	1293 (5052700)	R-37 (5298600)	1294 (5053100)	R-37-A (5298700)	1.257 (31.9)	1.372 (34.8)				
	13	.095 (2.41)	1.310(33.2)	1295 (5053500)	R-37 (5298600)	1296 (5053900)		1.285 (32.6)	1.400 (35.5)	M-71 (2539100)			
	14	.083 (2.10)	1.334(33.8)				1297 (5054300)				1298 (5054700)	1.446 (36.7)	
	15	.072 (1.82)	1.356(34.4)	1299 (5512167)	R-38 (5299000)	1300 (5055075)	R-38-A (5299100)	1.331 (33.8)	1.472 (37.3)	M-72 (2539920)	1550-900 (8404290)		979-C-300/ ATC-900
	16	.065 (1.65)	1.370(34.8)										
	17	.058 (1.47)	1.384(35.1)										
	18	.049 (1.24)	1.402(35.6)										
	19	.042 (1.06)	1.416(35.9)										
20	.035 (0.88)	1.430(36.3)											