

Airetool Condenser Expanders

G-8012 Series Heat Exchanger and Condenser Tube Expanders



Airetool®

G-8012 Series

O.D. Range:

1-3/4 – 4 Inches
44.4 – 76.2 mm

- Expanders with 2-1/4 in. (57.1mm) long rolls will accommodate tube sheet thicknesses of 1/2 in. to 4 in. (12.7 mm to 101.6 mm)

NOTE: Step expanding becomes necessary if the tube sheet thickness exceeds the length of the roll.

Tube O.D. In. (mm)	Tube Gauge		Tube I.D.		Tube Sheet Thickness		Min. I.D. Tool Enters In. (mm)	Max. Expan. of Tool In. (mm)	Mandrel No. (Stock No) 3/4 in. Sq. Dr. / 19.0 mm	Recommended Controlled Rolling Motors		
	bwg	In. (mm)	In. (mm)	1/2 in. to 4 in. (12.7 mm to 101.6 mm)		In. (mm)				In. (mm)	Airetrol	Electric Control
				Tool No. (Stock No.)	Roll Set No. (Stock No.)							
1-3/4 (44.4)	8	.165 (4.2)	1.420 (36.1)	8012-1-3/4-8 (5518639)	R-33-A (5297100)	1.368 (34.7)	1.550 (39.4)	M-90 2541900	1550-250 (8404280)	979-C-210/ ATC-900		
	10	.134 (3.4)	1.482 (37.6)	8012-1-3/4-10 (5139000)	R-37-A (5298700)	1.420 (36.0)	1.607 (40.8)					
	11	.120 (3.0)	1.510 (38.3)	8012-1-3/4-11 (5139100)	R-42 (5299400)	1.454 (36.9)	1.635 (41.5)					
	12	.109 (2.7)	1.532 (38.9)	8012-1-3/4-12 (5139200)	R-44 (5299500)	1.482 (37.6)	1.657 (42.0)					
	13	.095 (2.4)	1.560 (39.6)	8012-1-3/4-13 (5139300)	R-46 (5299600)	1.510 (38.3)	1.685 (42.7)					
	14	.083 (2.1)	1.584 (40.2)	8012-1-3/4-14 (5139400)	R-48 (5299700)	1.532 (38.9)	1.709 (43.4)					
2 (50.8)	8	.165 (4.2)	1.670 (42.4)	8012-2-8 (5518643)	R-48 (5299700)	1.595 (40.5)	1.795 (45.6)	M-91 2542200	1550-250 (8404280)	979-C-210/ ATC-900		
	10	.134 (3.4)	1.732 (43.9)	8012-2-10 (5139500)	R-50 (5299800)	1.640 (41.6)	1.857 (47.1)					
	11	.120 (3.0)	1.760 (44.7)	8012-2-11 (5139600)	R-52 (5299900)	1.670 (42.4)	1.885 (47.8)					
	12	.109 (2.7)	1.782 (45.2)	8012-2-12 (5139700)	R-54 (5300000)	1.704 (43.2)	1.907 (48.4)					
	13	.095 (2.4)	1.810 (45.9)	8012-2-13-18 (5139800)	R-56 (5300100)	1.732 (43.9)	1.956 (49.6)					
	14	.083 (2.1)	1.834 (46.5)									
	15	.072 (1.8)	1.856 (47.1)									
	16	.065 (1.6)	1.870 (47.4)									
17	.058 (1.5)	1.884 (47.9)										
18	.049 (1.2)	1.902 (48.3)										
2-1/4 (57.1)	10	.134 (3.4)	1.982 (50.3)	8012-2-1/4-10 (5140100)	R-56 (5300100)	1.890 (48.0)	2.107 (53.5)	M-92 2542300	1550-250 (8404280)	999-C-45/ ATC-900		
	11	.120 (3.0)	2.010 (51.0)	8012-2-1/4-11 (5140200)	R-58 (5300200)	1.920 (48.7)	2.135 (54.2)					
	12	.109 (2.7)	2.032 (51.6)	8012-2-1/4-12 (5140300)	R-60 (5300300)	1.954 (49.6)	2.157 (54.7)					
	13	.095 (2.4)	2.060 (52.3)	8012-2-1/4-12-16 (5140400)	R-62 (5300400)	1.982 (50.3)	2.185 (55.4)					
	14	.083 (2.1)	2.084 (52.9)									
	15	.072 (1.8)	2.106 (53.4)									
16	.065 (1.6)	2.120 (43.8)										
2-1/2 (63.5)	10	.134 (3.4)	2.232 (56.6)	8012-2-1/2-10-12 (5139900)	R-64 (5300500)	2.140 (54.3)	2.407 (61.1)	M-93 2542400	1550-250 (8404280)	999-C-45/ ATC-900		
	11	.120 (3.0)	2.260 (57.4)									

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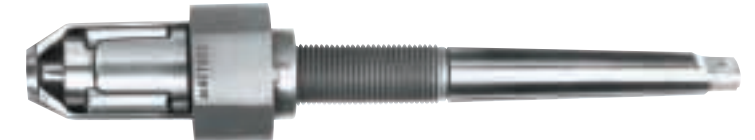
Tube O.D. In. (mm)	Tube Gauge		Tube I.D.		Tube Sheet Thickness		Min. I.D. Tool Enters In. (mm)	Max. Expan. of Tool In. (mm)	Mandrel No. (Stock No) 3/4 in. Sq. Dr. / 19.0 mm	Recommended Controlled Rolling Motors		
	bwg	In. (mm)	In. (mm)	In. (mm)	1/2 in. to 4 in. (12.7 mm to 101.6 mm)	Tool No. (Stock No.)				Roll Set No. (Stock No.)	Airetrol	Electric Control
2-1/2 (63.5)	12	.109 (2.7)	2.282 (57.9)	8012-2-1/2-10-12 (5139900)	R-64 (5300500)	2.140 (54.3)	2.407 (61.1)	M-93 (2542400)	1550-250 (8404280)	999-C-45/ ATC-900		
	13	.095 (2.4)	2.310 (58.6)	8012-2-1/2-13-18 (5140000)		2.232 (56.6)	2.450 (62.2)	M-94 (2542500)				
	14	.083 (2.1)	2.334 (59.2)									
	15	.072 (1.8)	2.356 (59.8)									
	16	.065 (1.6)	2.370 (60.1)									
	17	.058 (1.5)	2.384 (60.6)									
	18	.049 (1.3)	2.402 (61.0)									
2-3/4 (69.8)	10	.134 (3.4)	2.482 (63.0)	8012-2-3/4-10-16 (5140500)	R-66 (5300700)	2.390 (60.7)	2.702 (68.6)	M-96 (2542700)	1850-90 (8405315)	999-C-45/ ATC-900		
	11	.120 (3.0)	2.510 (63.7)									
	12	.109 (2.7)	2.532 (64.3)									
	13	.095 (2.4)	2.560 (64.3)									
	14	.083 (2.1)	2.584 (65.6)									
	15	.072 (1.8)	2.606 (66.1)									
	16	.065 (1.6)	2.620 (66.5)									
3 (76.2)	8	.165 (4.1)	2.670 (67.8)	8012-3-8-9 (5512193)	R-67 (5300800)	2.640 (67.0)	2.952 (74.9)	M-96 (2542700)	1850-90 (8405315)	999-C-45/ ATC-900		
	9	.148 (3.7)	2.704 (68.6)									
	10	.134 (4.3)	2.732 (69.3)									
	11	.120 (3.0)	2.760 (70.1)									
	12	.109 (2.7)	2.782 (70.6)									
	13	.095 (2.4)	2.810 (71.3)									
	14	.083 (2.1)	2.834 (71.9)									
	15	.072 (1.8)	2.856 (72.5)									
	16	.065 (1.6)	2.870 (72.8)									
	17	.058 (1.5)	2.884 (73.3)									
	18	.049 (1.2)	2.902 (73.7)									

Special Tube Expanders*



Linsen Flaring Expander

This special expander enlarges the ends of copper, brass and aluminum tubing so that another tube of the same size may be inserted into the expanded section for a soldered joint.

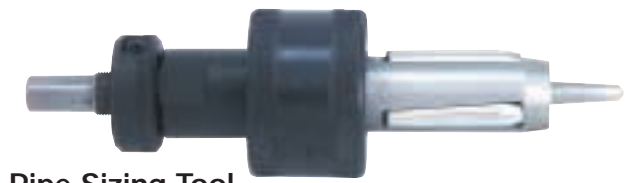


Diesel Engine Expander

Diesel engine expanders are a special line of expanders designed for rolling the injector sleeves into the heads of diesel engines. These expanders are made to order for each application, and a detailed drawing of the injector sleeve and engine head must accompany the order to insure proper expander design.

Step Rolling Expander

Step rolling expanders are ideally suited for faster tube rolling in thick tube sheets. The rolling process can be completed without removing the expander from the tube. Step rolling expanders are available in protractive and retractive models. The expander cage has grooves that accept a spring-loaded, quick-spacing thrust collar that permits fast step rolling throughout the full thickness of the tube sheet.



"PST" Pipe Sizing Tool

Airetool's PST Series pipe sizing expanders are designed to true pipe ends, and to enlarge the pipe diameter to provide the correct clearance between the pipe O.D. and the I.D. of a fitting before making a silver solder or brazed joint. The threaded mandrel allows fine adjustments for accurate sizing of the pipe end.



SR Expander

The rapid taper on the mandrel allows full expansion of a tube with minimum travel of the mandrel. The mandrel is retained at the rear of the expander to shorten mandrel length and to allow use near sharp tube bends or tube inserts.



Collins Expander

These nonparallel rolling, self-feeding expanders are typically used for thin tube sheets and give a slight flare to tube ends. Self-contained rolls give slight flare to tube ends. Sizes: 1/2 - 4-1/2 in. (12.7 - 113.8 mm) OD tubes.

* Please contact your Cooper Power Tools sales representative for more information.