



EXP-850

Tube expander set with 8 heads

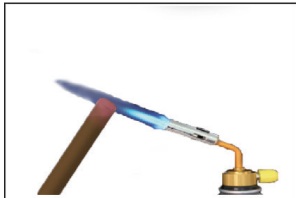


User guide

USER INSTRUCTIONS

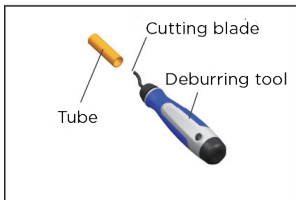
1. Preparation before expansion Anneal the tube

For hard tubes, it is necessary to anneal them before expansion; otherwise, they may crack.



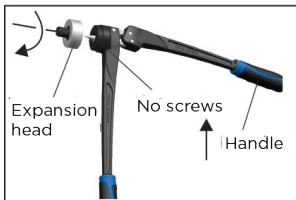
2. Preparation before expansion Deburr

Insert the deburring tool inside the tube and rotate it clockwise gently to remove burrs from the tube.



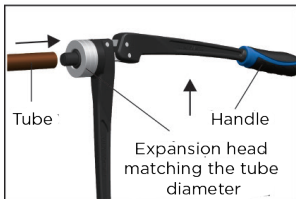
3. Preparation before expansion Install the expansion head

Open the expansion handles before installing the expansion head. Select the correct size head and rotate it clockwise to secure it onto the flaring tool.



4. Preparation before expansion Position the tube

First, insert the expansion head into the tube to a depth of 2-3 mm. Gently push the handles of the flaring tool to slightly expand

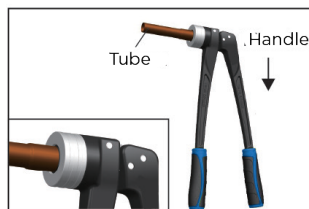


the tube, then fully insert the expansion head into the tube. légèrement le tube, puis insérer la tête d'expansion complètement dans le tube. If the tube is severely deformed and the expansion head cannot be fully inserted, follow these steps :

- 1) Remove the tube from the expansion head.
- 2) Rotate the expansion head counterclockwise to unscrew it from the flaring tool.
- 3) Install a smaller expansion head onto the flaring tool by rotating clockwise (e.g., if a 19 mm diameter tube needs to be expanded, install a 16 mm expansion head on the flaring tool).
- 4) Fully insert the tube onto the smaller expansion head and push the handles until the tube is fully expanded.
- 5) Remove the smaller expansion head first and install the correct size head on the flaring tool.
- 6) Fully insert the tube onto the correct expansion head.

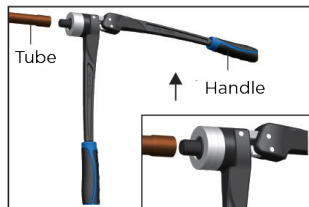
5. Expand the tube

Push the handle until the tube is fully expanded.



6. Remove the tube after expansion

Open the handles of the flaring tool to retract the expansion head, then remove the tube.





N.B. LINSTRUMENT reserves the right to make changes without prior notice.

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