YELLOW JACKET®

Tubing Expander
Model 60407



Owner's Manual

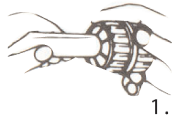
Features

- o Precise swaging on the job
- o Re-round deformed tubes and fittings
- o Salvage shorts and scrap for couplings
- o Automatically notches tube for capillary action.

YELLOW JACKET®
RITCHIE ENGINEERING COMPANY, INC.

Printed in the U.S.A.

Operating Instructions

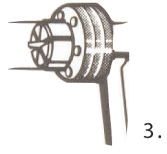

1.

1. Select expander head of appropriate size. Open tool handles. Screw head onto expander tool body about 1/4 - 1/2 turn. Close tool handles and fully tighten expander head.


2.

2. Deburr inside and outside of tube (Fig. 1)

3. Use soft copper tube or anneal end prior to expanding. (Fig. 2)


3.

4. Raise tool arm as far as it will go and slide tube onto expander head until tool stop is reached. (Fig. 3)

5. Close handle until it will go no further.

6. Raise tool arm and remove tube.


4.

7. Tube will be automatically notched to allow capillary action for solder flow. (Fig. 4)

8. For small diameter tubes, you may need to expand halfway , rotate tool, and finish expanding full diameter.

Expander Heads

UPC #	Description	Max. Wall Thickness	Swage Depth	Segment Stretch
✱60413	5/16" expander head	0.039"	0.24"	0.06"
60414	3/8" expander head	0.039"	0.35"	0.06"
60415	1/2" expander head	0.047"	0.43"	0.06"
60416	5/8" expander head	0.047"	0.57"	0.06"
60417	3/4" expander head	0.047"	0.59"	0.06"
60418	7/8" expander head	0.047"	0.77"	0.06"
60420	1-1/8" expander head	0.063"	0.77"	0.90"
✱60422	1-3/8" expander head	0.063"	0.77"	0.90"
✱60424	1-5/8" expander head	0.063"	0.77"	0.90"
60494	Hydraulic expander pump with reamer in case			

✱ Optional sizes - order separately