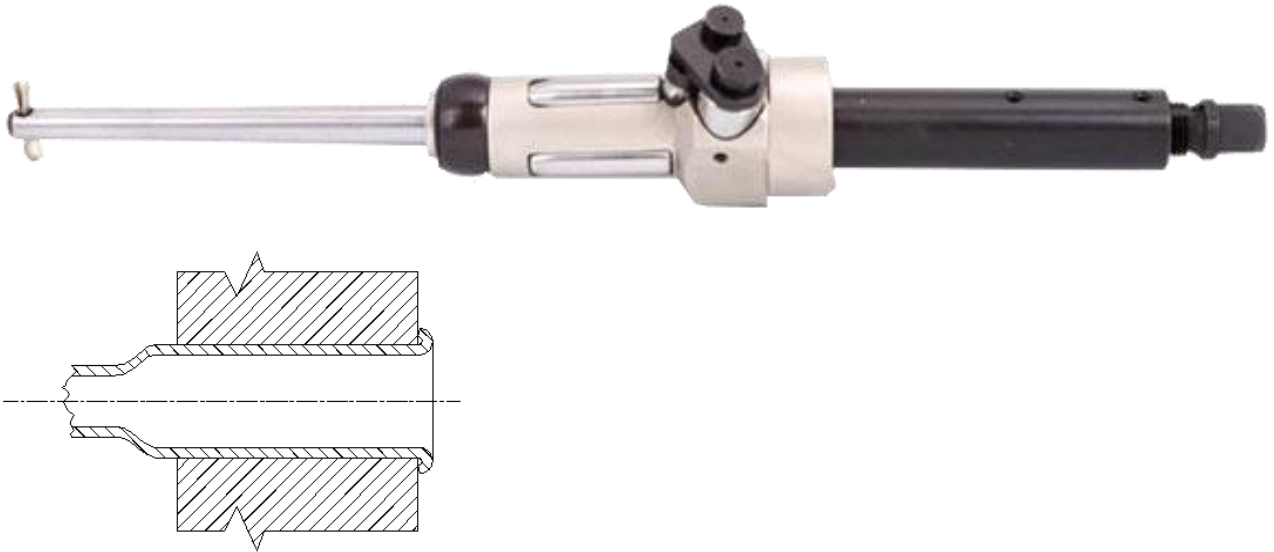


# Combination Beading Expanders

Tube expanding and beading in single operation



	Previously	Now
Tools Required	1) Flaring tube expander 2) Tube expander drive 3) Beading tool 4) Air hammer	1) Combination beading expander 2) Tube expander drive
Operating Steps	1) Expand 2) Bead 3) Reroll	1) Expand and bead (single operation)
Operator Fatigue	high...largely due to air hammer vibration and noise	Reduced significantly no air hammer for beading...no rerolling

Tube O.D		Tube Thickness		Expansion Range		Tool No.	Spare Roller No.	Beading Roll Model No.	Guide Roll Assembly Model No.	Mandrel Square		Spare Mandrel No.
mm	inch	bwg	inch	mm	inch					mm	inch	
50.80	2	10	0.134	43.2 - 48.41	1.700 - 1.906	41633 - 0010	41670 set of 4	41631 - 0010	41701 - 0010	19.05	(3/4")	41615
		11	0.120			41633 - 0011		41631 - 0011	41701 - 0011			
63.50	2.1/2	10	0.134	55.9 - 62.48	2.200 - 2.460	41634 - 0010	41673 set of 5	41651 - 0010	41702 - 0010	25.40	(1")	41635
		11	0.120			41634 - 0011		41651 - 0011	41702 - 0011			
		12	0.109			41634 - 0012		41651 - 0012	41702 - 0012			
		13	0.095			41634 - 0013		41651 - 0013	41702 - 0013			
76.20	3	10	0.134	68.6 - 75.69	2.700 - 2.980	41359 - 0010	41676 set of 5	41666 - 0010	41703 - 0010	25.40	(1")	41653
		11	0.120			41359 - 0011		41666 - 0011	41703 - 0011			
		12	0.109			41359 - 0012		41666 - 0012	41703 - 0012			