

# Tube Installation Accessories

Heat Exchanger & Condenser Tube Expanders Accessories

## GT Serrating Tools

An innovative line of serrating tools that re-defines grooving technology. The GT Serrating tools efficiently cut grooves in tube sheet holes which increases the strength of the rolled joint between the tube and tube sheet.



### Tube sheet hole application range: 1/2" – 1" (12.7 – 25.4 mm) I.D.

- Ti coated bits available in SAE and Metric sized groove configurations & shapes.
- Serrating Tools available with standard mandrel or mandrels with carbide inserts.
- Mandrels with carbide inserts remove burrs left on grooves eliminating an extra de-burring process.
- Compact design for extreme rigidity, extended bit life, less run-out and increased accuracy.
- Unique through-spindle coolant delivery system provides superior groove quality and unmatched bit life.
- Catalog tools have two bit patterns to choose from, all others are special, made to order, and priced on request.
- Designed for easy bit replacement which saves time and money.
- Depth from face of tube sheet to the back of the second groove is adjustable from 1/2" to 1-1/4" (12.7 - 31.75mm).



#### Complete serrating tool, furnished with carbide insert mandrel, SAE tool bit

Tube Sheet Hole		Inch Tool Number* (Order Number)	Shank	Standard Tool Bit	Optional Tool Bit
in.	mm			1/8 x 1/4 x 1/8"	1/8 x 3/8 x 1/8"
1/2	12.70	GT 500C 3MT (5526083)	3MT	GT 5003 S (2902039)	GT 5003 (2902030)
5/8	15.80	GT 625C 3MT (5525886)	3MT	GT 5003 S (2902039)	GT 5003 (2902030)
3/4	19.05	GT 750C 3MT (5525756)	3MT	GT 7503 S (2901403)	GT 7503 (2900686)
7/8	22.20	GT 875C3MT (5525587)	3MT	GT 7503 S (2901403)	GT 7503 (2900686)
1	25.40	GT 1000C 3MT (5525706)	3MT	GT 7503 S (2901403)	GT 7503 (2900686)
3/4	19.05	GT 750C 1SP (5526137)	1" RD	GT 7503 S (2901403)	GT 7503 (2900686)
1	25.40	GT 1000C 1SP (5526138)	1" RD	GT 7503 S (2901403)	GT 7503 (2900686)

\* Includes "Standard Tool Bit"

#### Complete serrating tool, furnished with carbide insert mandrel, Metric tool bit

Tube Sheet Hole		Inch Tool Number* (Order Number)	Shank	Standard Tool Bit	Optional Tool Bit
in.	mm			3 x 6 x 3 mm	3 x 10 x 3 mm
1/2	12.70	GT 1270C 3MT (5526115)	3MT	GT 50 363 (2902091)	GT 50 3103 (2902117)
5/8	15.80	GT 1588C 3MT (5526116)	3MT	GT 50 363 (2902091)	GT 50 3103 (2902117)
3/4	19.05	GT 1905C 3MT (5526117)	3MT	GT 75 363 (2902092)	GT 75 3103 (2902118)
7/8	22.20	GT 2223C 3MT (5526118)	3MT	GT 75 363 (2902092)	GT 75 3103 (2902118)
1	25.40	GT 2540C 3MT (5526119)	3MT	GT 75 363 (2902092)	GT 75 3103 (2902118)
3/4	19.05	GT 1905C 1SP (5526164)	1" RD	GT 75 363 (2902092)	GT 75 3103 (2902118)
1	25.40	GT 2540C 1SP (5526165)	1" RD	GT 75 363 (2902092)	GT 75 3103 (2902118)

\* Includes "Standard Tool Bit"

**Complete serrating tool, furnished with standard mandrel, SAE tool bit**

Tube Sheet Hole		Inch Tool Number* (Order Number)	Shank	Standard Tool Bit	Optional Tool Bit
in.	mm			1/8 x 1/4 x 1/8"	1/8 x 3/8 x 1/8"
1/2	12.70	GT 500NC 3MT (5526299)	3MT	GT 5003 S (2902039)	GT 5003 (2902030)
5/8	15.80	GT 625NC 3MT (5526296)	3MT	GT 5003 S (2902039)	GT 5003 (2902030)
3/4	19.05	GT 750NC 3MT (5526297)	3MT	GT 7503 S (2901403)	GT 7503 (2900686)
7/8	22.20	GT 875NC 3MT	3MT	GT 7503 S (2901403)	GT 7503 (2900686)
1	25.40	GT 1000NC 3MT (5526298)	3MT	GT 7503 S (2901403)	GT 7503 (2900686)
3/4	19.05	GT 750NC 1SP	1" RD	GT 7503 S (2901403)	GT 7503 (2900686)
1	25.40	GT 1000NC 1SP	1" RD	GT 7503 S (2901403)	GT 7503 (2900686)

\* Includes "Standard Tool Bit"

**Complete serrating tool, furnished with standard mandrel, Metric tool bit**

Tube Sheet Hole		Inch Tool Number* (Order Number)	Shank	Standard Tool Bit	Optional Tool Bit
in.	mm			3 x 6 x 3 mm	3 x 10 x 3 mm
1/2	12.70	GT 1270NC 3MT	3MT	GT 50 363 (2902091)	GT 50 3103 (2902117)
5/8	15.80	GT 1588NC 3MT	3MT	GT 50 363 (2902091)	GT 50 3103 (2902117)
3/4	19.05	GT 1905NC 3MT (526421)	3MT	GT 75 363 (2902092)	GT 75 3103 (2902118)
7/8	22.20	GT 2223NC 3MT (5526305PT)	3MT	GT 75 363 (2902092)	GT 75 3103 (2902118)
1	25.40	GT 2540NC 3MT	3MT	GT 75 363 (2902092)	GT 75 3103 (2902118)
3/4	19.05	GT 1905NC 1SP	1" RD	GT 75 363 (2902092)	GT 75 3103 (2902118)
1	25.40	GT 2540NC 1SP	1" RD	GT 75 363 (2902092)	GT 75 3103 (2902118)

\* Includes "Standard Tool Bit"

**GT Serrating Tool Nomenclature**

XX ↓ Tool Series	XXXX ↓ Tube Sheet Hole Dia.	XX ↓ Mandrel Type	XXX ↓ Shank Size	XXX ↓ Specials
GT	500 = 1/2" 625 = 5/8" 750 = 3/4" 875 = 7/8" 1000 = 1" 1270 = 12.70mm 1588 = 15.88mm 1905 = 19.05mm 2223 = 22.23mm 2540 = 25.40mm	C = Carbide NC = Non-carbide	3MT = #3 Morse Taper 1SP = 1" (25.4mm) Round	Longer reach



**Example**  
GT 5003 S  
(2902039)

