

G-1200 Series – 5-Roll Expanders

O.D. Range: 1/2" – 1-1/2" (12.7 – 38.1 mm)

- **Expanders with 1-1/2" (38.1 mm) long rolls will accommodate tube sheet thicknesses as follows:**
 Standard Reach 1/2" to 5" (12.7 mm to 127.0 mm)
 "A" Reach 1-1/4" to 7-3/4" (31.7 mm to 196.8 mm)
 "C" Reach 1-1/2" to 11-3/4" (38.1 mm to 298.5 mm)
- **Expanders with 2-1/4" (57.1 mm) long rolls will accommodate tube sheet thicknesses as follows:**
 Standard Reach 1-1/4" to 5-3/4" (31.7 mm to 146.0 mm)
 "A" Reach 2" to 8-1/2" (50.8 mm to 215.9 mm)
 "C" Reach 2-1/4" to 12-1/2" (57.1 mm to 317.5 mm)
- Longer reaches available upon request.
- Reversible Thrust Collar design allows flush and 1/8" recess tube rolling. Reversible thrust collars on Standard Reach expanders and have lubrication port for use with auto-lube configured ATR and DAS tube rolling systems.



NOTE: Step expanding becomes necessary if the tube sheet thickness exceeds the length of the roll. Specify "S" Type rolls for step rolling applications.

Sizes not listed available upon request.

Standard Reach		Tube Sheet Thickness				Min. I.D. Tool Enters		Max. Expan. of Tool		Mandrel Number (Order No.)	Recommended Rolling Motors (Order No.)								
Tube O.D.	Tube Gauge	1/2 in. to 5 in. (12.7 mm to 127.0 mm)		1-1/4 in. to 5-3/4 in. (31.7 mm to 146.0 mm)						3/8 in. Sq. Dr. (9.5 mm)	Airetool	Electric							
in.	mm	bwg	in.	mm	in.	mm	Tool No. (Order No.)	Roll Set No. (Order No.)	Tool No. (Order No.)	Roll Set No. (Order No.)	in.	mm	in.	mm					
5/8	15.8	17	0.058	1.47	0.509	12.92	1215-5 (5519905)	R-4-5 (5513832)	1216-5 (5516284)	R-4-A-5 (5517897)	0.499	12.67	0.564	14.32	M-59 (2528300)	850-1250-A (8405399)			
		18	0.049	1.24	0.527	13.38	1217-5 (5517561)	R-4-5 (5513832)	1218-5 (5516230)	R-4-A-5 (5517897)	0.517	13.13	0.576	14.63					
		19	0.042	1.06	0.541	13.74	1219-5 (5517601)	R-4-5 (5513832)	1220-5 (5515836)	R-4-A-5 (5517897)	0.531	13.48	0.596	15.13	M-61 (2530100)				
		20	0.035	0.88	0.555	14.09													
		21	0.032	0.81	0.561	14.24													
		22	0.028	0.71	0.569	14.45													
3/4	19.0	13	0.095	2.41	0.560	14.22	1221-5 (5518046)	R-5-5 (5513231)	1222-5 (5515972)	R-5-A-5 (5518189)	0.550	13.97	0.615	15.62	M-61 (2530100)	850-600-A (8405398)			
		14	0.083	2.10	0.584	14.83	1223-5 (5514699)	R-6-5 (5518187)	1224-5 (5513968)	R-6-A-5 (5517898)	0.574	14.57	0.629	15.97					
		15	0.072	1.82	0.606	15.39	1225-5 (5515940)	R-7-5 (5514393)	1226-5 (5523014)	R-7-A-5 (5517899)	0.590	14.98	0.661	16.78	M-62 (2531000)				
		16	0.065	1.65	0.620	15.74	1227-5 (5514698)	R-7-5 (5514393)	1228-5 (5512230)	R-7-A-5 (5517899)	0.605	15.36	0.680	17.27	M-63 (2531900)	850-1250-A (8405399)	979-C-650/ ATC-900		
		17	0.058	1.47	0.634	16.10	1229-5 (5515536)	R-8-5 (5515995)	1230-5 (5513536)	R-8-A-5 (5515996)	0.619	15.72	0.699	17.54					
		18	0.049	1.24	0.652	16.56													
		19	0.042	1.06	0.666	16.91	1231-5 (5514862)	R-9-5 (5517888)	1232-5 (5513488)	R-9-A-5 (5517900)	0.642	16.30	0.729	18.51					
		20	0.035	0.88	0.680	17.27													
		21	0.032	0.81	0.686	17.42													
		22	0.028	0.71	0.694	17.62													
7/8	22.2	13	0.095	2.41	0.685	17.39	1233-5 (5515915)	R-9-5 (5517888)	1234-5 (5518158)	R-9-A-5 (5517900)	0.670	17.01	0.747	18.97	M-64 (2532800) *			850-600-A (8405398)	979-C-650/ ATC-900
		14	0.083	2.10	0.709	18.00	1235-5 (5518682)	R-10-5 (5518191)	1236-5 (5520939)	R-10-A-5 (5517901)	0.685	17.39	0.774	19.65	M-65 (2533700) *				
		16	0.065	1.65	0.745	18.92	1239-5 (5525733)	R-11-5 (5517889)	1240-5 (5525734)	R-11-A-5 (5517902)	0.685	17.39	0.750	19.05					
		17	0.058	1.47	0.759	19.27	1243-5 (5518366)	R-11-5 (5517889)	1244-5 (5521320)	R-11-A-5 (5517902)	0.740	18.79	0.824	20.92	M-67 (2535500) *				
		18	0.049	1.24	0.777	19.73	1245-5 (5525740)	R-11-5 (5517889)	1246-5 (5515924)	R-11-A-5 (5517902)	0.763	19.38	0.851	21.61	M-68 (2536400) *				
		19	0.042	1.06	0.791	20.09													
		20	0.035	0.88	0.805	20.44													

* 1/2 in. Sq. Dr. (12.7 mm)

Condenser Expanders

G-1200 Series Heat Exchanger & Condenser Tube Expanders (cont.)

Standard Reach							Tube Sheet Thickness				Min. I.D. Tool Enters		Max. Expan. of Tool		Mandrel Number (Order No.) 1/2 in. Sq. Dr. (12.7 mm)	Recommended Rolling Motors (Order No.)	
Tube O.D.		Tube Gauge		Tube I.D.			1/2 in. to 5 in. (12.7 mm to 127.0 mm)		1-1/4 in. to 5-3/4 in. (31.7 mm to 146.0 mm)							Airetool	Electric
in.	mm	bwg	in.	mm	in.	mm	Tool No. (Order No.)	Roll Set No. (Order No.)	Tool No. (Order No.)	Roll Set No. (Order No.)	in.	mm	in.	mm			
7/8	22.2	21	0.032	0.81	0.811	20.59	1245-5 (5525740)	R-11-5 (5517889)	1246-5 (5515924)	R-11-A-5 (5517902)	0.763	19.38	0.851	21.61	M-68 (2536400)	850-1250-A (8405399)	979-C-650/ ATC-900
		22	0.028	0.71	0.819	20.80											
1	25.4	12	0.109	2.76	0.782	19.86	1245-5 (5525740)	R-11-5 (5517889)	1246-5 (5515924)	R-11-A-5 (5517902)	0.763	19.38	0.851	21.61	M-68 (2536400)	850-600-A (8405398)	979-C-650/ ATC-900
		13	0.095	2.41	0.810	20.57	1247-5 (5516336)	R-13-5 (5513741)	1248-5 (5517558)	R-13-A-5 (5517903)	0.791	20.09	0.880	22.35			
		14	0.083	2.10	0.834	21.18	1249-5 (5514121)	R-12-5 (5517890)	1250-5 (5514700)	R-12-A-5 (5515825)	0.810	20.57	0.909	23.08	M-70 (2538200)		
		15	0.072	1.82	0.856	21.74	1251-5 (5513797)	R-14-5 (5517894)	1252-5 (5512231)	R-14-A-5 (5515826)	0.837	21.25	0.936	23.77			
		16	0.065	1.65	0.870	22.09											
		17	0.058	1.47	0.884	22.45	1255-5 (5513740)	R-13-5 (5513741)	1256-5 (5513809)	R-13-A-5 (5517903)	0.865	21.97	0.965	24.51	M-71 (2539100)	850-1250-A (8405399)	
		18	0.049	1.24	0.902	22.91											
		19	0.042	1.06	0.916	23.26											
		20	0.035	0.88	0.930	23.62											
		21	0.032	0.81	0.936	23.77	1257-5 (5514329)	R-15-5 (5513833)	1258-5 (5513627)	R-15-A-5 (5517907)	0.883	22.42	0.997	25.32			
		22	0.028	0.71	0.944	23.97											
1-1/8	28.5	12	0.109	2.76	0.907	23.03	1257-5 (5514329)	R-15-5 (5513833)	1258-5 (5513627)	R-15-A-5 (5517907)	0.883	22.42	0.997	25.32	M-71 (2539100)	1050-400 (8404200)	979-C-300/ ATC-900
		13	0.095	2.41	0.935	23.74	1259-5 (5524563)	R-16-5 (5518056)	1260-5 (5525735)	R-16-A-5 (5517904)	0.916	23.26	1.000	25.40			
		14	0.083	2.10	0.959	24.35	1261-5 (5525736)	R-17-5 (5517891)	1262-5 (5514470)	R-17-A-5 (5517905)	0.935	23.74	1.043	26.49			
1-1/4	31.8	15	0.072	1.82	1.106	28.09	1275-5 (5521923)	R-21-5 (5517887)	1276-5 (5516623)	R-21-A-5 (5513291)	1.087	27.60	1.196	30.37	1276-5 (2982367)	1050-400 (8404200)	979-C-650/ ATC-900
		16	0.065	1.65	1.120	28.44											
		17	0.058	1.47	1.134	28.80	1279-5 (5525540)	R-21-5 (5517887)	1280-5 (5517875)	R-21-A-5 (5513291)	1.115	28.32	1.231	31.26	1280-5 (2983613)		
		18	0.049	1.24	1.152	29.26											
		19	0.042	1.06	1.166	29.61											
		20	0.035	0.88	1.180	29.97											
		21	0.032	0.81	1.186	30.12											
22	0.028	0.71	1.194	30.32													
1-3/8	34.9	12	0.109	2.76	1.154	29.31	1281-5 (5518823)	R-21-5 (5517887)	1282-5 (5525737)	R-21-A-5 (5513291)	1.133	28.77	1.242	31.54	1282-5 (2986615)	1550-250 (8404280)	979-C-210/ ATC-900
		14	0.083	2.10	1.209	30.70	1285-5 (5522166)	R-23-5 (5517982)	1286-5 (5525869)	R-23-A-5 (5518192)	1.179	29.94	1.296	31.91			
1-1/2	38.1	17	0.058	1.47	1.384	35.15	1299-5 (5513442)	R-29-5 (5517893)	1300-5 (5514833)	R-29-A-5 (5517906)	1.331	33.80	1.489	37.82	1299-5 (2973869)	1550-900 (8404290)	979-C-300/ ATC-900
		18	0.049	1.24	1.402	35.61											
		19	0.042	1.06	1.416	35.96											
		20	0.035	0.88	1.430	36.32											
		21	0.032	0.81	1.436	36.47											
		22	0.028	0.71	1.444	36.67											