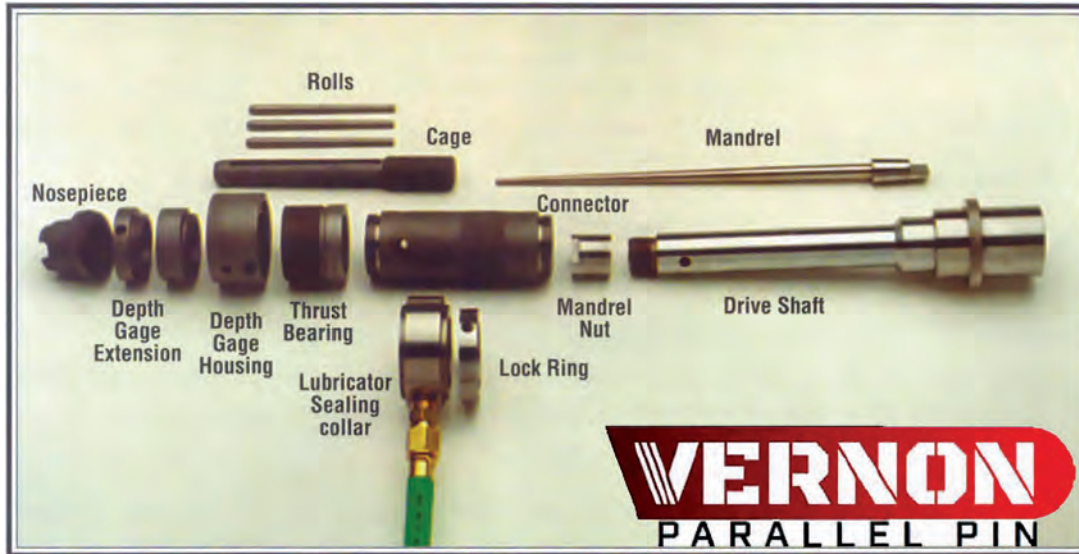


# Vernon Hydraulic Tube Expansion

Type "A" Vernon Tooling

## VERNON "A" TYPE TUBE EXPANDERS

TUBE O.D. RANGE: 1/2" THRU 1-1/4"



### TUBE TOOLING SELECTION GUIDE DEPTH GAGE

O.D.	BWG	I.D. (AVG.) WALL	EFF. ROLL LENGTH	Expander Part No.	Minimum Diameter	Maximum Diameter	Roll Set Part No.	Mandrel Part No.	Housing Part No.	Ext. Piece	Nose Piece
<b>1/2"</b>	17	0.384	2-3/16"	5-11A	0.374	0.424	1/2A	3A	L5	E5	4NPA
	18	0.402		4-18A	0.387	0.450	0A				
	19	0.416		4-18A	0.387	0.450	0A				
<b>5/8"</b>	11	0.385	2-3/16"	5-11A	0.374	0.424	1/2A	3A	L5	E5	5NPA
	12	0.407		4-18A	0.387	0.450	0A				
	13	0.435	2-7/8"	5-13A	0.422	0.502	1A	5A			
	14	0.459		5-14A	0.452	0.515	2A				
	15	0.481		5-15A	0.462	0.525	3A				
	16	0.495		5-16A	0.472	0.537	4A				
	17	0.509		5-17A	0.488	0.551	5A				
	18	0.527		5-18A	0.512	0.575	6A				
	19	0.541		5-18A	0.512	0.575	6A				
	20	0.555	3-3/8"	6-13A	0.534	0.611	9A	6A	L6		
<b>3/4"</b>	10	0.482	2-7/8"	5-15A	0.462	0.525	3A	5A	L5	E6	6NPA
	11	0.510		5-17A	0.488	0.551	5A				
	12	0.532		5-18A	0.512	0.575	6A				

## VERNON "A" TYPE TUBE EXPANDERS

TUBE O.D. RANGE: 1/2" THRU 1-1/4"

TUBE		TOOLING SELECTION GUIDE							DEPTH GAGE		
O.D.	BWG	I.D. (AVG.) WALL	EFF. ROLL LENGTH	Expander Part No.	Minimum Diameter	Maximum Diameter	Roll Set Part No.	Mandrel Part No.	Housing Part No.	Ext. Piece	Nose Piece
<b>3/4"</b>	13	0.560	3-3/4"	6-13A	0.534	0.611	9A	6A	LS	E6	6NPA
	14	0.584		6-14A	0.550	0.625	10A				
	15	0.606		6-15A	0.574	0.651	11A				
	16	0.620		6-16A	0.598	0.675	12A				
	17	0.634		6-17A	0.610	0.687	9A	8A			
	18	0.652		6-18A	0.626	0.703	10A				
	19	0.666		6-18A	0.626	0.703	10A				
	20	0.680		6-20A	0.652	0.729	11A				
	21	0.686		6-20A	0.652	0.729	11A				
	22	0.694		6-20A	0.652	0.729	11A				
<b>7/8"</b>	9	0.579	3-3/4"	6-14A	0.550	0.625	10A	6A	LS	E6	6NPA
	10	0.607		6-15A	0.574	0.651	11A	6A			
	11	0.635		6-17A	0.610	0.687	9A	8A			
	12	0.657		6-18A	0.626	0.703	10A	8A			
	13	0.685		8-9A	0.668	0.730	13A	7A			
	14	0.709		8-9A	0.680	0.742	13A				
	15	0.731		8-10A	0.700	0.762	14A				
	16	0.745		8-11A	0.724	0.786	15A				
	17	0.759		8-11A	0.724	0.786	15A				
	18	0.777		8-12A	0.773	0.835	16A				
	19	0.791		8-13A	0.766	0.843	20A	8A			
	20	0.805		8-13A	0.766	0.843	20A				
	21	0.811		8-13A	0.766	0.843	20A				
	22	0.819		8-14A	0.800	0.877	18A				
<b>1"</b>	8	0.670	3-3/4"	8-8A	0.650	0.712	12.5A	7A	L8	E6	8NPA
	9	0.704		8-9A	0.680	0.742	13A				
	10	0.732		8-10A	0.700	0.762	14A				
	11	0.760		8-11A	0.724	0.786	15A				
	12	0.782		8-12A	0.773	0.833	16A				
	13	0.810		8-13A	0.766	0.843	20A	8A			
	14	0.834		8-14A	0.800	0.877	18A				
	15	0.856		8-15A	0.823	0.900	19A	8A			
	16	0.870		8-16A	0.844	0.921	20A	10A			
	17	0.884		8-18A	0.869	0.921	18A				

# Vernon Hydraulic Tube Expansion

Type "A" Vernon Tooling

## VERNON "A" TYPE TUBE EXPANDERS

TUBE O.D. RANGE: 1/2" THRU 1-1/4"

### TUBE

### TOOLING SELECTION GUIDE

### DEPTH GAGE

O.D.	BWG	I.D. (AVG.) WALL	EFF. ROLL LENGTH	Expander Part No.	Minimum Diameter	Maximum Diameter	Roll Set Part No.	Mandrel Part No.	Housing Part No.	Ext. Piece	Nose Piece
<b>1"</b>	18	0.902	3-3/4"	8-18A	0.881	0.953	18A	10A	L8	E8	8NPA
	19	0.916		8-18A	0.881	0.958	18A				
	20	0.930		8-20A	0.901	0.978	19A				
	21	0.936		8-20A	0.901	0.978	19A				
	22	0.944		8-20A	0.901	0.978	19A				
<b>1-1/8"</b>	8	0.795	3-3/4"	8-13A	0.766	0.843	20A	8A	L8	E8	9NPA
	9	0.829		8-14A	0.800	0.877	18A				
	10	0.857		8-15A	0.823	0.900	19A				
	11	0.885		8-18A	0.869	0.921	18A	10A			
	12	0.907		8-18A	0.881	0.958	18A				
	13	0.935		10-9A	0.923	1.000	21A				
	14	0.959		10-9A	0.923	1.000	21A				
	15	0.981		10-10A	0.943	1.020	22A				
	16	0.995		10-11A	0.975	1.052	23A				
	17	1.009		10-11A	0.975	1.052	23A				
18	1.027		10-12A	0.999	1.076	24A					
<b>1-1/4"</b>	8	0.920	3-3/4"	8-18A	0.881	0.953	18A	10A	L8	E8	10NPA
	9	0.954		10-9A	0.923	1.000	21A				
	10	0.982		10-10A	0.943	1.020	22A				
	11	1.010		10-11A	0.975	1.052	23A				
	12	1.032		10-12A	0.999	1.076	24A				
	13	1.060		10-14A	1.047	1.124	26A				
	14	1.084		10-14A	1.047	1.124	26A				
	15	1.106		10-16A	1.095	1.172	28A				

Larger sizes available on request.

All take Thrust Bearing LTB -3/4