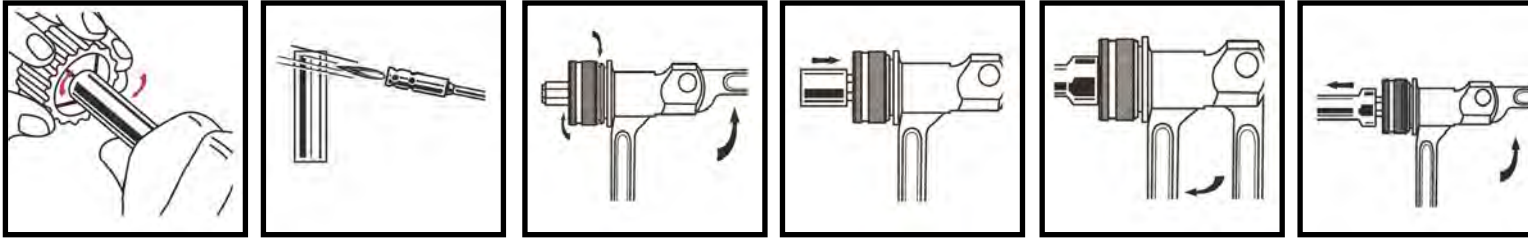


# XpandR™ Swaging/Tube Expander Tool

10000772\_B



## INSTRUCTIONS FOR USE

1. Deburr inside of tube.
2. To create perfectly centered capillary sockets for soldering or brazing, you must use soft copper or a tube end that has been fully annealed.
3. Pull XpandR handle up to 90-degree position. Maintain this position as you thread the appropriate size head over the center-punch and tighten.
4. Insert the tube end over the XpandR head.
5. Pull the lever completely down.
6. Return the lever to the 90-degree position. Remove expanded tube.

## To re-round slightly deformed tube ends

- Insert deformed tube end to the first groove of head
- Pull the lever completely down
- Return lever to the 90-degree position
- Removed expanded tube

**! WARNING** Keep body parts away from pinch/swage areas while using. Ensure tubing is secure in tool before swaging. Always wear approved eye protection. Broken materials may fly.



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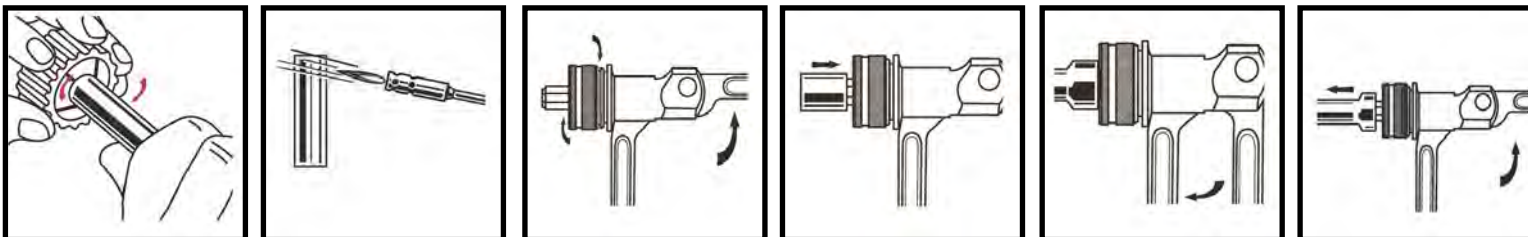
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## 175-EX REPLACEMENT PARTS LIST

175EXP	XpandR Pliers
175EXC	XpandR Case
175EX06	3/8" head
175EX08	1/2" head
175EX10	5/8" head
175EX12	3/4" head
175EX14	7/8" head
ADDITIONAL SIZES AVAILABLE	
175EX16	1" head
175EX18	1-1/8" head
175EX22	1-3/8" head
175EX26	1-5/8" head

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