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-day position
- Removed expanded tube

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