YELLOW JACKET®

Tubing Expander Model 60407

> Owner's Manual



Printed in the U.S.A.

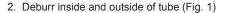
Features

- o Precise swaging on the job
- o Re-round deformed tubes and fittings
- o Salvage shorts and scrap for couplings
- o Automatically notches tube for capillary action.



Operating Instructions

1. Select expander head of appropriate size. Open tool handles. Screw head onto expander tool body about 1/4 - 1/2 turn. Close tool handles and fully tighten expander head.



- 3. Use soft copper tube or anneal end prior to expanding. (Fig. 2)
- 4. Raise tool arm as far as it will go and slide tube onto expander head until tool stop is reached. (Fig. 3)
- 5. Close handle until it will go no further.
- 6. Raise tool arm and remove tube.
- 7. Tube will be automatically notched to allow capillary action for solder flow. (Fig. 4)
- 8. For small diameter tubes, you may need to expand halfway, rotate tool, and finish expanding full diameter.

Expander Heads

UPC#	Description	Max. Wall Thickness	Swage Depth	Segment Stretch
★ 60413	5/16" expander head	0.039"	0.24"	0.06"
60414	3/8" expander head	0.039"	0.35"	0.06"
60415	1/2" expander head	0.047"	0.43"	0.06"
60416	5/8" expander head	0.047"	0.57"	0.06"
60417	3/4" expander head	0.047"	0.59"	0.06"
60418	7/8" expander head	0.047"	0.77"	0.06"
60420	1-1/8" expander head	0.063"	0.77"	0.90"
★ 60422	1-3/8" expander head	0.063"	0.77"	0.90"
★ 60424	1-5/8" expander head	0.063"	0.77"	0.90"
60494	Hydraulic expander pump with reamer in case			

* Optional sizes - order separately







