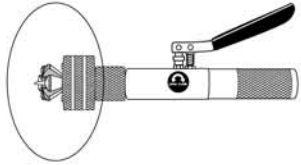


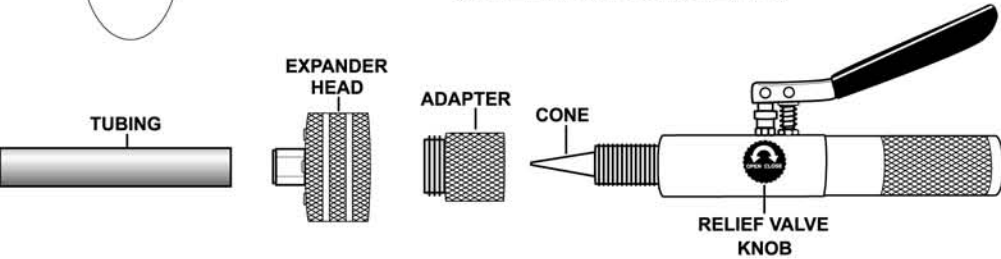


# TUBE EXPANDER INSTRUCTIONS

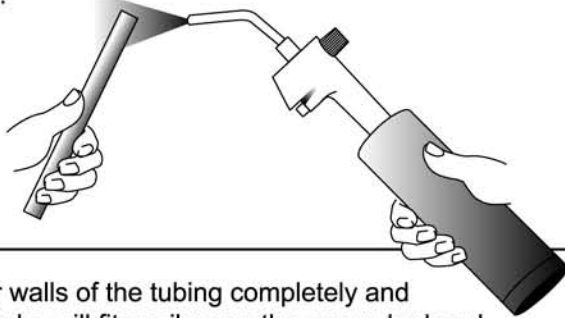
**! WARNING**  Wear Safety Goggles



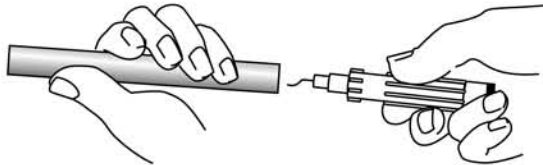
**NEVER OPERATE PUMP  
WITHOUT TUBING  
ON EXPANDER HEAD!**



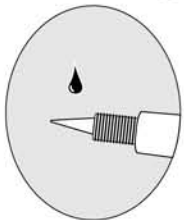
- 1) Use soft copper tube or heat (anneal) the section of hard copper tubing to be expanded.



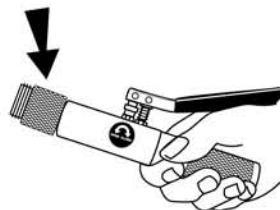
- 2) Deburr the inner walls of the tubing completely and make sure the tube will fit easily over the expander head.  
**DO NOT FORCE THE TUBE OVER THE EXPANDER HEAD!**



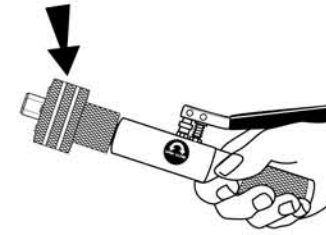
- 3) Apply lubricant (preferably grease) to the cone before using.



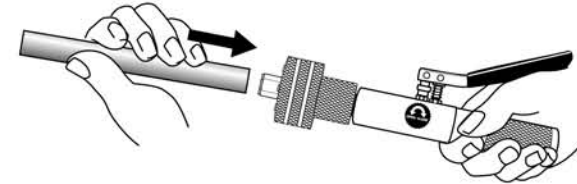
- 4) Screw the adapter onto the shaft of the pump all the way.



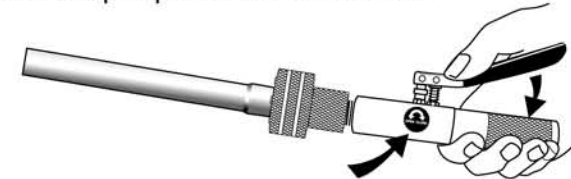
- 5) Screw the selected expander head onto the adapter.



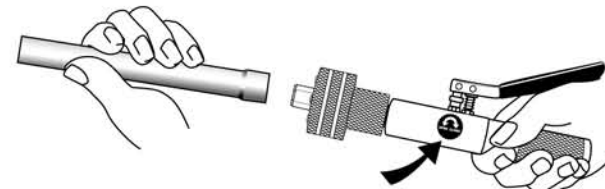
- 6) Place the tubing onto the expander head. Make sure that the expander head travels into the tube **FREELY**.  
**WARNING!! Do not force or twist the tube while you are placing the tube on the expander head.**



- 7) Tighten the relief valve knob and pump handle until tubing is expanded and pump handle becomes firm.



- 8) Loosen the relief valve knob to release the finished tubing.  
**If the tube does not release from the die head because of tube configuration or burrs, unscrew the adapter and die head (together) from the pump body.**



**TECHNICAL ASSISTANCE: PLEASE CALL...1-888-825-6989**