



HVAC/R TOOLS AND
VACUUM PUMPS SPECIALIST

LEVER TUBE EXPANDING TOOL KIT INSTRUCTION



CT-100AL CT-100A
CT-100ML CT-100M



Lever Tube Expanding Tool Kit		Specification
Item No.		
CT-100AL	WK-650 & CT-207	For Inch: 3/8", 1/2", 5/8", 3/4", 7/8", 1", 1 1/8", 1 1/4", 1 3/8", 1 1/2" & 1 5/8" O.D. Tubing
CT-100ML	CT-532 & CT-207	For Metric: 10, 12, 16, 19, 22, 25, 28, 32, 35, 38, 42mm O.D. Tubing
CT-100A		For Inch: 3/8", 1/2", 5/8", 3/4", 7/8", 1", 1 1/8" O.D. Tubing
CT-100M		For Metric: 10, 12, 16, 19, 22, 25, 28mm O.D. Tubing

New Spare Expander Heads		
Item No.	Inch	Metric
R1100A 41	For inch: 3/8"	For metric: 10mm
R1100A 42	For inch: 1/2"	For metric: 12mm
R1100A 43	For inch: 5/8"	For metric: 16mm
R1100A 44	For inch: 3/4"	For metric: 19mm
R1100A 45	For inch: 7/8"	For metric: 22mm
R1100A 46	For inch: 1"	For metric: 25mm
R1100A 47	For inch: 1 1/8"	For metric: 32mm
R1100A 48	For inch: 1 1/4"	For metric: 35mm
R1100A 49	For inch: 1 3/8"	For metric: 38mm
R1100A 50	For inch: 1 1/2"	For metric: 38mm
R1100A 51	For inch: 1 5/8"	For metric: 42mm

New Optional Expander Heads		
Item No.	Inch	Metric
R1100A 52	For inch: 3/4"	For metric: 19mm
R1100A 53	For inch: 1"	For metric: 25mm
R1100A 54	For inch: 1 1/8"	For metric: 32mm

DSZH®

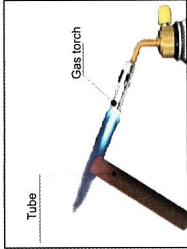


Thanks for purchasing **DSZH**® products. for safe and correct using, please read this user instruction carefully before using the product.

USER INSTRUCTION

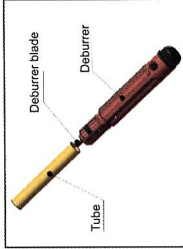
(1) Prepare before expanding- anneal the hard tube

For hard tubes, we need to anneal the tubes before expanding. If not, the tubes may cracking after be expanded;



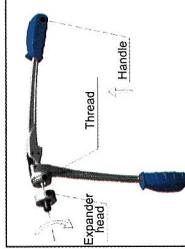
(2) Prepare before expanding- deburr

Put deburrer inside the tube and rotate it in clockwise smoothly to deburr the tube.



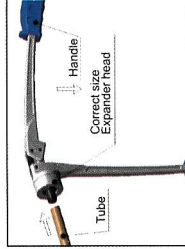
(3) Prepare before expanding - put on the expander head:

Put out the expander levers before put on the expander head. Choose a correct size expander head and rotate it in clockwise to put it on tube expander.



(4) Prepare before expanding - put on the tubing:

First, insert the expander head into tubing at a depth of 2-3mm, push the expander levers lightly to expand the tube a little bit, then insert the expander head in tube; if the tube is distorted badly and you can not insert expander head in it completely, follow the steps below:



1) Remove the tubing - remove the tubing from the expander head;

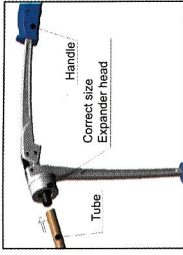
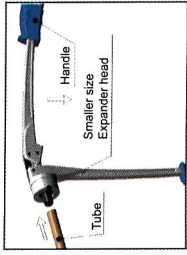
2) Remove the expander head - rotate the expander head in anticlockwise to remove the expander head from tube expander;

2) Put on the expander head - put on a smaller size expander head on the tube expander in clockwise (for example, if a 19mm O.D.tubing will be expanded, put a 16mm expander head on the tube expander.)

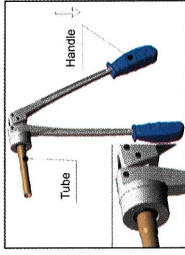
4) Put on and expand tubing-put the tubing on expander head completely and push the levers until the tubing is expanded completely;

5) Put on a correct size expander head - remove the smaller expander head first, and put on the correct size one in clockwise on the tube expander.

6) Put on the tubing - put the tubing on expander head completely;



(5) Start expand tubing- push the levers
Push the levers until the tubing is expanded completely;



(6) After tubing is expanded - pull the levers
Pull the levers, the expander punch will retract, then remove the tubing from expander head;

