

# F600 Flare Type Series

The F600 Series combines tube expansion with flaring in a single tool. It features three expansion rolls and three flaring rolls, offering a slightly adjustable working range. This tool is ideal for expanding and flaring tubes in condensers, coolers, heat exchangers, surface condensers, and FinFan coolers.



## WORKING RANGE

| TUBE ID          | TUBE OD        | TUBE SHEET       |
|------------------|----------------|------------------|
| 13,51 – 22,45 mm | 15,8 – 25,4 MM | 38,1 – 57,1 MM   |
| 0,532 – 0,884"   | 5/8" to 1"     | 1-1/2" to 2-1/4" |

## ADDITIONAL INFORMATION



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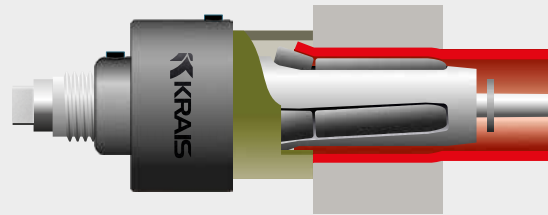
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## RECOMMENDATION

When using the F-600 series expander make sure that the flare length is correctly set up and the thrust collar rest against the tube sheet.



| TUBE ID |       | ROLL LENGTH<br>1-1/2" (38,1 MM) |             | ROLL LENGTH<br>2-1/4" (57,1 MM) |              | EXPANSION RANGE |       |       |       | FLARE ROLL  | MANDREL     | RECOMMENDED DRIVE* |           |
|---------|-------|---------------------------------|-------------|---------------------------------|--------------|-----------------|-------|-------|-------|-------------|-------------|--------------------|-----------|
| [INCH]  | [MM]  | TOOL NO.                        | ROLL NO.    | TOOL NO.                        | ROLL NO.     | [INCH]          | MIN   | MAX   | [MM]  |             |             | ELECTRIC           | PNEUMATIC |
| 0,532   | 13,51 | <b>619</b>                      | <b>K-7</b>  | <b>620</b>                      | <b>K-7A</b>  | 0,511           | 0,511 | 0,570 | 12,98 | <b>F-8</b>  | <b>M-6</b>  | TESMini 2, ES2     | K50-600   |
| 0,560   | 14,22 | <b>621</b>                      | <b>K-8</b>  | <b>622</b>                      | <b>K-8A</b>  | 0,539           | 0,539 | 0,606 | 13,69 | <b>F-8</b>  | <b>M-8</b>  | TESMini 2, ES2     | K50-600   |
| 0,584   | 14,83 | <b>623</b>                      | <b>K-9</b>  | <b>624</b>                      | <b>K-9A</b>  | 0,562           | 0,562 | 0,629 | 14,27 | <b>F-9</b>  | <b>M-8</b>  | TESMini 2, ES2     | K50-600   |
| 0,606   | 15,39 | <b>625</b>                      | <b>K-10</b> | <b>626</b>                      | <b>K-10A</b> | 0,586           | 0,586 | 0,649 | 14,88 | <b>F-10</b> | <b>M-8</b>  | TESMini 2, ES2     | K50-600   |
| 0,620   | 15,75 | <b>627</b>                      | <b>K-10</b> | <b>628</b>                      | <b>K-10A</b> | 0,594           | 0,594 | 0,677 | 15,09 | <b>F-10</b> | <b>M-9</b>  | TESMini 2, ES2     | K50-600   |
| 0,634   | 16,10 | <b>629</b>                      | <b>K-11</b> | <b>630</b>                      | <b>K-11A</b> | 0,610           | 0,610 | 0,688 | 15,49 | <b>F-11</b> | <b>M-9</b>  | TESMini 2, ES2     | K50-400   |
| 0,657   | 16,69 | <b>631</b>                      | <b>K-12</b> | <b>632</b>                      | <b>K-12A</b> | 0,633           | 0,633 | 0,712 | 16,08 | <b>F-12</b> | <b>M-9</b>  | TESMini 2, ES2     | K50-400   |
| 0,670   | 17,02 | <b>641</b>                      | <b>K-13</b> | <b>642</b>                      | <b>K-13A</b> | 0,645           | 0,645 | 0,724 | 16,38 | <b>F-13</b> | <b>M-9</b>  | TESMini 2, ES2     | K50-400   |
| 0,685   | 17,40 | <b>633</b>                      | <b>K-13</b> | <b>634</b>                      | <b>K-13A</b> | 0,661           | 0,661 | 0,740 | 16,79 | <b>F-13</b> | <b>M-10</b> | TESMini 2, ES2     | K50-400   |
| 0,709   | 18,01 | <b>635</b>                      | <b>K-14</b> | <b>636</b>                      | <b>K-14A</b> | 0,677           | 0,677 | 0,763 | 17,20 | <b>F-14</b> | <b>M-11</b> | TESMini 2, ES2     | K60-900   |
| 0,731   | 18,57 | <b>637</b>                      | <b>K-15</b> | <b>638</b>                      | <b>K-15A</b> | 0,700           | 0,700 | 0,791 | 17,78 | <b>F-15</b> | <b>M-11</b> | TESMini 2, ES2     | K60-900   |
| 0,745   | 18,92 | <b>639</b>                      | <b>K-15</b> | <b>640</b>                      | <b>K-15A</b> | 0,716           | 0,716 | 0,807 | 18,19 | <b>F-15</b> | <b>M-12</b> | TESMini 2, ES2     | K60-900   |
| 0,760   | 19,30 | <b>643</b>                      | <b>K-16</b> | <b>644</b>                      | <b>K-16A</b> | 0,732           | 0,732 | 0,818 | 18,59 | <b>F-16</b> | <b>M-12</b> | TESMini 2, DU1     | K60-900   |
| 0,782   | 19,86 | <b>645</b>                      | <b>K-17</b> | <b>646</b>                      | <b>K-17A</b> | 0,751           | 0,751 | 0,842 | 19,08 | <b>F-17</b> | <b>M-12</b> | TESMini 2, DU1     | K60-900   |
| 0,795   | 20,19 | <b>653</b>                      | <b>K-20</b> | <b>654</b>                      | <b>K-20A</b> | 0,767           | 0,767 | 0,866 | 19,48 | <b>F-20</b> | <b>M-13</b> | TESMini 2, DU1     | K60-900   |
| 0,810   | 20,57 | <b>647</b>                      | <b>K-18</b> | <b>648</b>                      | <b>K-18A</b> | 0,779           | 0,779 | 0,870 | 19,79 | <b>F-18</b> | <b>M-12</b> | TESMini 2, DU1     | K60-900   |
| 0,834   | 21,18 | <b>649</b>                      | <b>K-18</b> | <b>650</b>                      | <b>K-18A</b> | 0,799           | 0,799 | 0,897 | 20,29 | <b>F-18</b> | <b>M-13</b> | TESMini 2, DU1     | K60-900   |
| 0,856   | 21,74 | <b>651</b>                      | <b>K-19</b> | <b>652</b>                      | <b>K-19A</b> | 0,826           | 0,826 | 0,921 | 20,98 | <b>F-19</b> | <b>M-13</b> | TESMini 2, DU1     | K60-900   |
| 0,884   | 22,45 | <b>655</b>                      | <b>K-21</b> | <b>656</b>                      | <b>K-21A</b> | 0,854           | 0,854 | 0,948 | 21,69 | <b>F-21</b> | <b>M-13</b> | TESMini 2, DU1     | K60-900   |

\* Motor recommendation applies only to most popular cases with a standard percentage of the wall reduction. The recommendation can be different for thicker tube sheet, harder and exotic metal tube and a higher percentage of wall reduction.