

800-5 Five Roll Series

KRAIS 800-5 is a five-roll series designed for thin-wall tubes and materials sensitive to deformation. The five rolls distribute forming forces more evenly than standard tools, significantly reducing the risk of ovality and local distortion. This specialized design ensures joint integrity in very thin-wall tubing where precision is paramount.



WORKING RANGE

TUBE ID	TUBE OD	TUBE SHEET
12,98 - 36,68 MM	15,8 - 38,1 MM	12,7 - 57,1 MM
0,509" - 1,440"	5/8" to 1-1/2"	1/2" to 2-1/4"

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TUBE OD		TUBE GAUGE		TUBE ID		EXPANSION RANGE				TUBE SHEET THICKNESS				MANDREL	MANDREL SQUARE		PNEUMATIC MOTOR *	ELECTRIC MOTOR *	
										1/2" TO 1-1/2"		1-1/4" TO 2-1/4"							
										12,7 TO 38,1 MM		31,7 TO 57,1MM							
[INCH]	[MM]	[BWG]	[INCH]	[MM]	[INCH]	[MM]	MIN	MAX	MIN	MAX	TOOL NO.	ROLL NO.	TOOL NO.	ROLL NO.		[INCH]	[MM]		
5/8	15,8	17	0,058	1,47	0,509	12,93	0,499	0,564	12,67	14,33	815-5	R-4-5	816-5	R-4-A-5	M-816-5	3/8	9,5	K50-1250	TES3000 G1000 or TESMini2 DUO
		18	0,049	1,24	0,527	13,39	0,517	0,572	13,13	14,53	817-5	R-4-5	818-5	R-4-A-5	M-9	3/8	9,5		
		19	0,042	1,07	0,541	13,74	0,522	0,582	13,26	14,78	819-5	R-4-5	820-5	R-4-A-5	M-820-5	3/8	9,5		
		20	0,035	0,89	0,555	14,10	0,536	0,596	13,61	15,14	819-5[S]	R-4-5	820-5[S]	R-4-A-5	820-5[S]	3/8	9,5		
		21	0,032	0,81	0,561	14,25	0,536	0,596	13,61	15,14	819-5[S]	R-4-5	820-5[S]	R-4-A-5	820-5[S]	3/8	9,5		
		22	0,028	0,71	0,569	14,45	0,536	0,596	13,61	15,14	819-5[S]	R-4-5	820-5[S]	R-4-A-5	820-5[S]	3/8	9,5		
3/4	19,0	13	0,095	2,41	0,560	14,22	0,550	0,615	13,97	15,62	821-5	R-5-5	822-5	R-5-A-5	M-822-5	3/8	9,5	K50-600	TES3000 + G1450 TesMini2 + ES2
		14	0,083	2,11	0,584	14,83	0,574	0,639	14,58	16,23	823-5	R-6-5	824-5	R-6-A-5	M-824-5	3/8	9,5		
		15	0,072	1,83	0,606	15,39	0,590	0,661	14,99	16,79	825-5	R-7-5	826-5	R-7-A-5	M-826-5	3/8	9,5		
		16	0,065	1,65	0,620	15,75	0,605	0,685	15,37	17,40	827-5	R-7-5	828-5	R-7-A-5	M-13	3/8	9,5	K50-1250	TES3000 G1000 or TESMini2 DUO
		17	0,058	1,47	0,634	16,10	0,619	0,699	15,72	17,75	829-5	R-7-5	830-5	R-7-A-5	M-830-5	3/8	9,5		
		18	0,049	1,24	0,652	16,56	0,619	0,699	15,72	17,75	829-5	R-7-5	830-5	R-7-A-5	M-830-5	3/8	9,5		
		19	0,042	1,07	0,666	16,92	0,642	0,722	16,31	18,34	831-5	R-9-5	832-5	R-9-A-5	M-13	3/8	9,5		
		20	0,035	0,89	0,680	17,27	0,642	0,722	16,31	18,34	831-5	R-9-5	832-5	R-9-A-5	M-13	3/8	9,5		
		21	0,032	0,81	0,686	17,42	0,642	0,722	16,31	18,34	831-5	R-9-5	832-5	R-9-A-5	M-13	3/8	9,5		
		22	0,028	0,71	0,694	17,63	0,642	0,722	16,31	18,34	831-5	R-9-5	832-5	R-9-A-5	M-13	3/8	9,5		
7/8	22,2	13	0,095	2,41	0,685	17,40	0,670	0,750	17,02	19,05	833-5	R-9-5	834-5	R-9-A-5	M-14-3/8	3/8	9,5	K50-600	TES3000 G1450 or TESMini2 ES2
		14	0,083	2,11	0,709	18,01	0,685	0,774	17,40	19,66	835-5	R-10-5	836-5	R-10-A-5	M-15	3/8	9,5		
		16	0,065	1,65	0,745	18,92	0,726	0,815	18,44	20,70	839-5	R-11-5	840-5	R-11-A-5	M-840-5	3/8	9,5		
		17	0,058	1,47	0,759	19,28	0,740	0,829	18,80	21,06	843-5	R-11-5	844-5	R-11-A-5	M-17-3/8	3/8	9,5	K50-1250	TES3000 G1000 or TESMini2 DUO
		18	0,049	1,24	0,777	19,74	0,740	0,829	18,80	21,06	843-5	R-11-5	844-5	R-11-A-5	M-17-3/8	3/8	9,5		
		19	0,042	1,07	0,791	20,09	0,763	0,852	19,38	21,64	845-5	R-11-5	846-5	R-11-A-5	M-18-3/8	3/8	9,5		
		20	0,035	0,89	0,805	20,45	0,763	0,852	19,38	21,64	845-5	R-11-5	846-5	R-11-A-5	M-18-3/8	3/8	9,5		
		21	0,032	0,81	0,811	20,60	0,763	0,852	19,38	21,64	845-5	R-11-5	846-5	R-11-A-5	M-18-3/8	3/8	9,5		
22	0,028	0,71	0,819	20,80	0,763	0,852	19,38	21,64	845-5	R-11-5	846-5	R-11-A-5	M-18-3/8	3/8	9,5				

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TUBE OD		TUBE GAUGE		TUBE ID		EXPANSION RANGE				TUBE SHEET THICKNESS				MANDREL	MANDREL SQUARE		PNEUMATIC MOTOR *	ELECTRIC MOTOR *	
										1/2" TO 1-1/2"		1-1/4" TO 2-1/4"							
						[INCH]	[MM]	[INCH]	[MM]	[INCH]	[MM]	MIN	MAX		MIN	MAX			TOOL NO.
1	25,4	12	0,109	2,77	0,782	19,86	0,763	0,852	19,38	21,64	845-5	R-11-5	846-5	R-11-A-5	M-18-3/8	3/8	9,5	K50-600	TES3000 G1450 or TESMini2 ES2
		13	0,095	2,41	0,810	20,57	0,791	0,880	20,09	22,35	847-5	R-13-5	848-5	R-13-A-5	M-18-3/8	3/8	9,5		
		14	0,083	2,11	0,834	21,18	0,810	0,909	20,57	23,09	849-5	R-12-5	850-5	R-12-A-5	M-850-5	3/8	9,5		
		15	0,072	1,83	0,856	21,74	0,837	0,936	21,26	23,77	851-5	R-14-5	852-5	R-14-A-5	M-852-5	3/8	9,5		
		16	0,065	1,65	0,87	22,10	0,837	0,936	21,26	23,77	851-5	R-14-5	852-5	R-14-A-5	M-852-5	3/8	9,5		
		17	0,058	1,47	0,884	22,45	0,865	0,964	21,97	24,49	855-5	R-13-5	856-5	R-13-A-5	M-856-5	3/8	9,5	K50-1250	TES3000 G1000 or TESMini2 DU0
		18	0,049	1,24	0,902	22,91	0,865	0,964	21,97	24,49	855-5	R-13-5	856-5	R-13-A-5	M-856-5	3/8	9,5		
		19	0,042	1,07	0,916	23,27	0,865	0,964	21,97	24,49	855-5	R-13-5	856-5	R-13-A-5	M-856-5	3/8	9,5		
		20	0,035	0,89	0,93	23,62	0,865	0,964	21,97	24,49	855-5	R-13-5	856-5	R-13-A-5	M-856-5	3/8	9,5		
		21	0,032	0,81	0,936	23,77	0,883	0,982	22,43	24,94	857-5	R-15-5	858-5	R-15-A-5	M-21-3/8	3/8	9,5		
1-1/8	28,5	12	0,109	2,77	0,907	23,04	0,883	0,982	22,43	24,94	857-5	R-15-5	858-5	R-15-A-5	M-21-3/8	3/8	9,5	K60-400	TES3000 + G1000 TESMini2 + DU1
		13	0,095	2,41	0,935	23,75	0,916	1,015	23,27	25,78	859-5	R-16-5	860-5	R-16-A-5	M-860-5	1/2	12,7		
		14	0,083	2,11	0,959	24,36	0,935	1,044	23,75	26,52	861-5	R-17-5	862-5	R-17-A-5	M-862-5	1/2	12,7		
1-1/4	31,7	15	0,072	1,83	1,106	28,09	1,087	1,196	27,61	30,38	875-5	R-21-5	876-5	R-21-A-5	M-876-5	1/2	12,7	K60-400	TES3000 G1000 or TESMini2 DU1
		16	0,065	1,65	1,120	28,45	1,087	1,196	27,61	30,38	875-5	R-21-5	876-5	R-21-A-5	M-876-5	1/2	12,7		
		17	0,058	1,47	1,134	28,80	1,115	1,231	28,32	31,27	879-5	R-21-5	880-5	R-21-A-5	M-880-5	1/2	12,7		
		18	0,049	1,24	1,152	29,26	1,115	1,231	28,32	31,27	879-5	R-21-5	880-5	R-21-A-5	M-880-5	1/2	12,7		
		19	0,042	1,07	1,166	29,62	1,115	1,231	28,32	31,27	879-5	R-21-5	880-5	R-21-A-5	M-880-5	1/2	12,7		
		20	0,035	0,89	1,180	29,97	1,115	1,231	28,32	31,27	879-5	R-21-5	880-5	R-21-A-5	M-880-5	1/2	12,7		
		21	0,032	0,81	1,186	30,12	1,115	1,231	28,32	31,27	879-5	R-21-5	880-5	R-21-A-5	M-880-5	1/2	12,7		
		22	0,028	0,71	1,194	30,33	1,115	1,231	28,32	31,27	879-5	R-21-5	880-5	R-21-A-5	M-880-5	1/2	12,7		
1-3/8	34,9	12	0,109	2,77	1,157	29,39	1,133	1,242	28,78	31,55	881-5	R-21-5	882-5	R-21-A-5	M-882-5	1/2	12,7	K60-250	
		14	0,083	2,11	1,209	30,71	1,179	1,294	29,95	32,87	885-5	R-23-5	886-5	R-23-A-5	M-882-5	1/2	12,7		
1-1/2	38,1	17	0,058	1,47	1,384	35,15	1,331	1,472	33,81	37,39	899-5	R-29-5	900-5	R-29-A-5	M-900-5	1/2	12,7	K60-900	TES3000 G1000 or TESMini2 ES2
		18	0,049	1,24	1,402	35,61	1,331	1,472	33,81	37,39	899-5	R-29-5	900-5	R-29-A-5	M-900-5	1/2	12,7		
		19	0,042	1,07	1,416	35,97	1,331	1,472	33,81	37,39	899-5	R-29-5	900-5	R-29-A-5	M-900-5	1/2	12,7		
		20	0,035	0,89	1,430	36,32	1,331	1,472	33,81	37,39	899-5	R-29-5	900-5	R-29-A-5	M-900-5	1/2	12,7		
		21	0,032	0,81	1,436	36,47	1,331	1,472	33,81	37,39	899-5	R-29-5	900-5	R-29-A-5	M-900-5	1/2	12,7		
		22	0,028	0,71	1,444	36,68	1,331	1,472	33,81	37,39	899-5	R-29-5	900-5	R-29-A-5	M-900-5	1/2	12,7		

* 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.

RECOMMENDATION

For the thin wall tube, it is recommended to use 5 roll expanders with bottle rolls (BL) type rolls and BL type thrust collar to prevent the tube to be retracted inside the thrust collar making the tube projection uneven or even effectively jammed the tube inside collar.

