

F600 Flare Type Series

KRAIS F600 series performs tube expansion and end flaring in a single operation. Use it where specifications call for a flared tube end as a mechanical feature or to eliminate variability from separate flaring steps. Tight control of tube projection and flare geometry ensures consistent results and high productivity in specialized applications.



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



How-to basics
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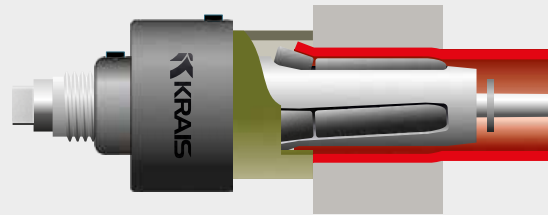
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RECOMMENDATION

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 1-1/2" (38,1 MM)		ROLL LENGTH 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	619	K-7	620	K-7A	0,511	0,570	12,98	14,48	F-8	M-6	TESMini 2, ES2	K50-600
0,560	14,22	621	K-8	622	K-8A	0,539	0,606	13,69	15,39	F-8	M-8	TESMini 2, ES2	K50-600
0,584	14,83	623	K-9	624	K-9A	0,562	0,629	14,27	15,98	F-9	M-8	TESMini 2, ES2	K50-600
0,606	15,39	625	K-10	626	K-10A	0,586	0,649	14,88	16,48	F-10	M-8	TESMini 2, ES2	K50-600
0,620	15,75	627	K-10	628	K-10A	0,594	0,677	15,09	17,20	F-10	M-9	TESMini 2, ES2	K50-600
0,634	16,10	629	K-11	630	K-11A	0,610	0,688	15,49	17,48	F-11	M-9	TESMini 2, ES2	K50-400
0,657	16,69	631	K-12	632	K-12A	0,633	0,712	16,08	18,08	F-12	M-9	TESMini 2, ES2	K50-400
0,670	17,02	641	K-13	642	K-13A	0,645	0,724	16,38	18,39	F-13	M-9	TESMini 2, ES2	K50-400
0,685	17,40	633	K-13	634	K-13A	0,661	0,740	16,79	18,80	F-13	M-10	TESMini 2, ES2	K50-400
0,709	18,01	635	K-14	636	K-14A	0,677	0,763	17,20	19,38	F-14	M-11	TESMini 2, ES2	K60-900
0,731	18,57	637	K-15	638	K-15A	0,700	0,791	17,78	20,09	F-15	M-11	TESMini 2, ES2	K60-900
0,745	18,92	639	K-15	640	K-15A	0,716	0,807	18,19	20,50	F-15	M-12	TESMini 2, ES2	K60-900
0,760	19,30	643	K-16	644	K-16A	0,732	0,818	18,59	20,78	F-16	M-12	TESMini 2, DU1	K60-900
0,782	19,86	645	K-17	646	K-17A	0,751	0,842	19,08	21,39	F-17	M-12	TESMini 2, DU1	K60-900
0,795	20,19	653	K-20	654	K-20A	0,767	0,866	19,48	22,00	F-20	M-13	TESMini 2, DU1	K60-900
0,810	20,57	647	K-18	648	K-18A	0,779	0,870	19,79	22,10	F-18	M-12	TESMini 2, DU1	K60-900
0,834	21,18	649	K-18	650	K-18A	0,799	0,897	20,29	22,78	F-18	M-13	TESMini 2, DU1	K60-900
0,856	21,74	651	K-19	652	K-19A	0,826	0,921	20,98	23,39	F-19	M-13	TESMini 2, DU1	K60-900
0,884	22,45	655	K-21	656	K-21A	0,854	0,948	21,69	24,08	F-21	M-13	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.