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*"World Class Quality"*

English

**OPERATING INSTRUCTIONS**

**"HYDRA-SWAGE" TUBE EXPANDING TOOL KIT**

**MODEL# 71600-A**



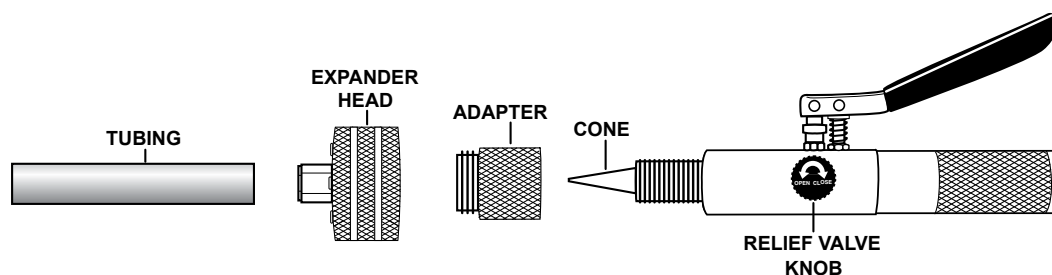
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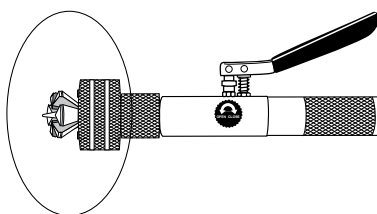
[info@valuetesters.com](mailto:info@valuetesters.com)



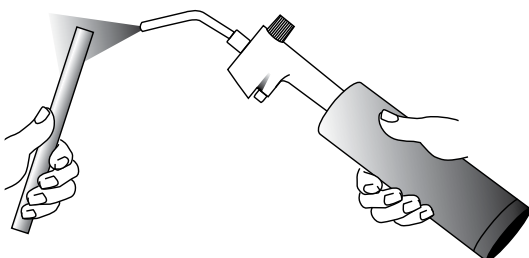
**Warning!**  
**Wear Safety Glasses**



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

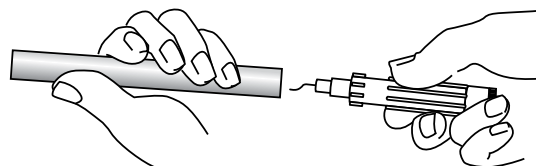


- 1) Use soft copper tube or heat (anneal) the section of hard copper tubing to be expanded.

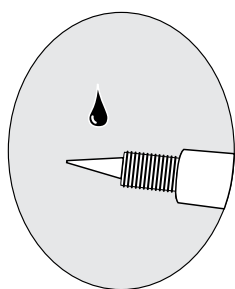


- 2) De-burr the inner walls of the tubing completely and make sure the tube will fit easily over the expander head.

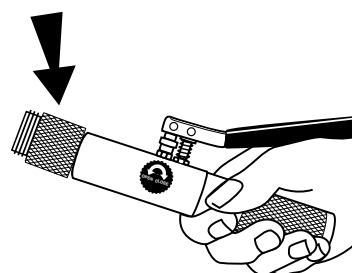
**DO NOT FORCE THE TUBE OVER THE EXPANDER HEAD!**



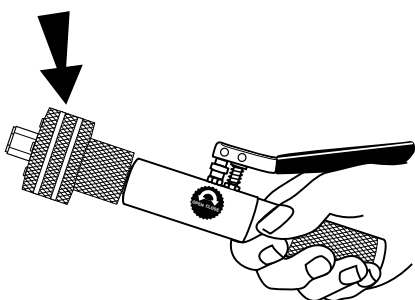
- 3) Apply lubricant (preferably grease) to the cone before using.



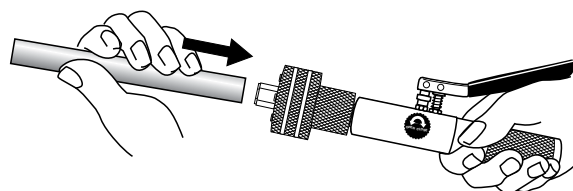
- 4) Screw the adapter onto the shaft of the pump all the way.



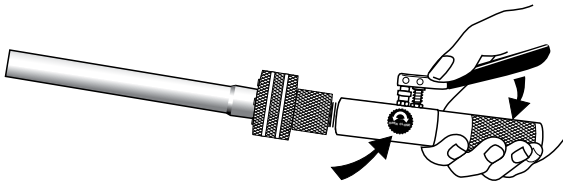
- 5) Screw the selected expander head onto the adapter.



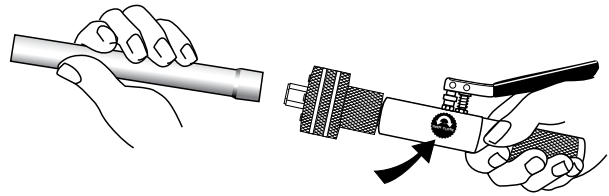
- 6) Place the tubing onto the expander head. Make sure that the expander head travels into the tube **FREELY**. **WARNING!! Do not force or twist the tube while you are placing the tube on the expander head.**



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.



| PARTS LIST     |                                                                                                                                   |           |
|----------------|-----------------------------------------------------------------------------------------------------------------------------------|-----------|
| PART#          | DESCRIPTION                                                                                                                       | TUBE O.D. |
| 71600-03       | Expander Head                                                                                                                     | 3/8"      |
| 71600-04       | Expander Head                                                                                                                     | 1/2"      |
| 71600-05       | Expander Head                                                                                                                     | 5/8"      |
| 71600-06       | Expander Head                                                                                                                     | 3/4"      |
| 71600-07       | Expander Head                                                                                                                     | 7/8"      |
| 71600-08       | Expander Head                                                                                                                     | 1"        |
| 71600-09       | Expander Head                                                                                                                     | 1 1/8"    |
| 71600-11       | Expander Head                                                                                                                     | 1 3/8"    |
| 71600-13       | Expander Head                                                                                                                     | 1 5/8"    |
| 71600-17       | Expander Head                                                                                                                     | 2 1/8"    |
| 71601-A        | Hydra-Swage                                                                                                                       |           |
| 71601-D        | Adapter for 71601                                                                                                                 |           |
| 71685          | Inner - Outer Reamer                                                                                                              |           |
| 71600-PB       | Molded Box for 71600 & 71650                                                                                                      |           |
| METRIC         |                                                                                                                                   |           |
| PART#          | DESCRIPTION                                                                                                                       | TUBE O.D. |
| 71600-10M      | Expander Head                                                                                                                     | 10mm      |
| 71600-12M      | Expander Head                                                                                                                     | 12mm      |
| 71600-15M      | Expander Head                                                                                                                     | 15mm      |
| 71600-16M      | Expander Head                                                                                                                     | 16mm      |
| 71600-18M      | Expander Head                                                                                                                     | 18mm      |
| 71600-22M      | Expander Head                                                                                                                     | 22mm      |
| 71600-28M      | Expander Head                                                                                                                     | 28mm      |
| ALSO AVAILABLE |                                                                                                                                   |           |
| 71680          | Hydraulic Flaring Accessory <ul style="list-style-type: none"> <li>• Make OEM flares with a simple pump of the handle.</li> </ul> |           |

**⚠ WARNING:** This product can expose you to chemicals including Di (2-ethylhexyl) phthalate, lead and lead compounds, which are known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to [www.P65Warnings.ca.gov](http://www.P65Warnings.ca.gov)