

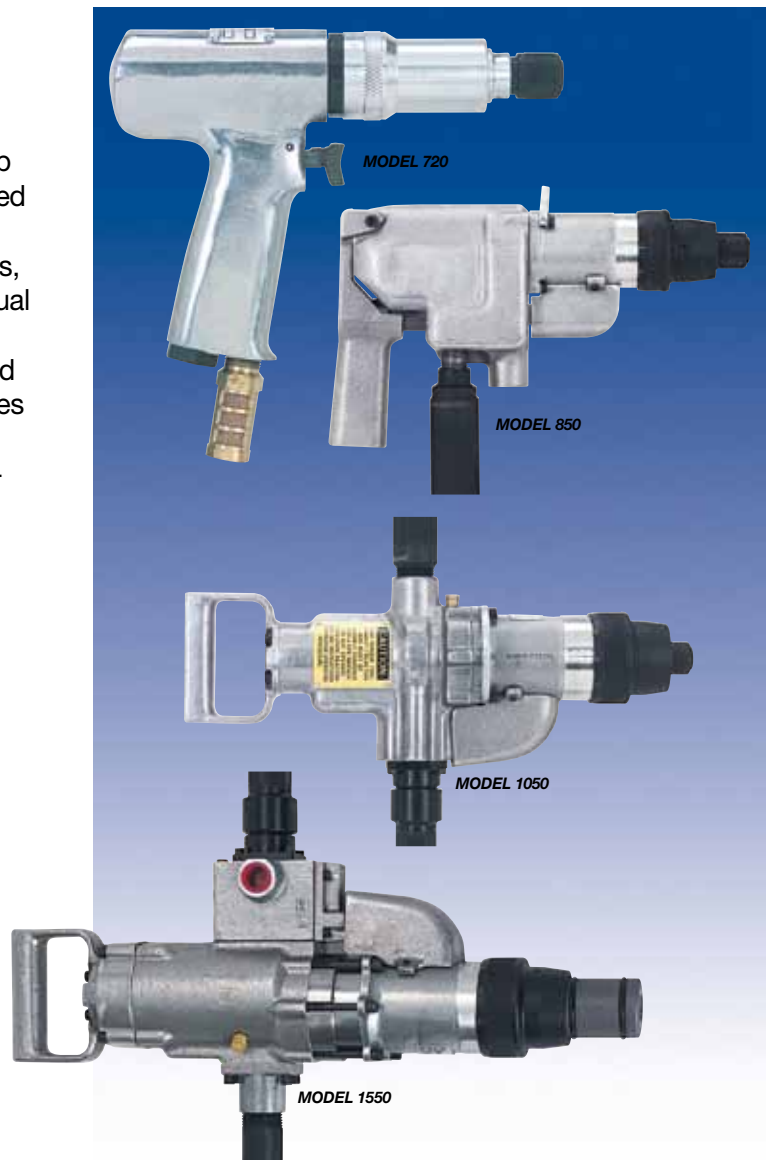
Tube Expansion Controls

Airetool®

Airetool Torque Controlled Rolling Motors

Airetrol Air Driven Motors

Airetool motors control expansion by accurate measurement of torque. They automatically stop expansion accurately according to predetermined setting. This prevents over- and under- expansion of tubes, assuring uniformly tight tube joints, providing maximum holding strength for individual tubes. Strong, lightweight aluminum housings provide easier handling and less fatigue. Rugged drive combines precision control which measures torque output. All AIRETROLS include torque sensing cams designed and manufactured specifically for tube expanding applications.



Model No.	Part No.	Speed & Torque 90 psig Air Pressure*						Overall Length		Weight		Side to Center		Operating Hose		CFM	Square Drive	Tube Capacities*		Chucks†	
		Free Speed RPM	Maximum Torque		Minimum Torque																
			In. lbs.	Nm	In. Lbs.	Nm	In.	mm	Lbs.	Kg	In.	mm	In.	mm	In.	mm	incl.	opt.			
720-2500B	8405541	2500	20	2.29	2	0.23	7-7/8"	198	2.4	1.09	13/16"	20.6	3/8"	7	17	1/4"	1/4"	6.3	1/4"QC	3/8"QC	
720-1800B‡	8405383	1800	27	3.05	2	0.23	7-7/8"	200	2.4	1.09	13/16"	20.6	3/8"	7	17	1/4"	3/8"	9.5	1/4"QC	3/8"QC	
720-550B	8405391	550	75	8.47	2	0.23	8-5/8"	219	2.7	1.23	13/16"	20.6	3/8"	7	17	3/8"	1/2"	12.7	3/8"QC	1/4"QC	
850-1250A	8405399	1066	126	14.2	9.6	1.08	12-1/4"	311	10.5	4.76	1-7/16"	36.5	1/2"	10	48	3/8"	3/4"	19	3/8"QC	1/2"QC	
850-600A	8405398	486	230	26	14.4	1.63	12-1/4"	311	10.5	4.76	1-7/16"	36.5	1/2"	10	48	3/8"	1"	25.4	3/8"QC	1/2"QC	

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		Free Speed RPM	Maximum Torque		Minimum Torque																
			Ft. lbs.	Nm	Ft. Lbs.	Nm	In.	mm	Lbs.	Kg	In.	mm	In.	mm	In.	mm	incl.	opt.			
1050-400	8404200	388	26.4	35.8	3.3	4.5	13-5/8"	346	14	6.35	1-15/16"	50	3/4"	13	68	1/2"	1-1/4"	31.7	3/8"QC	3/4-1"QC	
1550-900	8404290	756	30.7	41.6	4.7	6.4	18"	457	27	12.25	1-15/16"	50	3/4"	13	70	1/2"	1-1/2"	38.1	3/8-1/2"QC	3/4-1"QC	
1550-250	8404280	220	109.9	149	14.3	19.4	18"	457	27	12.25	1-15/16"	50	3/4"	13	56	3/4"	2-1/2"	63.5	3/4-1"	3/8-1/2"QC	

* Varies depending on tube material, gauge, and tube sheet thickness.
 ‡ Order 8405512 for 720-1800B with 3/8" Q.C. chuck.

† Ensures chuck matches mandrel or expander.

Airetool Electronic Controller & Rolling Motors

TEC-7000 Electronic Controller Specifications

Stock No: 941204

Microprocessor Controlled

- 16-bit processor
- Memory up to 3000 cycles
- Operating language, English / German

Quality Assurance

- Min / Max Value – Number of Expansion Cycles
- Statistics, shown on display or to serial printer port.

Time Programming

- Reverse and cycle pause, suppress time for low torque value settings. Cycle start timer.

Target Programming

- Shut off value and accepted High / Low value

Cycle mode

- Manual - Semi-Automatic - Full Automatic

Input 110 – 240 Volt, 1 ph

Output, max 1,7 kW

Foot switch for safe operation complete with emergency button

Model TEC 9000 FS

Stock No: 7940080



Model	Part Number	Speed	RPM	Capacity OD		Voltage	Power (Watt)		Chucks	
				Min.	Max.		Input	Output	Standard	Optional

Electric Rolling Motor Specifications

TEC 72636	94132	1	1400	1/4"	3/8"	230	300	180	1/4" QC	
TEC 7113	941315	2	450-1550	5/8"	1 1/4"	110	650	450	3/8" + 1/2" QC	
TEC 7213	941313	2	450-1550	5/8"	1 1/4"	230	650	450	3/8" + 1/2" QC	
TEC 7132	941203	4	110-190 350-590	3/4"	2 1/2"	110	1500	980	MC 3 x 1/2" QC	
TEC 7232	941202	4	110-190 350-590	3/4"	2 1/2"	230	1500	980	MC 3 x 3/8" QC	MC 3 x 1/2" Sq. MC 3 x 3/4" Sq.

The new Airetool DAS II Dominator has been designed to deliver power, performance, durability and unmatched productivity in pneumatic tube rolling technology.

- All pneumatic system for complete, self-contained tool holding system.
- No electrical power source required, eliminating typical problems such as fluctuating plant voltages and electrical interference from other equipment.
- Push-to-start motor runs only when needed, reducing noise, prolonging motor life and conserving shop air.
- Standard model features 5' vertical and horizontal reach.
- Small overall footprint w/4 casters for improved mobility.
- Larger integral lifting eye.
- Ergonomic design for operator comfort and ease of use.
- Smooth, fluid function design for unparalleled production.
- Tool holding system virtually eliminates operator error.
- Increases expander life by as much as three times compared to conventional hand-held equipment.
- Greatly enhances the accuracy of tube rolling reducing costly improperly rolled tubes.
- Right or left hand operation without conversion.
- Available with optional auto-lube & cycle counter.

For more information on the Airetool line visit our website at www.airetools.com.



Model Number	Part Number	Movement				Lift Capacity		Operating Pressure		Supply Hose	Allowable Torque	
		Vertical		Horizontal		Lbs.	Kg.	PSI	Bar		Ft.-Lbs.	Nm
		Ft.	mm	Ft.	mm							
Automatic Tube Rolling System Less DAS II Airetrol												
DAS II Dominator w/lube	5526140	5	1524	5	1524	55	25	90	6.2	3/4"	125	169
DAS II Dominator	5526081	5	1524	5	1524	55	25	90	6.2	3/4"	125	169
Basic Positioning Unit												
DAS II Dominator Basic Unit	5529158	5	1524	5	1524	55	25	90	6.2	3/4"	125	169

Model Number	Part Number	Free Speed	CFM	Max. Torque		Min. Torque		Chucks	
		R.P.M.		Ft. Lbs.	NM	Ft. Lbs.	NM	Included	Optional
DAS II Dominator Rolling Motors									
DAS II 850 1250 Airetrol with Lube,CTR	8405567	1250	50	10	13.6	1	1.4	3/8" QC	1/2" QC
DAS II 1550 900 Airetrol	8405563	825	75	32	43.4	4.5	6.1	3/8"-1/2" QC	3/4"-1"
DAS II 1550 900 Airetrol with Lube,CTR	8405565	825	75	32	43.4	4.5	6.1	3/8"-1/2" QC	3/4"-1"
DAS II 1550 250 Airetrol	8405564	225	75	110	149.1	15	20.3	3/4"-1"	3/8"-1/2" QC
DAS II 1550 250 Airetrol with Lube,CTR	8405568	225	75	110	149.1	15	20.3	3/4"-1"	3/8"-1/2" QC

Airetool Tube Process Controls

This system utilizes a microprocessor controlled expanding cycle with programmable expansion parameters. This includes torque, speed and expansion times for uniform bonding of the tube, to the tube sheet with accuracy and repeatability. Expansion modules are available for single or multiple spindle (independently controlled) tube expansion heads with fixed, or multiple pitch design.

The tooling is designed for robot or articulating tool-holding systems, resulting in ergonomic and virtually effortless productivity. The tube expander bracket combined with the automatic through-cage lubricant-injection system greatly extends the life of the tooling.

Expansion modules designed according to customer requirement & application.

Benefits:

- Fully programmable microprocessor expansion cycle
- Automatic expansion cycle
- Process documentation
- Multiple-expansion spindle unit (up to 16 independently operated and controlled cycles)
- Fixed or multiple-pitch adjustment
- Improves productivity up to 60%
- Reduces tooling cost



Apex Tool Group offers a wide variety of industrial power tools to meet the needs of the most demanding global markets. For more information on our complete tool offering, please contact your local Apex Tool Group representative or visit our website www.apextoolgroup.com.

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