

'A' Type

Ordering Instructions

To ascertain the correct tool number for your purposes, first establish the minimum bore which the tool enters (1st column of table below). Then select the appropriate Effective Parallel Rolling Length column, and read off at the Minimum Bore size line ... e.g.: for a tube with minimum bore size of 40mm and an effective parallel rolling length of 44mm (i.e.: 35mm seat thickness + 9mm over-roll) the tool number will read: A40/35.

Intermediate range tools are available to special order.



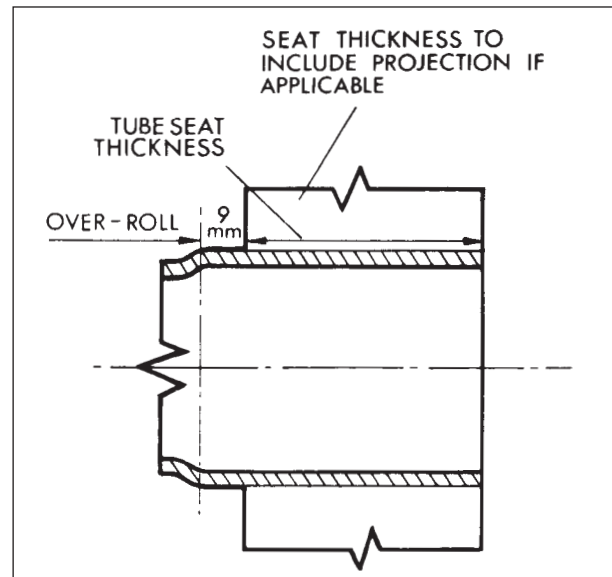
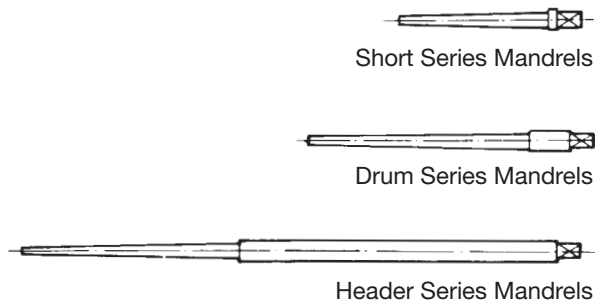
MIN BORE TOOL ENTERS		MAX EXPN OF TOOL		MIN HAND HOLE SIZE TOOL ENTERS		EFFECTIVE PARALLEL ROLLING LENGTH					
						29mm 1.142"	34mm 1.339"	39mm 1.535"	44mm 1.732"	49mm 1.929"	54mm 2.126"
mm	inch	mm	inch	mm	inch	TOOL NUMBER					
15	.591	17.5	.689	35	1.378	A15/20	A15/25	A15/30	A15/35	A15/40	A15/45
16	.630	18.9	.744	35	1.378	A16/20	A16/25	A16/30	A16/35	A16/40	A16/45
17	.669	20.3	.799	36	1.418	A17/20	A17/25	A17/30	A17/35	A17/40	A17/45
18	.709	21.5	.846	37	1.457	A18/20	A18/25	A18/30	A18/35	A18/40	A18/45
19	.748	22.1	.870	38	1.500	A19/20	A19/25	A19/30	A19/35	A19/40	A19/45
20	.787	23.5	.925	39	1.536	A20/20	A20/25	A20/30	A20/35	A20/40	A20/45
21	.827	24.7	.972	40	1.575	A21/20	A21/25	A21/30	A21/35	A21/40	A21/45
22	.866	26.5	1.043	42	1.654	A22/20	A22/25	A22/30	A22/35	A22/40	A22/45
23.5	.925	28.3	1.114	44	1.732	A23/20	A23/25	A23/30	A23/35	A23/40	A23/45
25	.984	29.8	1.173	45	1.772	A25/20	A25/25	A25/30	A25/35	A25/40	A25/45
27	1.063	31.8	1.252	47	1.850	A27/20	A27/25	A27/30	A27/35	A27/40	A27/45
29	1.142	33.8	1.331	49	1.929	A29/20	A29/25	A29/30	A29/35	A29/40	A29/45
31	1.220	36.5	1.437	52	2.047	A31/20	A31/25	A31/30	A31/35	A31/40	A31/45
33	1.300	38.5	1.516	54	2.126	A33/20	A33/25	A33/30	A33/35	A33/40	A33/45
35	1.378	42.5	1.673	58	2.284	A35/20	A35/25	A35/30	A35/35	A35/40	A35/45
37	1.457	43.3	1.704	60	2.363	A37/20	A37/25	A37/30	A37/35	A37/40	A37/45
40	1.575	47.7	1.877	64	2.520	A40/20	A40/25	A40/30	A40/35	A40/40	A40/45
43	1.693	51.9	2.043	68	2.678	A43/20	A43/25	A43/30	A43/35	A43/40	A43/45
46	1.811	54.9	2.161	72	2.835	A46/20	A46/25	A46/30	A46/35	A46/40	A46/45
49	1.930	57.9	2.279	74	2.914	A49/20	A49/25	A49/30	A49/35	A49/40	A49/45
52	2.047	60.9	2.397	78	3.071	A52/20	A52/25	A52/30	A52/35	A52/40	A52/45
56	2.205	63.9	2.515	80	3.150	A56/20	A56/25	A56/30	A56/35	A56/40	A56/45
60	2.362	68.9	2.712	85	3.347	A60/20	A60/25	A60/30	A60/35	A60/40	A60/45
64	2.520	72.9	2.870	89	3.504	A64/20	A64/25	A64/30	A64/35	A64/40	A64/45
68	2.678	76.3	3.003	92	3.622	A68/20	A68/25	A68/30	A68/35	A68/40	A68/45
72	2.835	80.3	3.161	96	3.780	A72/20	A72/25	A72/30	A72/35	A72/40	A72/45
76	2.992	84.5	3.326	103	4.056	A76/20	A76/25	A76/30	A76/35	A76/40	A76/45
80	3.149	88.5	3.484	106	4.174	A80/20	A80/25	A80/30	A80/35	A80/40	A80/45
84	3.307	92.5	3.641	110	4.331	A84/20	A84/25	A84/30	A84/35	A84/40	A84/45
88	3.465	96.5	3.800	118	4.489	A88/20	A88/25	A88/30	A88/35	A88/40	A88/45
92	3.622	100.5	3.956	118	4.646	A92/20	A92/25	A92/30	A92/35	A92/40	A92/45
96	3.780	104.5	4.114	122	4.803	A96/20	A96/25	A96/30	A96/35	A96/40	A96/45
100	3.937	108.5	4.271	125	4.922	A100/20	A100/25	A100/30	A100/35	A100/40	A100/45

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'A' Type

(continued)



Drum mandrels will be supplied unless header or short series mandrels are ordered.

MIN BORE TOOL ENTERS		Effective parallel rolling length			Mandrel Size ■	DRUM MANDREL	HEADER MANDREL	SHORT MANDREL	EXTRA SHORT MANDREL
		59mm 2.322"	69mm 2.716"	79mm 3.110"					
mm	inch	TOOL NUMBER			inch				
15	.591				3/8	DA1	HA1	SA1/2	ESA1/2/3
16	.630					225mm lg	450mm lg	145mm lg	125mm lg
17	.669					8.858" lg	17.717" lg	5.709" lg	4.921" lg
18	.709								
19	.748				3/8	DA2	HA2	SA3/4	ESA4/5/6
20	.787					255mm lg	450mm lg	160mm lg	135mm lg
21	.827					10.039" lg	17.717" lg	6.299" lg	5.315" lg
22	.866								
23.5	.925				1/2	DA3	HA3	SA5/6	ESA7/8/9
25	.984					255mm lg	450mm lg	160mm lg	135mm lg
27	1.063					10.039" lg	17.717" lg	6.299" lg	5.315" lg
29	1.142								
31	1.220				3/4	DA4	HA4	SA7/8	ESA10/11/12
33	1.300					350mm lg	500mm lg	214mm lg	174mm lg
35	1.378					13.780" lg	19.685" lg	8.425" lg	6.850" lg
37	1.457	A37/50	A37/60	A37/70	3/4	DA5	HA5	SA9/10	ESA13/14/15
40	1.575	A40/50	A40/60	A40/70		355mm lg	550mm lg	225mm lg	185mm lg
43	1.693	A43/50	A43/60	A43/70		13.976" lg	21.654" lg	8.858" lg	7.284" lg
46	1.811	A46/50	A46/60	A46/70					
49	1.930	A49/50	A49/60	A49/70	3/4	DA6	HA6	SA11/12	ESA16/17/18
52	2.047	A52/50	A52/60	A52/70		355mm lg	550mm lg	225mm lg	185mm lg
56	2.205	A56/50	A56/60	A56/70		13.976" lg	21.654" lg	8.858" lg	7.284" lg
60	2.362	A60/50	A60/60	A60/70					
64	2.520	A64/50	A64/60	A64/70	1	DA7	HA7	SA13/14	ESA19/20/21
68	2.678	A68/50	A68/60	A68/70		355mm lg	550mm lg	225mm lg	185mm lg
72	2.835	A72/50	A72/60	A72/70		13.976" lg	21.654" lg	8.858" lg	7.284" lg
76	2.992	A76/50	A76/60	A76/70					
80	3.149	A80/50	A80/60	A80/70	1	DA8	HA8	SA15/16	ESA22/23/24
84	3.307	A84/50	A84/60	A84/70		355mm lg	550mm lg	225mm lg	185mm lg
88	3.465	A88/50	A88/60	A88/70		13.976" lg	21.654" lg	8.858" lg	7.284" lg
92	3.622	A92/50	A92/60	A92/70					
96	3.780	A96/50	A96/60	A96/70					
100	3.937	A100/50	A100/60	A100/70					

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