# KS

## Självmatande panntubsexpandrar för invalsning och kragning

Tubområde: ytterdiameter 25,4-101,6 mm.
Tre expansionsvalsar och tre kragningsvalsar expanderar och kragar tuben samtidigt.
För omvalsning av läckande tuber och nytillverkning av vattenrörspannor, eldrörspannor, ekonomisrar och luftförvärmare.



Sex expansionsvalsar och tre kragningsvalsar finns på förfrågan. Vinkelställda valsmotorer i K70-serien rekommenderas.

## Dimensionstabell - del 1

| Verktyg | Ytter-Ø | BWG | Expansion | Valssats | Vals-längd | Dorn | Dorn-längd | Kort sats (3 st) | Kort längd | Driv-fyrkant |
|---|---|---|---|---|---|---|---|---|---|---|
| KS-1942 | 25,40 | 9-11 | 19-22 | RR12RK5/42 | 42 | TK19 | 195 | - | - | 12,7 |
| KS-2042 | 25,40 | 13-14 | 20-23 | RR12RK5/42 | 42 | TK20 | 195 | - | - | 12,7 |
| KS-2242 | 31,75 | 7 | 22-25 | RR12RK5/42 | 42 | TK22 | 195 | - | - | 12,7 |
| KS-2342 | 31,75 | 9 | 23-26 | RR13RK6/42 | 42 | TK23 | 195 | - | - | 12,7 |
| KS-2442 | 31,75 | 10 | 24-27 | RR13RK6/42 | 42 | TK24 | 195 | - | - | 12,7 |
| KS-2542 | 31,75 | 11-13 | 25-28 | RR13RK6/42 | 42 | TK25 | 195 | - | - | 12,7 |
| KS-2642 | 31,75 | 12-14 | 26-29 | RR13RK6/42 | 42 | TK26 | 195 | - | - | 12,7 |
| KS-2742 | 31,75 | 14-15 | 27-30 | RR15RK0/42 | 42 | TK27 | 200 | - | - | 12,7 |
| KS-2842 | 31,75 | 16 | 28-32 | RR16RK8/42 | 42 | TK28 | 260 | TKK28 | 175 | 19,05 |
| KS-2850 | 31,75 | 16 | 28-32 | RR16RK8/50 | 50 | TK28 | 260 | TKK28 | 175 | 19,05 |
| KS-2860 | 31,75 | 16 | 28-32 | RR16RK8/60 | 60 | TK28 | 260 | TKK28 | 175 | 19,05 |
| KS-2880 | 31,75 | 16 | 28-32 | RR16RK8/80 | 80 | TK28 | 260 | TKK28 | 175 | 19,05 |
| KS-2942 | 38,10 | 7-10 | 29-33 | RR16RK8/42 | 42 | TK29 | 260 | TKK29 | 175 | 19,05 |
| KS-2950 | 38,10 | 7-10 | 29-33 | RR16RK8/50 | 50 | TK29 | 260 | TKK29 | 175 | 19,05 |
| KS-2960 | 38,10 | 7-10 | 29-33 | RR16RK8/60 | 60 | TK29 | 260 | TKK29 | 175 | 19,05 |
| KS-2980 | 38,10 | 7-10 | 29-33 | RR16RK8/80 | 80 | TK29 | 260 | TKK29 | 175 | 19,05 |
| KS-3042 | 38,10 | 10-12 | 30-34 | RR16RK8/42 | 42 | TK30 | 260 | TKK30 | 175 | 19,05 |
| KS-3050 | 38,10 | 10-12 | 30-34 | RR16RK8/50 | 50 | TK30 | 260 | TKK30 | 175 | 19,05 |
| KS-3060 | 38,10 | 10-12 | 30-34 | RR16RK8/60 | 60 | TK30 | 260 | TKK30 | 175 | 19,05 |
| KS-3080 | 38,10 | 10-12 | 30-34 | RR16RK8/80 | 80 | TK30 | 260 | TKK30 | 175 | 19,05 |

Alla mått anges i mm. BWG är en godskod, inte ett mått. Korta dornsatser består av 3 delar.

# KS

## Dimensionstabell - del 2

| Verktyg | Ytter-Ø | BWG | Expansion | Valssats | Vals-längd | Dorn | Dorn-längd | Kort sats (3 st) | Kort längd | Driv-fyrkant |
|---|---|---|---|---|---|---|---|---|---|---|
| KS-3242 | 38,10 | 12-14 | 32-36 | RR17RK9/42 | 42 | TK32 | 260 | TKK32 | 175 | 19,05 |
| KS-3250 | 38,10 | 12-14 | 32-36 | RR17RK9/50 | 50 | TK32 | 260 | TKK32 | 175 | 19,05 |
| KS-3260 | 38,10 | 12-14 | 32-36 | RR17RK9/60 | 60 | TK32 | 260 | TKK32 | 175 | 19,05 |
| KS-3280 | 38,10 | 12-14 | 32-36 | RR17RK9/80 | 80 | TK32 | 260 | TKK32 | 175 | 19,05 |
| KS-3342 | 38,10 | 13-20 | 33-38 | RP33RR33/42 | 42 | TK33 | 290 | TKK33 | 181 | 19,05 |
| KS-3350 | 38,10 | 13-20 | 33-38 | RP33RR33/50 | 50 | TK33 | 290 | TKK33 | 181 | 19,05 |
| KS-3360 | 38,10 | 13-20 | 33-38 | RP33RR33/60 | 60 | TK33 | 290 | TKK33 | 181 | 19,05 |
| KS-3380 | 38,10 | 13-20 | 33-38 | RP33RR33/80 | 80 | TK33 | 290 | TKK33 | 181 | 19,05 |
| KS-3542 | 44,45 | 8-9 | 35-41 | RR21RK35/42 | 42 | TK37 | 310 | TKK37 | 188 | 19,05 |
| KS-3550 | 44,45 | 8-9 | 35-41 | RR21RK35/50 | 50 | TK37 | 310 | TKK37 | 188 | 19,05 |
| KS-3560 | 44,45 | 8-9 | 35-41 | RR21RK35/60 | 60 | TK37 | 310 | TKK37 | 188 | 19,05 |
| KS-3580 | 44,45 | 8-9 | 35-41 | RR21RK35/80 | 80 | TK37 | 310 | TKK37 | 188 | 19,05 |
| KS-3742 | 44,45 | 10-12 | 37-43 | RR22RK10/42 | 42 | TK37 | 310 | TKK37 | 188 | 19,05 |
| KS-3750 | 44,45 | 10-12 | 37-43 | RR22RK10/50 | 50 | TK37 | 310 | TKK37 | 188 | 19,05 |
| KS-3760 | 44,45 | 10-12 | 37-43 | RR22RK10/60 | 60 | TK37 | 310 | TKK37 | 188 | 19,05 |
| KS-3780 | 44,45 | 10-12 | 37-43 | RR22RK10/80 | 80 | TK37 | 310 | TKK37 | 188 | 19,05 |
| KS-3942 | 44,45 | 12-18 | 39-45 | RR40RK40/42 | 42 | TK37 | 310 | TKK37 | 188 | 19,05 |
| KS-3950 | 44,45 | 12-18 | 39-45 | RR40RK40/50 | 50 | TK37 | 310 | TKK37 | 188 | 19,05 |
| KS-3960 | 44,45 | 12-18 | 39-45 | RR40RK40/60 | 60 | TK37 | 310 | TKK37 | 188 | 19,05 |
| KS-3980 | 44,45 | 12-18 | 39-45 | RR40RK40/80 | 80 | TK37 | 310 | TKK37 | 188 | 19,05 |
| KS-4040 | 50,80 | 7-9 | 40-46 | RR40RK40/40 | 40 | TK42 | 310 | TKK42 | 205 | 19,05 |
| KS-4050 | 50,80 | 7-9 | 40-46 | RR40RK40/50 | 50 | TK42 | 310 | TKK42 | 205 | 19,05 |
| KS-4060 | 50,80 | 7-9 | 40-46 | RR40RK40/60 | 60 | TK42 | 310 | TKK42 | 205 | 19,05 |
| KS-4080 | 50,80 | 7-9 | 40-46 | RR40RK40/80 | 80 | TK42 | 310 | TKK42 | 205 | 19,05 |
| KS-4240 | 50,80 | 10-13 | 42-48 | RR23RK11/40 | 40 | TK42 | 310 | TKK42 | 205 | 19,05 |
| KS-4250 | 50,80 | 10-13 | 42-48 | RR23RK11/50 | 50 | TK42 | 310 | TKK42 | 205 | 19,05 |
| KS-4260 | 50,80 | 10-13 | 42-48 | RR23RK11/60 | 60 | TK42 | 310 | TKK42 | 205 | 19,05 |
| KS-4280 | 50,80 | 10-13 | 42-48 | RR23RK11/80 | 80 | TK42 | 310 | TKK42 | 205 | 19,05 |

Alla mått anges i mm. BWG är en godskod, inte ett mått. Korta dornsatser består av 3 delar.

# KS

## Dimensionstabell - del 3

| Verktyg | Ytter-Ø | BWG | Expansion | Valssats | Vals-längd | Dorn | Dorn-längd | Kort sats (3 st) | Kort längd | Driv-fyrkant |
|---|---|---|---|---|---|---|---|---|---|---|
| KS-4440 | 50,80 | 12-14 | 44-50 | RR23RK11/40 | 40 | TK44 | 310 | TKK44 | 205 | 19,05 |
| KS-4450 | 50,80 | 12-14 | 44-50 | RR23RK11/50 | 50 | TK44 | 310 | TKK44 | 205 | 19,05 |
| KS-4460 | 50,80 | 12-14 | 44-50 | RR23RK11/60 | 60 | TK44 | 310 | TKK44 | 205 | 19,05 |
| KS-4480 | 50,80 | 12-14 | 44-50 | RR23RK11/80 | 80 | TK44 | 310 | TKK44 | 205 | 19,05 |
| KS-4740 | 50,80 | 15-16 | 47-54 | RR24RK12/40 | 40 | TK47 | 338 | TKK47 | 218 | 19,05 |
| KS-4750 | 50,80 | 15-16 | 47-54 | RR24RK12/50 | 50 | TK47 | 338 | TKK47 | 218 | 19,05 |
| KS-4760 | 50,80 | 15-16 | 47-54 | RR24RK12/60 | 60 | TK47 | 338 | TKK47 | 218 | 19,05 |
| KS-4780 | 50,80 | 15-16 | 47-54 | RR24RK12/80 | 80 | TK47 | 338 | TKK47 | 218 | 19,05 |
| KS-4940 | 57,15 | 10-13 | 49-56 | RR24RK12/40 | 40 | TK49 | 338 | TKK49 | 218 | 19,05 |
| KS-4950 | 57,15 | 10-13 | 49-56 | RR24RK12/50 | 50 | TK49 | 338 | TKK49 | 218 | 19,05 |
| KS-4960 | 57,15 | 10-13 | 49-56 | RR24RK12/60 | 60 | TK49 | 338 | TKK49 | 218 | 19,05 |
| KS-4980 | 57,15 | 10-13 | 49-56 | RR24RK12/80 | 80 | TK49 | 338 | TKK49 | 218 | 19,05 |
| KS-5240 | 57,15 | 14-16 | 52-59 | RR25RK13/40 | 40 | TK49 | 338 | TKK49 | 218 | 19,05 |
| KS-5250 | 57,15 | 14-16 | 52-59 | RR25RK13/50 | 50 | TK49 | 338 | TKK49 | 218 | 19,05 |
| KS-5260 | 57,15 | 14-16 | 52-59 | RR25RK13/60 | 60 | TK49 | 338 | TKK49 | 218 | 19,05 |
| KS-5280 | 57,15 | 14-16 | 52-59 | RR25RK13/80 | 80 | TK49 | 338 | TKK49 | 218 | 19,05 |
| KS-5440 | 63,50 | 8-13 | 54-62 | RR26RK14/40 | 40 | TK54 | 375 | TKK54 | 230 | 19,05 |
| KS-5450 | 63,50 | 8-13 | 54-62 | RR26RK14/50 | 50 | TK54 | 375 | TKK54 | 230 | 19,05 |
| KS-5460 | 63,50 | 8-13 | 54-62 | RR26RK14/60 | 60 | TK54 | 375 | TKK54 | 230 | 19,05 |
| KS-5480 | 63,50 | 8-13 | 54-62 | RR26RK14/80 | 80 | TK54 | 375 | TKK54 | 230 | 19,05 |
| KS-5740 | 63,50 | 12-16 | 57-66 | RR27RK15/40 | 40 | TK57 | 395 | TKK57 | 235 | 19,05 |
| KS-5750 | 63,50 | 12-16 | 57-66 | RR27RK15/50 | 50 | TK57 | 395 | TKK57 | 235 | 19,05 |
| KS-5760 | 63,50 | 12-16 | 57-66 | RR27RK15/60 | 60 | TK57 | 395 | TKK57 | 235 | 19,05 |
| KS-5780 | 63,50 | 12-16 | 57-66 | RR27RK15/80 | 80 | TK57 | 395 | TKK57 | 235 | 19,05 |
| KS-6040 | 69,85 | 7-11 | 60-69 | RR28RK16/40 | 40 | TK57 | 395 | TKK57 | 235 | 19,05 |
| KS-6050 | 69,85 | 7-11 | 60-69 | RR28RK16/50 | 50 | TK57 | 395 | TKK57 | 235 | 19,05 |
| KS-6060 | 69,85 | 7-11 | 60-69 | RR28RK16/60 | 60 | TK57 | 395 | TKK57 | 235 | 19,05 |
| KS-6080 | 69,85 | 7-11 | 60-69 | RR28RK16/80 | 80 | TK57 | 395 | TKK57 | 235 | 19,05 |
| KS-6540 | 76,20 | 7-8 | 65-74 | RR29RK17/40 | 40 | TK65 | 395 | TKK65 | 235 | 19,05 |
| KS-6550 | 76,20 | 7-8 | 65-74 | RR29RK17/50 | 50 | TK65 | 395 | TKK65 | 235 | 19,05 |
| KS-6560 | 76,20 | 7-8 | 65-74 | RR29RK17/60 | 60 | TK65 | 395 | TKK65 | 235 | 19,05 |
| KS-6580 | 76,20 | 7-8 | 65-74 | RR29RK17/80 | 80 | TK65 | 395 | TKK65 | 235 | 19,05 |

Alla mått anges i mm. BWG är en godskod, inte ett mått. Korta dornsatser består av 3 delar.

# KS

## Dimensionstabell - del 4

| Verktyg | Ytter-Ø | BWG | Expansion | Valssats | Vals-längd | Dorn | Dorn-längd | Kort sats (3 st) | Kort längd | Driv-fyrkant |
|---|---|---|---|---|---|---|---|---|---|---|
| KS-6840 | 76,20 | 10-14 | 68-77 | RR30RK18/40 | 40 | TK72 | 403 | TKK72 | 255 | 25,4 |
| KS-6850 | 76,20 | 10-14 | 68-77 | RR30RK18/50 | 50 | TK72 | 403 | TKK72 | 255 | 25,4 |
| KS-6860 | 76,20 | 10-14 | 68-77 | RR30RK18/60 | 60 | TK72 | 403 | TKK72 | 255 | 25,4 |
| KS-6880 | 76,20 | 10-14 | 68-77 | RR30RK18/80 | 80 | TK72 | 403 | TKK72 | 255 | 25,4 |
| KS-7240 | 82,55 | 7-11 | 72-81 | RR31RK19/40 | 40 | TK72 | 403 | TKK72 | 255 | 25,4 |
| KS-7250 | 82,55 | 7-11 | 72-81 | RR31RK19/50 | 50 | TK72 | 403 | TKK72 | 255 | 25,4 |
| KS-7260 | 82,55 | 7-11 | 72-81 | RR31RK19/60 | 60 | TK72 | 403 | TKK72 | 255 | 25,4 |
| KS-7280 | 82,55 | 7-11 | 72-81 | RR31RK19/80 | 80 | TK72 | 403 | TKK72 | 255 | 25,4 |
| KS-7740 | 82,55 | 15-16 | 77-87 | RR32RK20/40 | 40 | TK77 | 422 | TKK77 | 255 | 25,4 |
| KS-7750 | 82,55 | 15-16 | 77-87 | RR32RK20/50 | 50 | TK77 | 422 | TKK77 | 255 | 25,4 |
| KS-7760 | 82,55 | 15-16 | 77-87 | RR32RK20/60 | 60 | TK77 | 422 | TKK77 | 255 | 25,4 |
| KS-7780 | 82,55 | 15-16 | 77-87 | RR32RK20/80 | 80 | TK77 | 422 | TKK77 | 255 | 25,4 |
| KS-8240 | 88,90 | 10-13 | 82-92 | RR33RK21/40 | 40 | TK82 | 422 | TKK82 | 255 | 25,4 |
| KS-8250 | 88,90 | 10-13 | 82-92 | RR33RK21/50 | 50 | TK82 | 422 | TKK82 | 255 | 25,4 |
| KS-8260 | 88,90 | 10-13 | 82-92 | RR33RK21/60 | 60 | TK82 | 422 | TKK82 | 255 | 25,4 |
| KS-8280 | 88,90 | 10-13 | 82-92 | RR33RK21/80 | 80 | TK82 | 422 | TKK82 | 255 | 25,4 |
| KS-8640 | 95,25 | 8-12 | 86-96 | RR34RK22/40 | 40 | TK86 | 422 | TKK86 | 255 | 25,4 |
| KS-8650 | 95,25 | 8-12 | 86-96 | RR34RK22/50 | 50 | TK86 | 422 | TKK86 | 255 | 25,4 |
| KS-8660 | 95,25 | 8-12 | 86-96 | RR34RK22/60 | 60 | TK86 | 422 | TKK86 | 255 | 25,4 |
| KS-8680 | 95,25 | 8-12 | 86-96 | RR34RK22/80 | 80 | TK86 | 422 | TKK86 | 255 | 25,4 |
| KS-9040 | 101,60 | 9-12 | 90-100 | RR34RK22/40 | 40 | TK90 | 422 | TKK90 | 275 | 25,4 |
| KS-9050 | 101,60 | 9-12 | 90-100 | RR34RK22/50 | 50 | TK90 | 422 | TKK90 | 275 | 25,4 |
| KS-9060 | 101,60 | 9-12 | 90-100 | RR34RK22/60 | 60 | TK90 | 422 | TKK90 | 275 | 25,4 |
| KS-9080 | 101,60 | 9-12 | 90-100 | RR34RK22/80 | 80 | TK90 | 422 | TKK90 | 275 | 25,4 |
| KS-9640 | 101,60 | 16 | 96-106 | RR35RK23/40 | 40 | TK96 | 422 | TKK96 | 275 | 25,4 |
| KS-9650 | 101,60 | 16 | 96-106 | RR35RK23/50 | 50 | TK96 | 422 | TKK96 | 275 | 25,4 |
| KS-9660 | 101,60 | 16 | 96-106 | RR35RK23/60 | 60 | TK96 | 422 | TKK96 | 275 | 25,4 |
| KS-9680 | 101,60 | 16 | 96-106 | RR35RK23/80 | 80 | TK96 | 422 | TKK96 | 275 | 25,4 |

Alla mått anges i mm. BWG är en godskod, inte ett mått. Korta dornsatser består av 3 delar.

# KS

## Self-feeding expanding and flaring boiler tube tools

Tube outside diameter 25.4-101.6 mm.
Three expansion rolls and three flare rolls expand and flare the tube simultaneously.
For re-rolling leaking tubes and manufacturing water-tube and fire-tube boilers, economisers and air preheaters.



Six expansion rolls with three flare rolls are available on request. K70-series angle rolling motors are recommended.

## Selection table - part 1

| Tool no. | Tube OD | BWG | Expansion | Roll set | Roll len. | Mandrel | Mandrel length | Short set (3 pcs) | Short length | Drive square |
|---|---|---|---|---|---|---|---|---|---|---|
| KS-1942 | 25.40 | 9-11 | 19-22 | RR12RK5/42 | 42 | TK19 | 195 | - | - | 12.7 |
| KS-2042 | 25.40 | 13-14 | 20-23 | RR12RK5/42 | 42 | TK20 | 195 | - | - | 12.7 |
| KS-2242 | 31.75 | 7 | 22-25 | RR12RK5/42 | 42 | TK22 | 195 | - | - | 12.7 |
| KS-2342 | 31.75 | 9 | 23-26 | RR13RK6/42 | 42 | TK23 | 195 | - | - | 12.7 |
| KS-2442 | 31.75 | 10 | 24-27 | RR13RK6/42 | 42 | TK24 | 195 | - | - | 12.7 |
| KS-2542 | 31.75 | 11-13 | 25-28 | RR13RK6/42 | 42 | TK25 | 195 | - | - | 12.7 |
| KS-2642 | 31.75 | 12-14 | 26-29 | RR13RK6/42 | 42 | TK26 | 195 | - | - | 12.7 |
| KS-2742 | 31.75 | 14-15 | 27-30 | RR15RK0/42 | 42 | TK27 | 200 | - | - | 12.7 |
| KS-2842 | 31.75 | 16 | 28-32 | RR16RK8/42 | 42 | TK28 | 260 | TKK28 | 175 | 19.05 |
| KS-2850 | 31.75 | 16 | 28-32 | RR16RK8/50 | 50 | TK28 | 260 | TKK28 | 175 | 19.05 |
| KS-2860 | 31.75 | 16 | 28-32 | RR16RK8/60 | 60 | TK28 | 260 | TKK28 | 175 | 19.05 |
| KS-2880 | 31.75 | 16 | 28-32 | RR16RK8/80 | 80 | TK28 | 260 | TKK28 | 175 | 19.05 |
| KS-2942 | 38.10 | 7-10 | 29-33 | RR16RK8/42 | 42 | TK29 | 260 | TKK29 | 175 | 19.05 |
| KS-2950 | 38.10 | 7-10 | 29-33 | RR16RK8/50 | 50 | TK29 | 260 | TKK29 | 175 | 19.05 |
| KS-2960 | 38.10 | 7-10 | 29-33 | RR16RK8/60 | 60 | TK29 | 260 | TKK29 | 175 | 19.05 |
| KS-2980 | 38.10 | 7-10 | 29-33 | RR16RK8/80 | 80 | TK29 | 260 | TKK29 | 175 | 19.05 |
| KS-3042 | 38.10 | 10-12 | 30-34 | RR16RK8/42 | 42 | TK30 | 260 | TKK30 | 175 | 19.05 |
| KS-3050 | 38.10 | 10-12 | 30-34 | RR16RK8/50 | 50 | TK30 | 260 | TKK30 | 175 | 19.05 |
| KS-3060 | 38.10 | 10-12 | 30-34 | RR16RK8/60 | 60 | TK30 | 260 | TKK30 | 175 | 19.05 |
| KS-3080 | 38.10 | 10-12 | 30-34 | RR16RK8/80 | 80 | TK30 | 260 | TKK30 | 175 | 19.05 |

All dimensions are in mm. BWG is a gauge code, not a dimension. Short mandrel sets contain 3 pieces.

# KS

## Selection table - part 2

| Tool no. | Tube OD | BWG | Expansion | Roll set | Roll len. | Mandrel | Mandrel length | Short set (3 pcs) | Short length | Drive square |
|---|---|---|---|---|---|---|---|---|---|---|
| KS-3242 | 38.10 | 12-14 | 32-36 | RR17RK9/42 | 42 | TK32 | 260 | TKK32 | 175 | 19.05 |
| KS-3250 | 38.10 | 12-14 | 32-36 | RR17RK9/50 | 50 | TK32 | 260 | TKK32 | 175 | 19.05 |
| KS-3260 | 38.10 | 12-14 | 32-36 | RR17RK9/60 | 60 | TK32 | 260 | TKK32 | 175 | 19.05 |
| KS-3280 | 38.10 | 12-14 | 32-36 | RR17RK9/80 | 80 | TK32 | 260 | TKK32 | 175 | 19.05 |
| KS-3342 | 38.10 | 13-20 | 33-38 | RP33RR33/42 | 42 | TK33 | 290 | TKK33 | 181 | 19.05 |
| KS-3350 | 38.10 | 13-20 | 33-38 | RP33RR33/50 | 50 | TK33 | 290 | TKK33 | 181 | 19.05 |
| KS-3360 | 38.10 | 13-20 | 33-38 | RP33RR33/60 | 60 | TK33 | 290 | TKK33 | 181 | 19.05 |
| KS-3380 | 38.10 | 13-20 | 33-38 | RP33RR33/80 | 80 | TK33 | 290 | TKK33 | 181 | 19.05 |
| KS-3542 | 44.45 | 8-9 | 35-41 | RR21RK35/42 | 42 | TK37 | 310 | TKK37 | 188 | 19.05 |
| KS-3550 | 44.45 | 8-9 | 35-41 | RR21RK35/50 | 50 | TK37 | 310 | TKK37 | 188 | 19.05 |
| KS-3560 | 44.45 | 8-9 | 35-41 | RR21RK35/60 | 60 | TK37 | 310 | TKK37 | 188 | 19.05 |
| KS-3580 | 44.45 | 8-9 | 35-41 | RR21RK35/80 | 80 | TK37 | 310 | TKK37 | 188 | 19.05 |
| KS-3742 | 44.45 | 10-12 | 37-43 | RR22RK10/42 | 42 | TK37 | 310 | TKK37 | 188 | 19.05 |
| KS-3750 | 44.45 | 10-12 | 37-43 | RR22RK10/50 | 50 | TK37 | 310 | TKK37 | 188 | 19.05 |
| KS-3760 | 44.45 | 10-12 | 37-43 | RR22RK10/60 | 60 | TK37 | 310 | TKK37 | 188 | 19.05 |
| KS-3780 | 44.45 | 10-12 | 37-43 | RR22RK10/80 | 80 | TK37 | 310 | TKK37 | 188 | 19.05 |
| KS-3942 | 44.45 | 12-18 | 39-45 | RR40RK40/42 | 42 | TK37 | 310 | TKK37 | 188 | 19.05 |
| KS-3950 | 44.45 | 12-18 | 39-45 | RR40RK40/50 | 50 | TK37 | 310 | TKK37 | 188 | 19.05 |
| KS-3960 | 44.45 | 12-18 | 39-45 | RR40RK40/60 | 60 | TK37 | 310 | TKK37 | 188 | 19.05 |
| KS-3980 | 44.45 | 12-18 | 39-45 | RR40RK40/80 | 80 | TK37 | 310 | TKK37 | 188 | 19.05 |
| KS-4040 | 50.80 | 7-9 | 40-46 | RR40RK40/40 | 40 | TK42 | 310 | TKK42 | 205 | 19.05 |
| KS-4050 | 50.80 | 7-9 | 40-46 | RR40RK40/50 | 50 | TK42 | 310 | TKK42 | 205 | 19.05 |
| KS-4060 | 50.80 | 7-9 | 40-46 | RR40RK40/60 | 60 | TK42 | 310 | TKK42 | 205 | 19.05 |
| KS-4080 | 50.80 | 7-9 | 40-46 | RR40RK40/80 | 80 | TK42 | 310 | TKK42 | 205 | 19.05 |
| KS-4240 | 50.80 | 10-13 | 42-48 | RR23RK11/40 | 40 | TK42 | 310 | TKK42 | 205 | 19.05 |
| KS-4250 | 50.80 | 10-13 | 42-48 | RR23RK11/50 | 50 | TK42 | 310 | TKK42 | 205 | 19.05 |
| KS-4260 | 50.80 | 10-13 | 42-48 | RR23RK11/60 | 60 | TK42 | 310 | TKK42 | 205 | 19.05 |
| KS-4280 | 50.80 | 10-13 | 42-48 | RR23RK11/80 | 80 | TK42 | 310 | TKK42 | 205 | 19.05 |

All dimensions are in mm. BWG is a gauge code, not a dimension. Short mandrel sets contain 3 pieces.

# KS

## Selection table - part 3

| Tool no. | Tube OD | BWG | Expansion | Roll set | Roll len. | Mandrel | Mandrel length | Short set (3 pcs) | Short length | Drive square |
|---|---|---|---|---|---|---|---|---|---|---|
| KS-4440 | 50.80 | 12-14 | 44-50 | RR23RK11/40 | 40 | TK44 | 310 | TKK44 | 205 | 19.05 |
| KS-4450 | 50.80 | 12-14 | 44-50 | RR23RK11/50 | 50 | TK44 | 310 | TKK44 | 205 | 19.05 |
| KS-4460 | 50.80 | 12-14 | 44-50 | RR23RK11/60 | 60 | TK44 | 310 | TKK44 | 205 | 19.05 |
| KS-4480 | 50.80 | 12-14 | 44-50 | RR23RK11/80 | 80 | TK44 | 310 | TKK44 | 205 | 19.05 |
| KS-4740 | 50.80 | 15-16 | 47-54 | RR24RK12/40 | 40 | TK47 | 338 | TKK47 | 218 | 19.05 |
| KS-4750 | 50.80 | 15-16 | 47-54 | RR24RK12/50 | 50 | TK47 | 338 | TKK47 | 218 | 19.05 |
| KS-4760 | 50.80 | 15-16 | 47-54 | RR24RK12/60 | 60 | TK47 | 338 | TKK47 | 218 | 19.05 |
| KS-4780 | 50.80 | 15-16 | 47-54 | RR24RK12/80 | 80 | TK47 | 338 | TKK47 | 218 | 19.05 |
| KS-4940 | 57.15 | 10-13 | 49-56 | RR24RK12/40 | 40 | TK49 | 338 | TKK49 | 218 | 19.05 |
| KS-4950 | 57.15 | 10-13 | 49-56 | RR24RK12/50 | 50 | TK49 | 338 | TKK49 | 218 | 19.05 |
| KS-4960 | 57.15 | 10-13 | 49-56 | RR24RK12/60 | 60 | TK49 | 338 | TKK49 | 218 | 19.05 |
| KS-4980 | 57.15 | 10-13 | 49-56 | RR24RK12/80 | 80 | TK49 | 338 | TKK49 | 218 | 19.05 |
| KS-5240 | 57.15 | 14-16 | 52-59 | RR25RK13/40 | 40 | TK49 | 338 | TKK49 | 218 | 19.05 |
| KS-5250 | 57.15 | 14-16 | 52-59 | RR25RK13/50 | 50 | TK49 | 338 | TKK49 | 218 | 19.05 |
| KS-5260 | 57.15 | 14-16 | 52-59 | RR25RK13/60 | 60 | TK49 | 338 | TKK49 | 218 | 19.05 |
| KS-5280 | 57.15 | 14-16 | 52-59 | RR25RK13/80 | 80 | TK49 | 338 | TKK49 | 218 | 19.05 |
| KS-5440 | 63.50 | 8-13 | 54-62 | RR26RK14/40 | 40 | TK54 | 375 | TKK54 | 230 | 19.05 |
| KS-5450 | 63.50 | 8-13 | 54-62 | RR26RK14/50 | 50 | TK54 | 375 | TKK54 | 230 | 19.05 |
| KS-5460 | 63.50 | 8-13 | 54-62 | RR26RK14/60 | 60 | TK54 | 375 | TKK54 | 230 | 19.05 |
| KS-5480 | 63.50 | 8-13 | 54-62 | RR26RK14/80 | 80 | TK54 | 375 | TKK54 | 230 | 19.05 |
| KS-5740 | 63.50 | 12-16 | 57-66 | RR27RK15/40 | 40 | TK57 | 395 | TKK57 | 235 | 19.05 |
| KS-5750 | 63.50 | 12-16 | 57-66 | RR27RK15/50 | 50 | TK57 | 395 | TKK57 | 235 | 19.05 |
| KS-5760 | 63.50 | 12-16 | 57-66 | RR27RK15/60 | 60 | TK57 | 395 | TKK57 | 235 | 19.05 |
| KS-5780 | 63.50 | 12-16 | 57-66 | RR27RK15/80 | 80 | TK57 | 395 | TKK57 | 235 | 19.05 |
| KS-6040 | 69.85 | 7-11 | 60-69 | RR28RK16/40 | 40 | TK57 | 395 | TKK57 | 235 | 19.05 |
| KS-6050 | 69.85 | 7-11 | 60-69 | RR28RK16/50 | 50 | TK57 | 395 | TKK57 | 235 | 19.05 |
| KS-6060 | 69.85 | 7-11 | 60-69 | RR28RK16/60 | 60 | TK57 | 395 | TKK57 | 235 | 19.05 |
| KS-6080 | 69.85 | 7-11 | 60-69 | RR28RK16/80 | 80 | TK57 | 395 | TKK57 | 235 | 19.05 |
| KS-6540 | 76.20 | 7-8 | 65-74 | RR29RK17/40 | 40 | TK65 | 395 | TKK65 | 235 | 19.05 |
| KS-6550 | 76.20 | 7-8 | 65-74 | RR29RK17/50 | 50 | TK65 | 395 | TKK65 | 235 | 19.05 |
| KS-6560 | 76.20 | 7-8 | 65-74 | RR29RK17/60 | 60 | TK65 | 395 | TKK65 | 235 | 19.05 |
| KS-6580 | 76.20 | 7-8 | 65-74 | RR29RK17/80 | 80 | TK65 | 395 | TKK65 | 235 | 19.05 |

All dimensions are in mm. BWG is a gauge code, not a dimension. Short mandrel sets contain 3 pieces.

# KS

## Selection table - part 4

| Tool no. | Tube OD | BWG | Expansion | Roll set | Roll len. | Mandrel | Mandrel length | Short set (3 pcs) | Short length | Drive square |
|---|---|---|---|---|---|---|---|---|---|---|
| KS-6840 | 76.20 | 10-14 | 68-77 | RR30RK18/40 | 40 | TK72 | 403 | TKK72 | 255 | 25.4 |
| KS-6850 | 76.20 | 10-14 | 68-77 | RR30RK18/50 | 50 | TK72 | 403 | TKK72 | 255 | 25.4 |
| KS-6860 | 76.20 | 10-14 | 68-77 | RR30RK18/60 | 60 | TK72 | 403 | TKK72 | 255 | 25.4 |
| KS-6880 | 76.20 | 10-14 | 68-77 | RR30RK18/80 | 80 | TK72 | 403 | TKK72 | 255 | 25.4 |
| KS-7240 | 82.55 | 7-11 | 72-81 | RR31RK19/40 | 40 | TK72 | 403 | TKK72 | 255 | 25.4 |
| KS-7250 | 82.55 | 7-11 | 72-81 | RR31RK19/50 | 50 | TK72 | 403 | TKK72 | 255 | 25.4 |
| KS-7260 | 82.55 | 7-11 | 72-81 | RR31RK19/60 | 60 | TK72 | 403 | TKK72 | 255 | 25.4 |
| KS-7280 | 82.55 | 7-11 | 72-81 | RR31RK19/80 | 80 | TK72 | 403 | TKK72 | 255 | 25.4 |
| KS-7740 | 82.55 | 15-16 | 77-87 | RR32RK20/40 | 40 | TK77 | 422 | TKK77 | 255 | 25.4 |
| KS-7750 | 82.55 | 15-16 | 77-87 | RR32RK20/50 | 50 | TK77 | 422 | TKK77 | 255 | 25.4 |
| KS-7760 | 82.55 | 15-16 | 77-87 | RR32RK20/60 | 60 | TK77 | 422 | TKK77 | 255 | 25.4 |
| KS-7780 | 82.55 | 15-16 | 77-87 | RR32RK20/80 | 80 | TK77 | 422 | TKK77 | 255 | 25.4 |
| KS-8240 | 88.90 | 10-13 | 82-92 | RR33RK21/40 | 40 | TK82 | 422 | TKK82 | 255 | 25.4 |
| KS-8250 | 88.90 | 10-13 | 82-92 | RR33RK21/50 | 50 | TK82 | 422 | TKK82 | 255 | 25.4 |
| KS-8260 | 88.90 | 10-13 | 82-92 | RR33RK21/60 | 60 | TK82 | 422 | TKK82 | 255 | 25.4 |
| KS-8280 | 88.90 | 10-13 | 82-92 | RR33RK21/80 | 80 | TK82 | 422 | TKK82 | 255 | 25.4 |
| KS-8640 | 95.25 | 8-12 | 86-96 | RR34RK22/40 | 40 | TK86 | 422 | TKK86 | 255 | 25.4 |
| KS-8650 | 95.25 | 8-12 | 86-96 | RR34RK22/50 | 50 | TK86 | 422 | TKK86 | 255 | 25.4 |
| KS-8660 | 95.25 | 8-12 | 86-96 | RR34RK22/60 | 60 | TK86 | 422 | TKK86 | 255 | 25.4 |
| KS-8680 | 95.25 | 8-12 | 86-96 | RR34RK22/80 | 80 | TK86 | 422 | TKK86 | 255 | 25.4 |
| KS-9040 | 101.60 | 9-12 | 90-100 | RR34RK22/40 | 40 | TK90 | 422 | TKK90 | 275 | 25.4 |
| KS-9050 | 101.60 | 9-12 | 90-100 | RR34RK22/50 | 50 | TK90 | 422 | TKK90 | 275 | 25.4 |
| KS-9060 | 101.60 | 9-12 | 90-100 | RR34RK22/60 | 60 | TK90 | 422 | TKK90 | 275 | 25.4 |
| KS-9080 | 101.60 | 9-12 | 90-100 | RR34RK22/80 | 80 | TK90 | 422 | TKK90 | 275 | 25.4 |
| KS-9640 | 101.60 | 16 | 96-106 | RR35RK23/40 | 40 | TK96 | 422 | TKK96 | 275 | 25.4 |
| KS-9650 | 101.60 | 16 | 96-106 | RR35RK23/50 | 50 | TK96 | 422 | TKK96 | 275 | 25.4 |
| KS-9660 | 101.60 | 16 | 96-106 | RR35RK23/60 | 60 | TK96 | 422 | TKK96 | 275 | 25.4 |
| KS-9680 | 101.60 | 16 | 96-106 | RR35RK23/80 | 80 | TK96 | 422 | TKK96 | 275 | 25.4 |

All dimensions are in mm. BWG is a gauge code, not a dimension. Short mandrel sets contain 3 pieces.