



HB Coupling Expander Instructions

Description

The HB Expander is a hand operated pull through type expander. It is used in a fixed location for small production runs or as a portable repair type expander.

The HB Expander will attach all sizes of Holedall® Curb Pump couplings and sizes 3/4" through 2" of Holedall Petroleum couplings.

Features

- Vice or Bench Mounted
- Hand Operated
- Pull Through Type

Used to attach:

- Holedall Petroleum fittings
- Holedall Curb Pump fittings

Installation

The HB Expander is shipped assembled except for attaching the handles and threading the drive screw through the drive screw nut. It can be held in a bench vice or secured to a bench.

Using either method, the expander should be positioned so that the handles overhang sufficiently to give freedom of movement when turning.

Maintenance

1. The drive screw No. 5 must be kept well lubricated with graphite grease.
2. Oil periodically where indicated on body No. 1.

Operation

To expand couplings sizes through 1"

1. Select the proper size reducer (if male coupling), reducer and close nipple (if female coupling). Screw reducer onto thrust connector No. 3 by hand, then screw male coupling into reducer by hand, or if a female coupling, screw onto close nipple until it stops on the washer seat.
2. Position drive screw No. 5 (use 1/2" wrench on flats to turn drive screw) so that the end with the tapped hole is approximately flush with the front end (threaded end) of the coupling.
3. Select the proper size punch and screw it into drive screw No. 5 using a 1/2" wrench to tighten. Hold drive screw No. 5 from turning and turn the handles clockwise until punch enters coupling under slight pressure. (Lubricating punch is not necessary - Holedall Petroleum fittings are pre-lubricated).

HB Coupling Expander Instructions

4. To assemble Holedall® Petroleum:

Place proper size ferrule on the hose so that the end of the hose is flush with the turned over portion of the ferrule (end of hose must be cut square). Keeping the ferrule stationary to the hose, slide the assembly over the punch and onto the shank of the coupling until top of ferrule is 1/8" from coupling face. Holding the hose in place, slide the ferrule flush against the coupling face. This allows the turned over portion of the ferrule to be anchored properly during the expansion process.

5. To assemble Holedall Curb Pump:

Push hose over the punch and into the coupling until hose bottoms out. The easiest way to ensure proper insertion depth is to measure and mark the coupling shank depth on the hose.

6. Turn handles clockwise until resistance to turning ceases - indicating expansion is complete.

7. After expansion has been completed, remove thrust connector No. 3 from expander. Unscrew thrust connector and reducer as a unit from coupling. Replace thrust connector in machine, then remove punch. Machine is now ready for next expansion.

To expand couplings sizes 1-1/4" through 2"

1. Drive screw No. 5 must be reversed. Remove drive screw from nut No. 2, reverse drive screw and reassemble with nut No. 2.

2. Select proper size reducer or reducer nipple. Screw coupling onto reducer (or reducer nipple).

3. Advance drive screw No. 5 through coupling until keyed extension of drive screw projects beyond coupling.

4. Slide expanding punch onto keyed extension of drive screw. Screw on lock nut No. 7. Turn handles clockwise until punch enters coupling under slight pressure.

5. To assemble Holedall Petroleum:

a) Place proper size ferrule on the hose so that the end of the hose is flush with the turned over portion of the ferrule (end of hose must be cut square). Keeping the ferrule stationary to the hose, slide the assembly over the punch and onto the shank of the coupling until top of ferrule is 1/8" from coupling face. Holding the hose in place, slide the ferrule flush against the coupling face. This allows the turned over portion of the ferrule to be anchored properly during the expansion process.

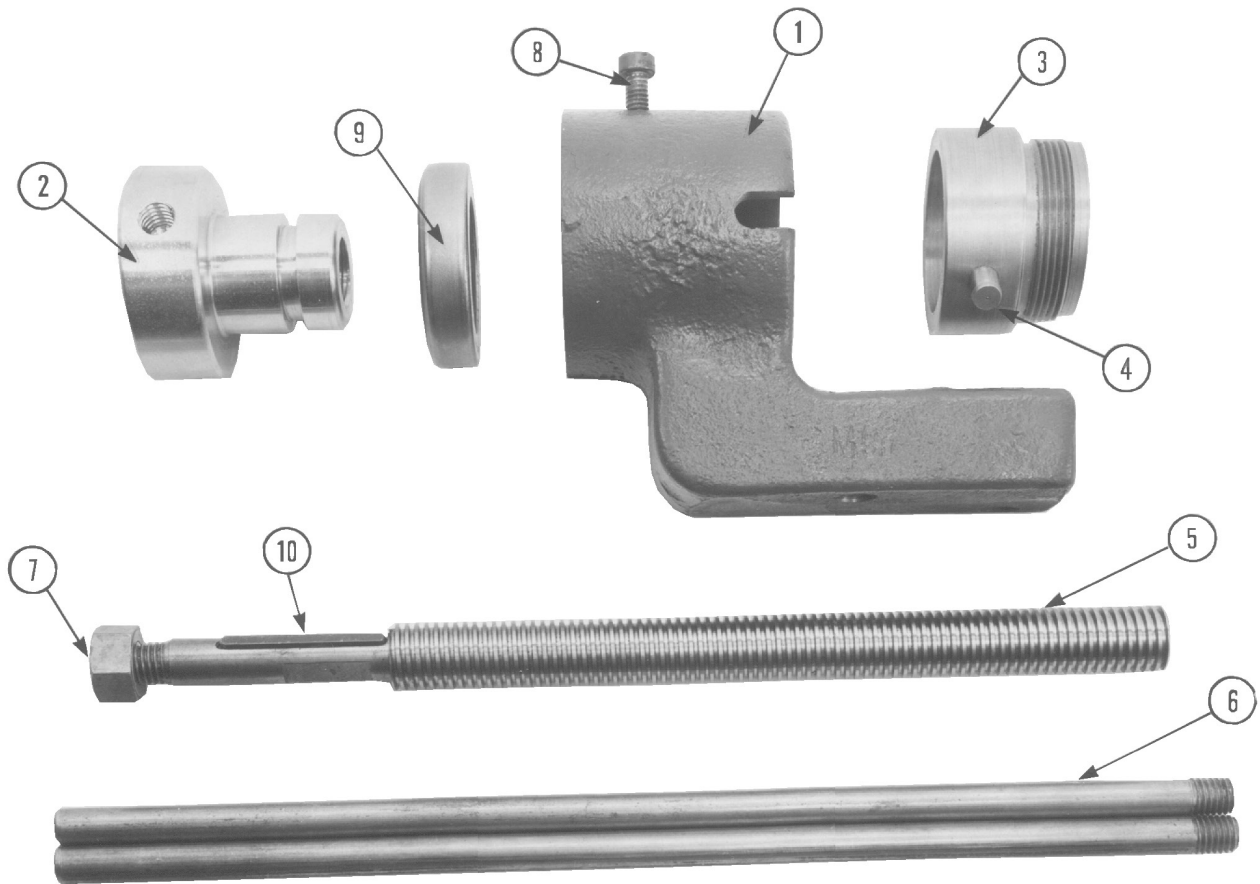
b) Turn handles clockwise until resistance to turning ceases - indicating expansion is complete.

6. After expansion has been completed, remove Thrust connector from machine. Unscrew thrust connector No. 3 and reducer as a unit from coupling. Replace thrust connector in machine. Remove punch, machine is now ready for next expansion.

Caution

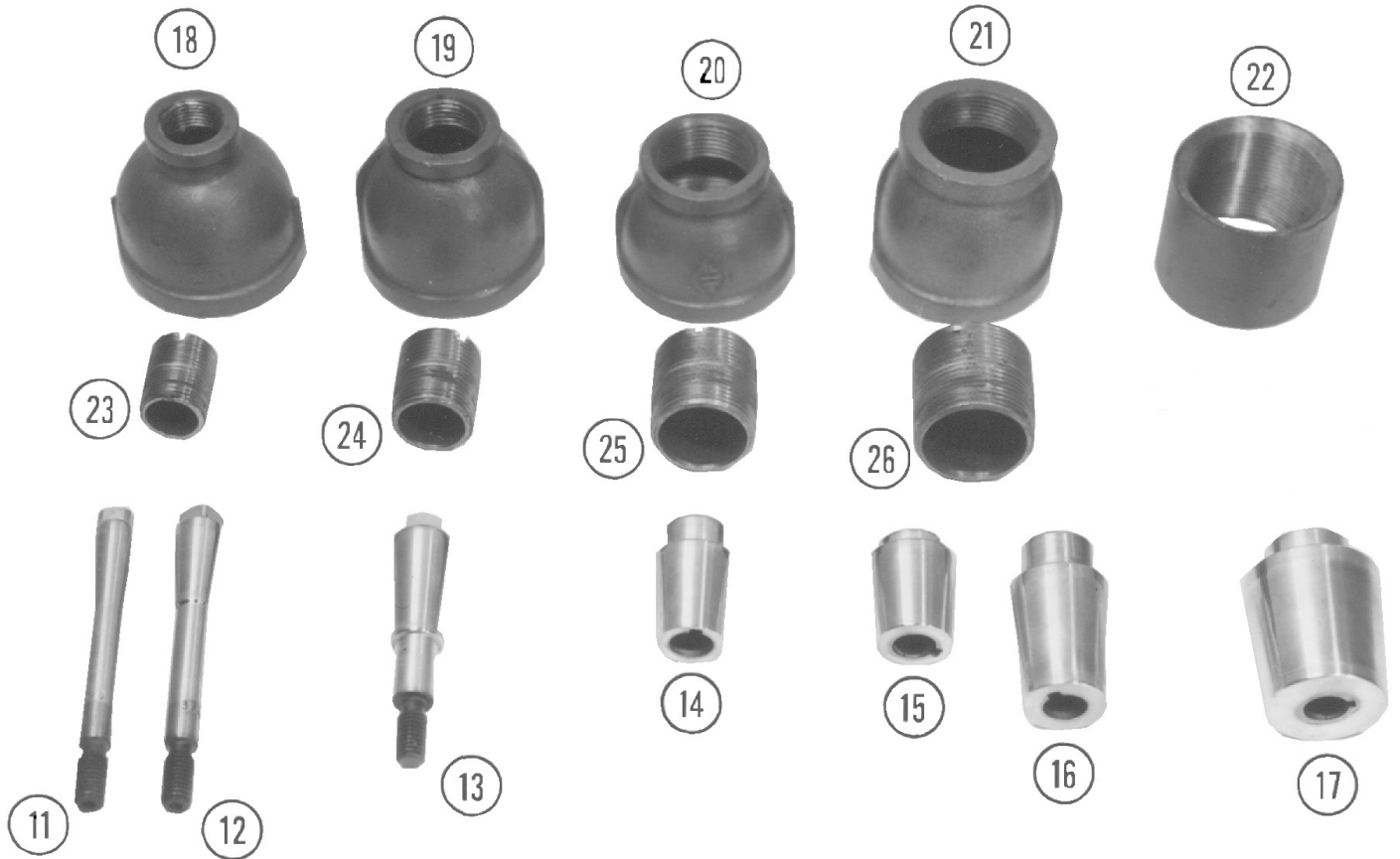
After starting the expansion of a coupling, the handles must never be turned counter clockwise. The thrust bearing is a single direction action and reverse operation of the machine will damage the drive screw.

Parts List for HB Expander



Item #	Description	Part #
1	body	2500HB0001
2	drive screw nut	2500HB0002
3	thrust connector	2500HB0003
4	thrust connector pin (2 required)	2500HB0004
5	drive screw with key	2500HB0005
6	handle (2 required)	2500HB0006
7	punch retaining nut	2500HSP11
8	lock screw	2500HB0007
9	thrust bearing	2500HB0008
10	keyed shaft-key included	2500HSP10

Tooling for HB Expander



Item #	Description	Part #
11	5/8" expanding punch	25000HTL01
12	3/4" expanding punch	25000HTL02
13	1" expanding punch	25000HTL03
14	1-1/4" expanding punch	25000HTL04
15	1-3/8" expanding punch	25000HTL05
16	1-1/2" expanding punch	25000HTL06
17	2" expanding punch	25000HTL07
18	2" x 3/4" standard reducer	BR2075
19	2" x 1" standard reducer	BR2010
20	2" x 1-1/4" standard reducer	BR2012
21	2" x 1-1/4" standard reducer	BR2015
22	2" standard coupling	RHC200
23	3/4" x 1-3/8" close nipple	CN075
24	1" x 1-1/2" close nipple	CN100
25	1-1/4" x 1-5/8" close nipple	CN125
26	1-1/2" x 2-3/4" close nipple	CN150

HB Manual Coupling Expanding Machine
Coupling Types: Holedall® Petroleum and Holedall Curb Pump
Coupling Sizes: 5/8" to 2"

Description	Part #
HB Coupling Expanding Machine	2500HB0000

HB expander includes the following replaceable parts

Description	Part #
HB-201 body	2500HB0001
HB-202 drive screw nut	2500HB0002
HB-204 thrust connector	2500HB0003
HB-203 thrust connector pin (2 required)	2500HB0004
HB-207 drive screw with key	2500HB0005
HB-208 handle (2 required)	2500HB0006
HB-209 lock screw	2500HB0007
HB-101 thrust bearing	2500HB0008
H-213 punch retaining nut	2500HSP11
keyed shaft-key included	2500HSP10

Tooling Needed for HB Expander

Punch, reducer and close nipple for each size
2" requires punch and standard coupling ONLY
For 1-3/8" fittings, reducers and nipples use 1-1/2"

Description	Part #
H-820 5/8" punch	25000HTL01
H-607 3/4" punch	25000HTL02
H-601 1" punch	25000HTL03
H-608 1-1/4" punch	25000HTL04
H-602 1-3/8" punch	25000HTL05
H-603 1-1/2" punch	25000HTL06
H-604 2" punch	25000HTL07
HB-106 2" x 3/4" standard reducer	BR2075
HB-105 2" x 1" standard reducer	BR2010
HB-104 2" x 1-1/4" standard reducer	BR2012
HB-103 2" x 1-1/2" standard reducer	BR2015
HB-102 2" standard coupling	RHC200
HB-110 3/4" x 13/8" close nipple	CN075
HB-109 1" x 1-1/2" close nipple	CN100
HB-108 1-1/4" x 1-5/8" close nipple	CN125
HB-107 1-1/2" x 2-3/4" close nipple	CN150

NOTE: Cannot use on NST fittings, a special adapter is required for these fittings



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