

VALVE SEAT EXPANDERS



Seating rings are expanded on the **capstan lathe** or the **lathe** using the BR 32 valve seat expander.

After turning the seat receptacle the lathe operator inserts the seating ring in the seat. The **expansion** of the ring can be performed by the machine tool without changing the direction of rotation of the workpiece. Following expansion the lathe operator can immediately complete the machining of the valve seat.

The **feeding** of the expanding mandrel, which is clamped tight, is accomplished by the revolver head, the lathe support or the sleeve of the tailstock. The feeding of the expanding mandrel is limited by two **adjustable lock nuts** on the mandrel. The feared stresses in the valve seat housing due to overexpansion are ruled out as a result. Axial pressures occurring during expansion are absorbed by **thrust ball bearings**. Due to the design of the valve seat expander, the seating ring is held flat on its seat before the start of expansion. The expansion is **completely round** and **absolutely tight**. The BR 32 valve seat expander is also available in a custom version for **transfer lines**.

Note: Since valves differ in their series and the seating rings sometimes have somewhat different dimensions, the expansion ranges of the complete tube expander have not been stated. Therefore, we kindly request that you supply us with exact details, including dimensional sketches or drawings, when enquiring or ordering.

The mandrels can be supplied with **Morse taper, square receptacle** or **straight shank**. Please state precisely which receptacle is required when ordering.

Custom versions are available.

TECHNICAL DATA – VALVE SEAT EXPANDERS

Valve seat expander	Spare mandrel	Spare rolls	Nominal width	Number of rolls
Order no.	Order no.	Order no.	inch	
0321500	1321500	2321500	0.59 / 0.79	3
0322500	1322500	2322500	0.98	4
0323200	1323200	2323200	1.26	4
0324000	1324000	2324000	1.58	4
0325000	1325000	2325000	1.97	5
0326500	1326500	2326500	2.56	5
0328000	1328000	2328000	3.15	5
0328100	1328100	2328100	3.94	5
0328200	1328200	2328200	4.92	5
0328300	1328300	2328300	5.91	5
0328400	1328400	2328400	6.89	5
0328500	1328500	2328500	7.87	5