

**“UNPARALLELED PERFORMANCE AND SAFETY UNDER PRESSURE!”®**

SelectForm®

## Model 400 Series End Forming Tools



- Pressures up to 3,000 psi (207 bar)
- 0.19 in. to 1.38 in. OD (4.7 mm to 35.0 mm OD)
- Pressure-compensated design
- Expand, reduce, bead, or flare tube ends
- Precision-machined stainless steel construction

### DESCRIPTION

The patented SelectForm® Model 400 Series End Forming Tool is a dedicated, hand-held tool that accurately expands, reduces, beads, or flares a single shape on the end of tube diameters from 0.19 in. to 1.38 in. (4.7 mm to 35.0 mm). These tools utilize two quick disconnects for easy connection to hydraulic power unit. When combined with the SelectForm® Model 400 Hydraulic Power Unit, the tool is simply placed over the tube end and the operator presses a foot switch on the power source. The tool cycles automatically, producing a finished form in 2 to 5 seconds.

### COMMON END FORMS



### MODEL 400 DEDICATED END FORMING TOOLS

Model Number	End Form Shape
400	Tube Expansion
401	Hydraulic Ball Inserter
402	Tube Reduction
403	Bead Form
437	37° S.A.E. Flare
445	45° S.A.E. Flare

### APPLICATION

The SelectForm® Model 400 Series End Forming Tools are used to produce a specific end form on tubes for manufacturing applications in a variety of industries, including: aerospace and aircraft, boiler, heat exchanger and radiator, military, nuclear and hydro-electric, metal furniture, on/off road mobile vehicles, outdoor power equipment, plumbing fittings, sports equipment, boat and water craft, tube and pipe manufacturing.

### TOOL CONFIGURATION

Grip: On tube OD  
Actuation: Hydraulically-operated extend and retract

### OPERATING CONDITIONS

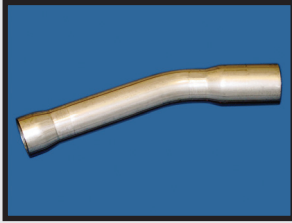
Maximum Pressure: 3,000 psi (207 bar)  
Temperature: 32° F to 120° F (0° C to 49° C)  
Tube OD Range: 0.19 in. to 1.38 in.  
(4.7 mm to 35.0 mm)  
Expansion Length: Up to 3 x tube OD, depending on application  
Expansion: <20% of the Tube OD\*  
Reduction Length: Up to 3 x tube OD, depending on application  
Reduction: <20% of the Tube OD\*  
Flare: 37° and 45°  
Wall Thickness: Standard tubing  
Materials: Aluminum, carbon steel, copper, stainless steel, and titanium

\* Actual expansion range may vary depending on material, please check with Airmo for details.

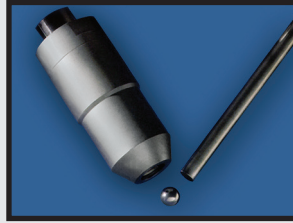
**MAXIMUM PRESSURE**  
**3,000 psi**  
**207 bar**

SelectForm®  
**Model 400 Series**  
End Forming Tools

**End Form - aluminum, carbon steel, copper, stainless steel, and titanium**



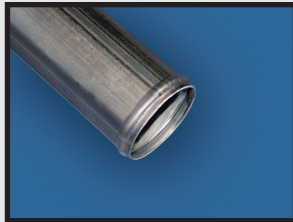
**Model 400 Tool - Expansion**



**Model 401 Tool - Ball Inserter**



**Model 402 Tool - Reduction**



**Model 403 Tool - Bead**



**Model 437 Tool - Flare**

*Special Configurations Available Upon Request*

**FEATURES**

- Fast operation, cycles in 2 to 5 seconds
- Pressure-compensated design
- Low marking collet design
- Compact, balanced design
- Precision-machined from heat-treated stainless steel
- Low maintenance
- Designed for use with SelectForm® Hydraulic Power Unit

**BENEFITS**

- Increases productivity and throughput
- Contains all high-pressure loads for safe operation
- Prevents tube end collapse and eliminates scrap
- Reduces operator fatigue
- Provides long, trouble-free service
- No lubrication required for most applications
- Transport portable system and tooling to job site



**AIRMO, INC.** 9445 Evergreen Blvd. NW, Minneapolis, MN 55433-5840 USA

**PHONE:** 1(763) 786-0000 or 1(800) 394-0016 | **FAX:** 1(763) 786-4622 | **EMAIL:** [airmo@airmo.com](mailto:airmo@airmo.com) | **WEBSITE:** [www.airmo.com](http://www.airmo.com)

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