



# Specialty Tool & Supply, Inc.

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*Heat Exchanger Services and Tube Slewing*

## DATA SHEET FOR TUBE TO TUBE SHEET JOINT USING HYDRAULIC EXPANSION METHOD

Job or Quotation Reference Number \_\_\_\_\_

Contact: \_\_\_\_\_ Phone: \_\_\_\_\_ Fax: \_\_\_\_\_

End User: \_\_\_\_\_ New or Retube: \_\_\_\_\_ Start Date: \_\_\_\_\_

### Tube:

1) O.D. \_\_\_\_\_ Wall Thickness \_\_\_\_\_ Avg. or Min. Wall \_\_\_\_\_ Qty. \_\_\_\_\_

2) O.D. \_\_\_\_\_ Wall Thickness \_\_\_\_\_ Avg. or Min. Wall \_\_\_\_\_ Qty. \_\_\_\_\_

3) O.D. \_\_\_\_\_ Wall Thickness \_\_\_\_\_ Avg. or Min Wall \_\_\_\_\_ Qty. \_\_\_\_\_

Seamless \_\_\_\_\_ Welded Drawn \_\_\_\_\_ Tube Material Spec. \_\_\_\_\_

U bend? \_\_\_\_\_ Tube Protrusion - 1st Tubesheet \_\_\_\_\_ 2nd Tubesheet \_\_\_\_\_

Total # of Units \_\_\_\_\_ Total # of Expansions \_\_\_\_\_

Tubesheet: #1 Thickness \_\_\_\_\_ Tolerance \_\_\_\_\_ Material \_\_\_\_\_

Clad? \_\_\_\_\_ Thickness \_\_\_\_\_ Material \_\_\_\_\_

Total thickness T/S #1 \_\_\_\_\_

#2 Thickness \_\_\_\_\_ Tolerance \_\_\_\_\_ Material \_\_\_\_\_

Clad? \_\_\_\_\_ Thickness \_\_\_\_\_ Material \_\_\_\_\_

Total thickness T/S #2 \_\_\_\_\_

Hole: Diameter \_\_\_\_\_ Tolerance \_\_\_\_\_ Drilled \_\_\_\_\_ Reamed \_\_\_\_\_

Pattern \_\_\_\_\_ Pitch \_\_\_\_\_

Chamfer \_\_\_\_\_ Which Side? \_\_\_\_\_ Angle \_\_\_\_\_ Depth \_\_\_\_\_

Grooves: Quantity \_\_\_\_\_ Face of T.S. to First Groove \_\_\_\_\_ Width of Groove \_\_\_\_\_

Groove Depth \_\_\_\_\_ Space Between Grooves \_\_\_\_\_ Width of 2nd Groove \_\_\_\_\_

Space Between Grooves \_\_\_\_\_ Width of 3rd Groove \_\_\_\_\_

Customer Receptive to Hydroswage Groove (1/4. Wide x 1/64. Deep)? \_\_\_\_\_

Pressure Zone: Tube Lock Prior to Expansion Yes \_\_\_\_\_ No \_\_\_\_\_

Expansion Zone: Starting Distance from Primary Face \_\_\_\_\_

Distance from Secondary Side \_\_\_\_\_

Total Expansion Zone \_\_\_\_\_

Contact Only? Yes \_\_\_\_\_ No \_\_\_\_\_ Seal Welded? Yes \_\_\_\_\_ No \_\_\_\_\_

Strength Welded? Yes \_\_\_\_\_ No \_\_\_\_\_

Any Channel or partition plate in place during expansion of tube? Yes \_\_\_\_\_ No \_\_\_\_\_

Other Special Considerations: \_\_\_\_\_

X \_\_\_\_\_

(Customer signature for acknowledgement of Specs.)