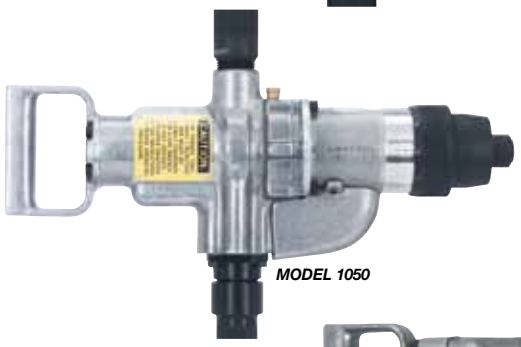
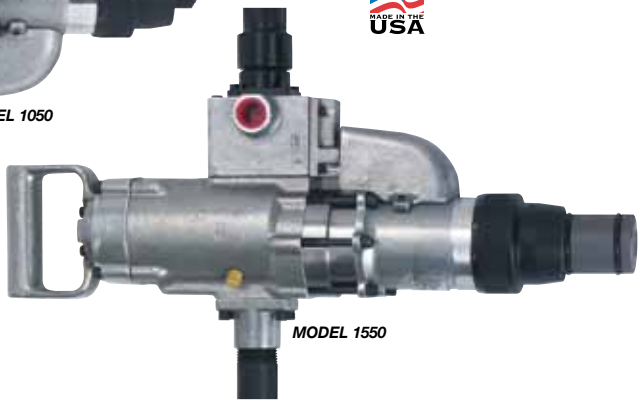

MODEL 720


MODEL 850


MODEL 1050


MODEL 1550

Airetrol Air Driven Rolling Motors

Airetool rolling motors control expansion by the accurate measurement of torque. They automatically stop expanding according to a predetermined setting. Torque control prevents over- and under-expansion of tubes, assures uniformly tightened tube joints, and provides maximum holding strength for individual tubes. All Airetrols include torque sensing cams designed and manufactured specifically for tube expanding applications.

- **Strong, lightweight aluminum housings for easier handling and less operator fatigue**
- **Rugged drive combines precision control and measured torque output**
- **Simple dial-a-torque adjustment collar for easy set up**
- **Cushioned shut-off reduces torque reaction**
- **Quick change chucks to improve productivity**

MADE IN THE USA

Model Number	Order Number	Speed & Torque @ 90 psig Air Pressure*					Overall Length		Weight		Side to Center		Operating Hose		CFM	Square Drive	Tube Capacities*		Quick Change Chuck (in.)	
		Free Speed	Max. Torque		Min. Torque															
		RPM	in. lbs.	Nm	in. lbs.	Nm	in.	mm	lbs.	Kg	in.	mm	in.	mm		in.	in.	mm	Included	Optional
720-2500B	8405541	2500	20.0	2.3	2.0	0.23	7.875	198	2.4	1.09	0.813	20.7	3/8	9.5	17	1/4	1/4	6.4	1/4	3/8
720-2500B 3/8	8405561	2500	20.0	2.3	2.0	0.23	7.875	198	2.4	1.09	0.813	20.7	3/8	9.5	17	1/4	1/4	6.4	1/4	3/8
720-1800B	8405383	1800	27.0	3.1	2.0	0.23	7.875	200	2.4	1.09	0.813	20.7	3/8	9.5	17	1/4	3/8	9.5	1/4	3/8
720-1800B 3/8	8405512	1800	27.0	3.1	2.0	0.23	7.875	200	2.4	1.09	0.813	20.7	3/8	9.5	17	1/4	3/8	9.5	1/4	3/8
720-550B	8405391	550	75.0	8.5	2.0	0.23	8.625	219	2.7	1.22	0.813	20.7	3/8	9.5	17	3/8	1/2	12.7	3/8	1/4
850-1250A	8405399	1100	115.0	13.0	22.0	2.49	12.250	311	10.5	4.76	1.438	36.5	1/2	12.7	48	3/8	3/4	19.1	3/8	1/2
850-600A	8405398	500	192.0	21.7	31.0	3.50	12.250	311	10.5	4.76	1.438	36.5	1/2	12.7	48	3/8	1	25.4	3/8, 1/2	-

*Varies depending on tube material, gauge, and tube sheet thickness

Model Number	Order Number	Speed & Torque @ 90 psig Air Pressure*					Overall Length		Weight		Side to Center		Operating Hose		CFM	Square Drive	Tube Capacities*		Quick Change Chuck (in.)	
		Free Speed	Max. Torque		Min. Torque															
		RPM	ft. lbs.	Nm	ft. lbs.	Nm	in.	mm	lbs.	Kg	in.	mm	in.	mm		in.	in.	mm	Included	Optional
1050-400	8404200	394	22.0	29.8	6.5	8.8	13.625	346	14	6.35	1.938	49.2	3/4"	19.1	68	1/2	1-1/4	31.8	3/8, 1/2	3/4, 1
1050-400 HD	8404201	394	29.5	40.0	7.5	10.2	13.625	346	14	6.35	1.938	49.2	3/4"	19.1	68	1/2	1-1/4	31.8	3/8, 1/2	3/4, 1
1550-900	8404290	756	30.7	41.6	4.7	6.4	18.000	457	27	12.25	1.938	49.2	3/4"	19.1	70	1/2	1-1/2	38.1	3/8, 1/2	3/4, 1
1550-250	8404280	217	100.0	135.5	25.0	33.9	18.000	457	27	12.25	1.938	49.2	3/4"	19.1	56	3/4	2-1/2	63.5	3/4, 1	3/8, 1/2

*Varies depending on tube material, gauge, and tube sheet thickness

1850 Series Torque Control Rolling Motors

Heavy duty torque controlled rolling motor capable of rolling boiler tubes up to 4-1/2" O.D.

- **Offers the highest controlled torque of any rolling motor currently available.**
- **Torque range 320 - 570 ft.lbs.**

MADE IN THE USA

1750 Series Right Angle Torque Control Rolling Motors

These right angle torque control rolling motors are used to roll tubes into drums of package and stationary boilers.

- **Heavy duty gear train components for increased durability**
- **External torque control setting for easy adjustment**
- **Rotating exhaust deflector and indexing angle head for operator control and comfort**
- **Modular construction simplifies tool maintenance**
- **Roll Throttle makes for safe operation in any working position**

MADE IN THE USA

Model Number	Order Number	Speed & Torque 90 psig Air Pressure*					Overall Length		Weight		Side to Center		Operating Hose		CFM	Square Drive	Tube Capacities*		Chucks (in.)†	
		Free Speed	Maximum Torque		Minimum Torque															
		RPM	ft. lbs.	Nm	ft. lbs.	Nm	in.	mm	lbs.	kg	in.	mm	in.	mm			in.	mm	Incl.	Opt.
1850 Series Torque Control Rolling Motors																				
1850-90	8405315	82	301	408	92	125	13	330	46	20.9	3.375	86	1/2	12.7	60	1	3-1/2	89	3/4, 1	1-1/4, 1-1/2
1850-40	8405314	34	570	772	320	434	15	381	52	23.6	3.625	92.1	1/2	12.7	60	1	4-1/2	114	3/4, 1	1-1/4, 1-1/2

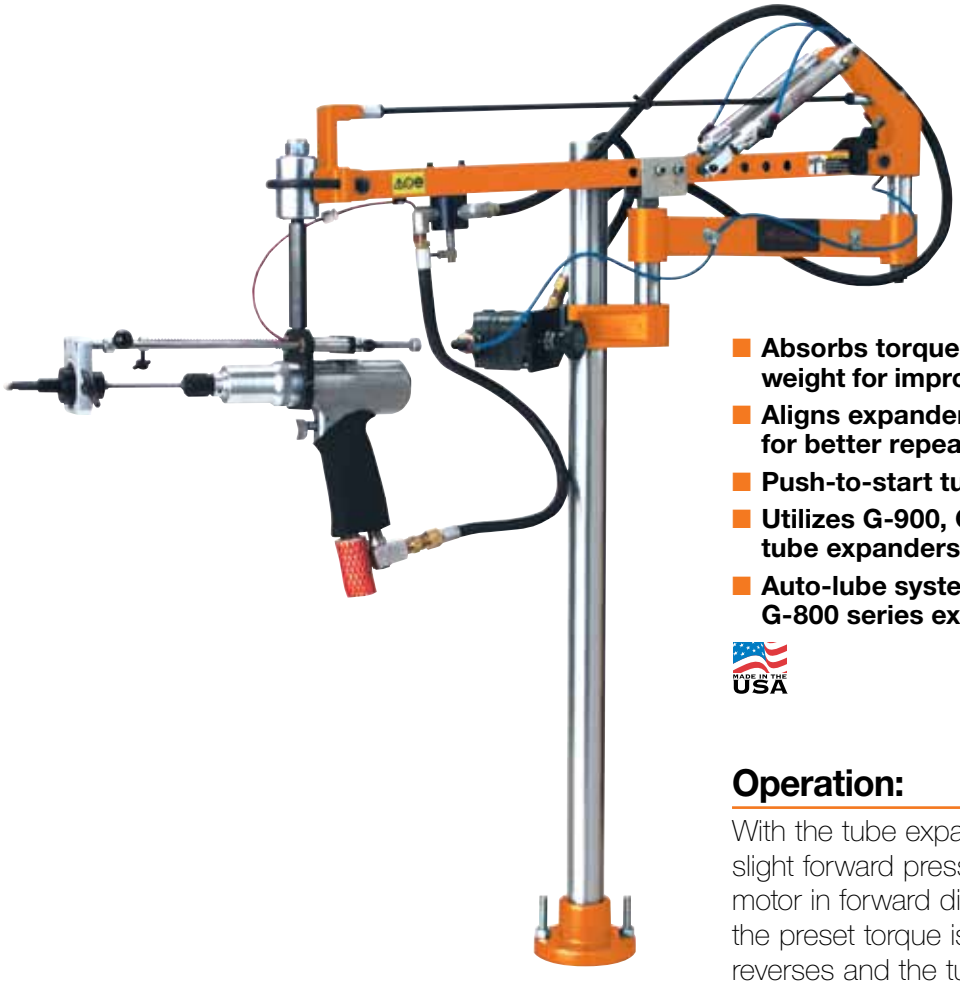
*Varies depending on tube material, gauge, and tube sheet thickness

Model Number	Order Number	Speed & Torque 90 psig Air Pressure*					Overall Length		Weight		Head Dimensions				Square Drive Size	Tube Capacities*		Chuck Size (in.)†
		Free Speed	Maximum Torque		Minimum Torque						Side to Center		Height Less Square Drive					
		RPM	ft. lbs.	Nm	ft. lbs.	Nm	in.	mm	lbs.	kg	in.	mm	in.	mm	in.	in.	mm	incl.
1750 Series Reversible – Roll Throttle																		
1753-R-190	8405420	190	140	190	70	95	20.1	530.0	13.0	5.8	1.1	28.0	2.60	65.0	5/8	2.5	63.5	3/4
1753-RS-190	8405422	190	155	210	0	0	19.4	490.0	11.4	5.2	1.1	28.0	2.50	64.0	5/8	2.5	63.5	3/4
1752-R-90	8405421	90	305	413	150	203	21.7	550.0	14.8	6.7	1.5	37.0	2.75	70.0	3/4	4.0	101.5	3/4, 1
1752-RS-90	8405423	90	325	440	0	0	20.1	511.0	13.1	6.0	1.4	37.0	2.8	70.0	3/4	4.0	101.5	3/4, 1
1750 Series Reversible – Lever Throttle																		
1752-L-90	8405425	90	305	413	150	203	21.7	550.0	14.8	6.7	1.5	37.0	2.60	65.0	3/4	4.0	101.5	3/4, 1

† See page 13 for chuck size chart.
*Varies depending on tube material, gauge, and tube sheet thickness

Standard Equipment
Air Inlet: 1/2" NPT
Minimum hose size: 1/2"
Splined torque reaction plate and reaction bar included (8567610)

DAS-100-TRS Tube Rolling System



Tube rolling system for bench top tube rolling. The support post can be mounted directly on a work-bench or workstation pedestal for easy access. Suitable for tube rolling applications of 1/4" thru 5/8" O.D. tubes.

- **Absorbs torque reaction while supporting tool weight for improved productivity and ergonomics**
- **Aligns expander with tube sheet for better repeatability**
- **Push-to-start tube rolling cycle**
- **Utilizes G-900, G-1300 and G-800 series tube expanders**
- **Auto-lube system configurations for use with G-800 series expanders with lube collars**

MADE IN THE USA

Operation:

With the tube expander positioned inside the tube, slight forward pressure on the Airetrol starts the motor in forward direction to expand the tube. Once the preset torque is met, the motor automatically reverses and the tube expander can be removed from the tube. The tube expander holder is spring loaded, keeping the tube expander in the retracted position to assist the expander entering the tube.

Model Number	Order Number	Post Height		Vertical Travel		Horizontal Travel	
		in.	mm	in.	mm	in.	mm
DAS 100 THB - Balancer Less Rolling Motor							
DAS 100 THB	5526551PT	29.0	736.6	14.5	368.3	77.0	1955.8

Model Number	Order Number	Free Speed	Speed & Torque 90 psig Air Pressure				CFM	Tube Capacities*		Chucks (in.)†	
			Maximum Torque		Minimum Torque						
		RPM	in. lbs.	Nm	in. lbs.	Nm		in.	mm	Included	Optional
DAS 100 TRS 720 Tube Rolling Systems with Motors											
DAS 100 720 2500B	5525242	2500	20.0	2.26	2.0	0.23	17	1/4	6.3	1/4	3/8
DAS 100 720 1800B	5525243	1800	27.0	3.05	2.0	0.23	17	3/8 - 1/2	12.7	1/4	3/8
DAS 100 720 1800B 3/8 L**	5526141	1800	27.0	3.05	2.0	0.23	17	3/8 - 1/2	12.7	3/8	1/4
DAS 100 720 550B	5525244	550	75.0	8.48	2.0	0.23	17	1/2 - 5/8	15.8	3/8	1/4
DAS 100 720 550B L**	5526142	550	75.0	8.47	2.0	0.23	17	1/2 - 5/8	15.8	3/8	1/4

† See page 13 for chuck size chart.
*Varies depending on tube material, gauge, and tube sheet thickness
**L = Auto-lube

DAS II Dominator System

The Airetool DAS II Dominator Tube Rolling System was designed to take pneumatic tube rolling technology to the next level using time proven Airetrol rolling motors outfitted with on-board pneumatic control logic.

- **Fully pneumatic system for fabrication shops and/or field service work**
- **"Basic" unit works well with tube pulling, tube end facing, and orbital welding equipment**
- **Greatly enhances the accuracy of tube rolling reducing costly rework of improperly rolled tubes**
- **Increases expander life (up to 3X) compared to conventional hand-held equipment**
- **Ergonomic design supports tool weight and torque reaction**
- **Floor lock holds system in place for stability while rolling tubes**
- **Right or left hand operation without conversion**
- **Five foot vertical and horizontal reach**
- **Available in three different configurations: Basic Unit*, Standard, Lubricator**

MADE IN THE USA

DAS II Component	DAS II Dominators		
	Basic Unit*	Standard	With Lube
Base	*	*	*
Tower	*	*	*
Articulating ToolArm	*	*	*
Filter & Lubricator (Tool)		*	*
Airetool Supply Hoses		*	*
Lubricator (Expander)			*

*The basic positioning unit can be used to support a wide variety of tube service tools including drills, end facers, tube cutting tools, tube pulling rams, and tube cleaning motors

Model Number	Order Number	Movement				Lift Capacity		Operating Pressure		Operating Hose		Allowable Torque	
		Vertical		Horizontal									
		ft.	m	ft	m	lbs.	kg	PSI	Bar	in.	mm	ft.-lbs.	Nm
Automatic Tube Rolling System Less DAS II Airetrol													
DAS II Dominator	5526081	5.0	1.5	5.0	1.5	55	25	90	6.2	3/4	19.1	125	169
DAS II Dominator w/lube	5526140	5.0	1.5	5.0	1.5	55	25	90	6.2	3/4	19.1	125	169
Basic Positioning Unit*													
DAS II Dominator Basic Unit	5529158	5.0	1.5	5.0	1.5	55	25	90	6.2	3/4	19.1	125	169

DAS II Dominator System

The Airetool DAS II Dominator Rolling Motors are designed to deliver power, performance, and durability while providing accurate and repeatable tube expansion.

- **Time proven torque control rolling motors with on-board pneumatic control logic**
- **Simple dial-a-torque adjustment collar for easy set up**
- **Push-to-start configurations (no suffix) run only when activated, reducing noise and conserving shop air**
- **Timed Start* configurations (T suffix) cycle continuously for trigger free tube rolling**
- **Tool Options include “Cycle Counter” (C suffix) and “Expander Lubricator" (L suffix)**

MADE IN THE USA

Examples: DAS II 1550 900 TCL is a timed start model with counter & lube

DAS II 850 1250 CL is a push-to-start model with counter & lube

**Timed Start option will run continuously when the toggle switch is in the “on” position. After the tube is rolled and the tool switches into reverse rotation, an adjustable delay timer is activated. The tool will start running in the forward direction again after the time delay is finished. (Available only on 1050 & 1550 Series.)*

Model Number	Order Number	Free Speed	CFM	Maximum Torque		Minimum Torque		Chucks (in.)†	
		RPM		ft. lbs.	Nm	ft. lbs.	Nm	Included	Optional
DAS II Dominator Rolling Motors*									
DAS II 850 1250 Airetrol	8405562	1100	48	9.6	13.0	1.8	2.4	3/8	1/2
DAS II 850 1250 CL Airetrol	8405567	1100	48	9.6	13.0	1.8	2.4	3/8	1/2
DAS II 850 600 Airetrol	8405569	500	48	16.0	21.7	2.6	3.5	3/8, 1/2	-
DAS II 850 600 CL Airetrol	8405578	500	48	16.0	21.7	2.6	3.5	3/8, 1/2	-
DAS II 1050 400 TCL Airetrol	8405594	394	68	29.5	40.0	7.5	10.2	3/8, 1/2	3/4 - 1
DAS II 1550 900 Airetrol	8405563	756	75	30.7	41.6	4.7	6.4	3/8, 1/2	3/4, 1
DAS II 1550 900 CL Airetrol	8405565	756	75	30.7	41.6	4.7	6.4	3/8, 1/2	3/4, 1
DAS II 1550 900 T Airetrol	8405576	756	75	30.7	41.6	4.7	6.4	3/8, 1/2	3/4, 1
DAS II 1550 900 TCL Airetrol	8405580	756	75	30.7	41.6	4.7	6.4	3/8, 1/2	3/4, 1
DAS II 1550 250 Airetrol	8405564	217	75	100.0	135.5	25.0	33.9	3/4, 1	3/8, 1/2
DAS II 1550 250 T Airetrol	8405577	217	75	100.0	135.5	25.0	33.9	3/4, 1	3/8, 1/2
DAS II 1550 250 CL Airetrol	8405568	271	75	100.0	135.5	25.0	33.9	3/4, 1	3/8, 1/2

† 3/8 & 1/2 are QC Chucks (quick change)
* Configurations

No suffix - Basic Airetrol, push-to-start (PTS)
C suffix - PTS with Counter
L suffix - PTS with Lubricator
T suffix - Timer (continuous cycling, negates PTS, available only on 1050 & 1550 Series)

Electronic Controller

The ATC-900 Electronic Controller is a compact, lightweight and durable microprocessor based electronic motor controller. It is designed to provide accurate torque control for Airetool electric rolling motors by monitoring the amperage that the tool is using and comparing it to a preset current limit value. When the preset current limit value is reached, the controller opens the circuit which stops the motor. The current limit value is adjusted using the up/down push-buttons on the front of the controller to increment or decrement the current limit set point.

- **ATC-900 Controller automatically identifies connected motor**
- **GFCI Power Cord for operator safety**
- **Expansion counter increments each time the controller shuts off the tool**
- **Up/down pushbuttons used to preset torque shutoff set point in 0.1Amp increments**
- **Auxiliary Receptacles for Trip Light and Lubricator**

MADE IN THE USA

Airetool Electric Rolling Motors may be used without the ATC-900 Electronic Controller and plugged directly into a wall outlet using a "Optional" Direct Power Cord. (see chart below)

Airetool Electric Rolling Motors may be used with the DAS II Dominator "Basic Unit" (see page 6) by using a 8405583PT Mounting Kit.

MODEL 979-C

MODEL 999-C

Model Number	Order Number
Accessories	
Universal 2KVA Step Down Transformer 220/110 VAC	8405529

Model Number	Order Number	Input Voltage		Current Requirements		Weight		Dimensions					
				Supply	Adjustment			Length		Width		Height	
		VAC	Hz.	Amps	Amps	lbs.	kg	in.	mm	in.	mm	in.	mm
Electronic Controller													
ATC 900*	2996326	120	50/60	20	0.1	7.2	3.27	11.75	298.5	12	304.8	7.63	193.8

*Not CE certified
Standard Equipment: Power Cord 2996733PT
Optional Equipment: Step down transformer (220VAC to 110VAC) 8405529

Model Number	Order Number	RPM	Maximum Torque		Minimum Torque		Tube Capacity*		Weight		Chucks
			ft. lbs.	Nm	ft. lbs.	Nm	in.	mm	lbs.	kg	in.
Electric Rolling Motors											
979-C-210	8405489	210	40.0	54.2	20.0	19.0	3/4–2	19.1–50.8	32.0	14.5	3/8-1/2 QC
979-C-300	8405488	300	28.0	37.9	14.0	8.8	3/4–1-1/2	19.1–38.1	32.0	14.5	3/8-1/2 QC
979-C-650	8405487	650	13.0	17.6	6.5	128.7	5/8–1-1/4	15.9–31.8	32.0	14.5	3/8-1/2 QC
999-C-45	8405492	45	190.0	257.5	95.0	128.8	2–4	50.8–101.6	32.0	14.5	3/4-1

*May vary due to tube wall, material and/or tube sheet thickness.
Standard Equipment: Controller cable

Model Number	Order Number	Length	
		ft.	m
System Cables			
ATC 900 Power Cord, GFCI	2996733PT	8.0	2.5
979 Motor to Controller	8405493	15.0	4.6
979 Motor to Wall Outlet	8405495	10.0	3.1
999 Motor to Controller	8405494	15.0	4.6
999 Motor to Wall Outlet	8405545	10.0	3.1

TEC 7000 Series Electronic Controller

TEC 7000 series electronic controller for use with hand-held rolling motors and trolley type units (with telescopic shaft).

TEC 7000 General Specifications

- **CE Certified design**
- **Microprocessor controlled tube expansion**
- **Memory storage up to 3000 cycles**
- **Operating language in English or German**
- **Statistics for Quality Assurance include; Min / Max value for the number of expansion cycles in memory can be shown on display or send to the serial printer port**
- **Programmable timers for; cycle start, reverse pause, end of cycle, and a suppress timer for low torque value settings.**
- **Programmable torque shut-off value and high / low torque limits**
- **Three cycle modes - manual, semi-automatic, and full automatic**

Model Number	Order Number	Input Voltage (1 phase)		Power Requirements (Watt)		Weight		Dimensions					
								Width		Height		Depth	
		VAC	Hz.	Input	Output	lbs.	kg.	in.	mm	in.	mm	in.	mm
Electronic Controller													
TEC 7000	941204	110-240	50/60	650	1700	25.7	11.7	13.4	340.0	6.7	170.0	16.5	420.0

Optional Equipment: TEC-9000 FS foot switch, order number 7940080

Model	Order Number	Speed	RPM	Tube Capacities OD*		Voltage	Power (Watt)		Chucks (in.)	
				in.	mm		Input	Output	Standard	Optional
Electric Rolling Motor Specifications										
TEC 72636	941312	1	1400	1/4 - 3/8	6.35 - 9.52	230	300	180	1/4 QC	
TEC 7113	941315	2	450-1550	5/8 - 1 1/4	15.88 - 31.75	110	650	450	3/8, 1/2 QC	
TEC 7213	941313	2	450-1550	5/8 - 1 1/4	15.88 - 31.75	230	650	450	3/8, 1/2 QC	
TEC 7132	941203	4	110-190	3/4 - 2 1/2	19.05 - 63.50	110	1500	980		MC 3 x 1/2 QC
			350-590						MC 3 x 3/8 QC	MC 3 x 1/2 SQ
TEC 7232	941202	4	110-190	3/4 - 2 1/2	19.05 - 63.50	230	1500	980	MC 3 x 3/8 QC	MC 3 x 1/2 SQ
			350-590							MC 3 x 3/4 SQ

* May vary due to tube wall, material and/or tube sheet thickness.

TEC 8000VS Series Electronic Controller

TEC 8000VS series electronic controller for use with trolley type units (with telescopic shaft)

TEC 8000VS General Specifications

- **CE Certified design**
- **Standard 1-phase operation 230V supply, optional 120V supply**
- **Universal controller for use with 3-phase motors or brushless servomotors**
- **Unique variable speed motor control**
- **Programming functionality the same as TEC 7000**
- **Custom solutions designed for TEC Controllers working with 3 ph - 42 Volt transformers used in multi-spindle systems, applications with robot and/or articulating arm tool holder systems, and more.**

Please contact your authorized Airetool distributor for details, system specifications, and recommendations.

Fixture Mounted Tube Rolling Systems—Electric Driven

Utilizing a microprocessor controlled expanding cycle with programmable expansion parameters including torque, speed, and time. This ensures a very accurate, uniform, and repeatable process. Expansion modules available for single or multiple spindles (up to 16) with fixed or adjustable pitch designs.

- **Fully programmable automatic expansion cycle**
- **View and/or export tube expansion results for data archive and QA analysis**
- **Through-cage lubricant-injection system increases the durability of the tooling (expanders)**
- **Robot or articulating arm mounting provides for an ergonomic solution and effortless productivity gains**

Dual Spindle Torque Control Tube Expansion Systems - Air Driven

Utilizing 720 series Airetool motors to achieve almost twice the production rate of a hand-held rolling motor. A “dual start” button activates both motors, while left-start/right-start buttons are used for independent single tube rolling.

- **Torque control tube rolling with automatic reverse**
- **Commonality of components with other rolling motors**

MADE IN THE USA