



# Inch and Metric Flanging Tooling for 1025 and 1050 Parflange Machines

Tube Size O.D. x Wall Thickness (in.)	Tooling for 90°/180° Tube Flanging			Available Flanging Tooling			
	Flange Pin and Die Set Part Number	Pin Part Number	Die Part Number	1040		1025	
				-S	-SS	-S	-SS
1/4 x .028	4004X028180	B4004X028180	M4004X028180	•	•	•	•
1/4 x .035	4004X035180	B4004X035180	M4004X035180	•	•	•	•
1/4 x .049	4004X049180	B4004X049180	M4004X049180	•	•	•	•
3/8 x .035	4006X035180	B4006X035180	M4006X035180	•	•	•	•
3/8 x .049	4006X049180	B4006X049180	M4006X049180	•	•	•	•
3/8 x .065	4006X065180	B4006X065180	M4006X065180	•	•	•	•
1/2 x .035	4008X035180	B4008X035180	M4008X035180	•	•	•	•
1/2 x .049	4008X049180	B4008X049180	M4008X049180	•	•	•	•
1/2 x .065	4008X065180	B4008X065180	M4008X065180	•	•	•	•
1/2 x .083	4008X083180	B4008X083180	M4008X083180	•	•	•	•
5/8 x .049	4010X049180	B4010X049180	M4010X049180	•	•	•	•
5/8 x .065	4010X065180	B4010X065180	M4010X065180	•	•	•	•
5/8 x .083	4010X083180	B4010X083180	M4010X083180	•	•	•	•
5/8 x .095	4010X095180	B4010X095180	M4010X095180	•	•	•	•
5/8 x .109	4010X109180	B4010X109180	M4010X109180	•	•	•	•
5/8 x .120	4010X120180	B4010X120180	M4010X120180	•	•	•	•
3/4 x .049	4012X049180	B4012X049180	M4012X049180	•	•	•	•
3/4 x .065	4012X065180	B4012X065180	M4012X065180	•	•	•	•
3/4 x .083	4012X083180	B4012X083180	M4012X083180	•	•	•	•
3/4 x .095	4012X095180	B4012X095180	M4012X095180	•	•	•	•
3/4 x .109	4012X109180	B4012X109180	M4012X109180	•	•	•	•
3/4 x .120	4012X120180	B4012X120180	M4012X120180	•	•	•	•
1 x .065	4016X065180	B4016X065180	M4016X065180	•	•	•	•
1 x .083	4016X083180	B4016X083180	M4016X083180	•	•	•	•
1 x .095	4016X095180	B4016X095180	M4016X095180	•	•	•	•
1 x .109	4016X109180	B4016X109180	M4016X109180	•	•	•	•
1 x .120	4016X120180	B4016X120180	M4016X120180	•	•	•	•
1 x .134	4016X134180	B4016X134180	M4016X134180	•	•	•	•
1 x .148	4016X148180	B4016X148180	M4016X148180	•	•	•	•
1 x .156	4016X156180	B4016X156180	M4016X156180	•	•	•	•
1 x .188	4016X188180	B4016X188180	M4016X188180	•	•	•	•
1 1/4 x .065	4020X065180	B4020X065180	M4020X065180	•	•	•	•
1 1/4 x .083	4020X083180	B4020X083180	M4020X083180	•	•	•	•
1 1/4 x .095	4020X095180	B4020X095180	M4020X095180	•	•	•	•
1 1/4 x .109	4020X109180	B4020X109180	M4020X109180	•	•	•	•
1 1/4 x .120	4020X120180	B4020X120180	M4020X120180	•	•	•	•
1 1/4 x .134	4020X134180	B4020X134180	M4020X134180	•	•	•	•
1 1/4 x .148	4020X148180	B4020X148180	M4020X148180	•	•	•	•
1 1/4 x .156	4020X156180	B4020X156180	M4020X156180	•	•	•	•
1 1/4 x .188	4020X188180	B4020X188180	M4020X188180	•	•	•	•
1 1/2 x .065	4024X065180	B4024X065180	M4024X065180	•	•	•	•
1 1/2 x .083	4024X083180	B4024X083180	M4024X083180	•	•	•	•
1 1/2 x .095	4024X095180	B4024X095180	M4024X095180	•	•	•	•
1 1/2 x .109	4024X109180	B4024X109180	M4024X109180	•	•	•	•
1 1/2 x .120	4024X120180	B4024X120180	M4024X120180	•	•	•	•
1 1/2 x .134	4024X134180	B4024X134180	M4024X134180	•	•	•	•
1 1/2 x .148	4024X148180	B4024X148180	M4024X148180	•	•	•	•
1 1/2 x .156	4024X156180	B4024X156180	M4024X156180	•	•	•	•
1 1/2 x .188	4024X188180	B4024X188180	M4024X188180	•	•	•	•
2 x .083	4032X083180	B4032X083180	M4032X083180	•	•	•	•
2 x .095	4032X095180	B4032X095180	M4032X095180	•	•	•	•
2 x .120	4032X120180	B4032X120180	M4032X120180	•	•	•	•

**Note:** Use “-SS” suffix after part number for flanging tools for stainless steel tube. [Contact the Tube Fittings Division](#) for sizes and/or materials not listed, or for additional SS sizes released for limited use.

**Table S5 — Pin & Die Part Numbers for Inch Sizes**

Tube Size O.D. x Wall Thickness (mm)	Tooling for 90°/180° Tube Flanging		Available Flanging Tooling			
	Pin Part Number	Die Part Number	1040		1025	
			-S	-SS	-S	-SS
6 x 1	B4018006X1M	M4018006X1M	•	•	•	•
6 x 1.5	B4018006X1.5M	M4018006X1.5M	•	•	•	•
8 x 1	B4018008X1M	M4018008X1M	•	•	•	•
8 x 1.5	B4018008X1.5M	M4018008X1.5M	•	•	•	•
10 x 1	B4018010X1M	M4018010X1M	•	•	•	•
10 x 1.5	B4018010X1.5M	M4018010X1.5M	•	•	•	•
10 x 2	B4018010X2M	M4018010X2M	•	•	•	•
12 x 1	B4018012X1M	M4018012X1M	•	•	•	•
12 x 1.5	B4018012X1.5M	M4018012X1.5M	•	•	•	•
12 x 2	B4018012X2M	M4018012X2M	•	•	•	•
15 x 1.5	B4018015X1.5M	M4018015X1.5M	•	•	•	•
15 x 2	B4018015X2M	M4018015X2M	•	•	•	•
16 x 1	B4018016X1M	M4018016X1M	•	•	•	•
16 x 1.5	B4018016X1.5M	M4018016X1.5M	•	•	•	•
16 x 2	B4018016X2M	M4018016X2M	•	•	•	•
16 x 2.5	B4018016X2.5M	M4018016X2.5M	•	•	•	•
18 x 1	B4018018X1M	M4018018X1M	•	•	•	•
18 x 1.5	B4018018X1.5M	M4018018X1.5M	•	•	•	•
18 x 2	B4018018X2M	M4018018X2M	•	•	•	•
20 x 2	B4018020X2M	M4018020X2M	•	•	•	•
20 x 2.5	B4018020X2.5M	M4018020X2.5M	•	•	•	•
20 x 3	B4018020X3M	M4018020X3M	•	•	•	•
22 x 1.5	B4018022X1.5M	M4018022X1.5M	•	•	•	•
22 x 2	B4018022X2M	M4018022X2M	•	•	•	•
22 x 2.5	B4018022X2.5M	M4018022X2.5M	•	•	•	•
22 x 3	B4018022X3M	M4018022X3M	•	•	•	•
25 x 2	B4018025X2M	M4018025X2M	•	•	•	•
25 x 2.5	B4018025X2.5M	M4018025X2.5M	•	•	•	•
25 x 3	B4018025X3M	M4018025X3M	•	•	•	•
25 x 3.5	B4018025X3.5M	M4018025X3.5M	•	•	•	•
25 x 4	B4018025X4M	M4018025X4M	•	•	•	•
28 x 2	B4018028X2M	M4018028X2M	•	•	•	•
28 x 2.5	B4018028X2.5M	M4018028X2.5M	•	•	•	•
30 x 2	B4018030X2M	M4018030X2M	•	•	•	•
30 x 3	B4018030X3M	M4018030X3M	•	•	•	•
30 x 3.5	B4018030X3.5M	M4018030X3.5M	•	•	•	•
30 x 4	B4018030X4M	M4018030X4M	•	•	•	•
32 x 3	B4018032X3M	M4018032X3M	•	•	•	•
32 x 4	B4018032X4M	M4018032X4M	•	•	•	•
35 x 3	B4018035X3M	M4018035X3M	•	•	•	•
38 x 3	B4018038X3M	M4018038X3M	•	•	•	•
38 x 4	B4018038X4M	M4018038X4M	•	•	•	•
38 x 5	B4018038X5M	M4018038X5M	•	•	•	•

1) Flanging tools (90°/180°) listed are for carbon steel tube. [Contact the Tube Fittings Division](#) for metric flanging tools for tube materials other than carbon steel or for sizes not listed.

**Table S6 — Pin & Die Part Numbers for Metric Sizes**

Dimensions and pressures for reference only, subject to change.