

# INSTRUCTIONS

910-89528

## FLARING TOOL

1. Before flaring, be sure that tubing is cut off squarely and burrs are removed from tubing.

**CAUTION:** When flaring stainless steel tubing, it is imperative that additional steps be performed to assure a sound flare and reduce damage to the flaring tool.

- 1a. Using a drill and standard countersink tool, bevel the inside diameter of the tubing to a depth equal to half of the wall thickness of the tubing (this reduces the chance for the sharp edge of the tubing to gouge the flaring cone). Apply a dab of extreme pressure grease to the flaring cone to prevent galling.
2. Slip appropriate flare nut onto tubing prior to flaring.
3. Loosen clamping screw used for locking the sliding block segments in the die holder. (See fig.1)
4. Insert tubing between the segments of the die block that correspond to the size of tubing to be flared. **THE TOOL IS DESIGNED TO BE SELF GAUGING.** The proper flare is produced when the tubing is clamped flush with top of die block. (See fig. 2)
5. Advance the clamp screw against the end segment and tighten firmly. (See fig. 3)
6. Move the flaring yoke down over the top of the die holder, position directly over the end of tube, and turn clockwise to lock into position on die holder.
7. Turn feed screw down firmly to form flare. Continue until increased resistance is felt. This indicates that an accurate flare has been completed. (See fig. 4)
8. Occasionally oil the screw and flaring cone.

**NOTE:** While this tool has proven to be durable for producing hundreds of flares on mild and stainless steel tubing, continuous use on hardened steel tubing will reduce the life expectancy of the tool. Production quality roll-flare tooling is available from most aviation tool supply sources with prices starting in the \$300 to \$500 range.

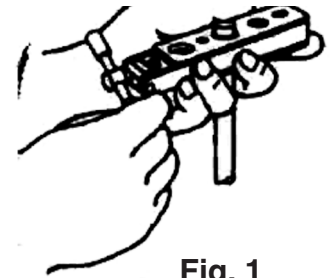


Fig. 1



Fig. 2

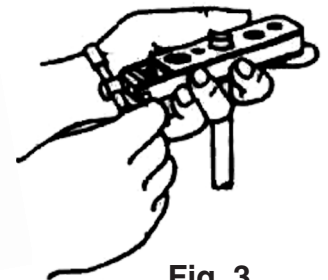


Fig. 3

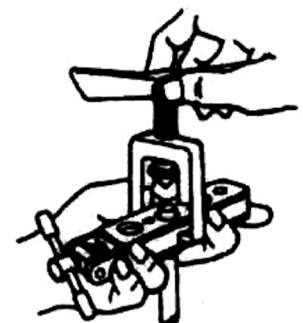


Fig. 4

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