

INSTRUCTIONS

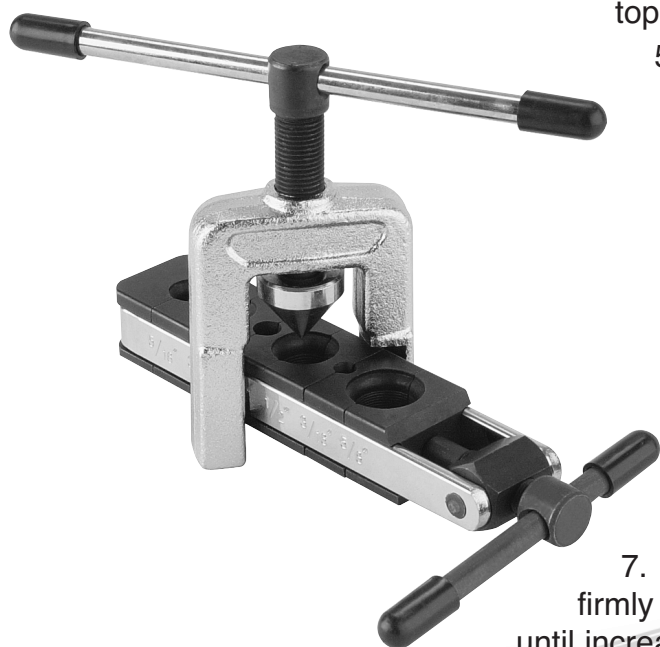
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STANDARD FLARING TOOL

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

NOTE: This tool is designed to flare soft brass, copper, aluminum, and mild steel tubing. Use on hardened or stainless steel tubing may result in deformed flares or excessive wear to tool.

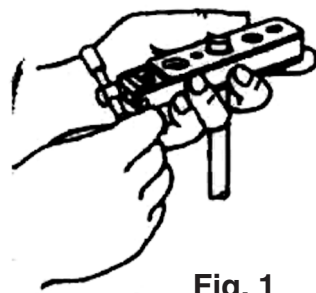


Fig. 1



Fig. 2

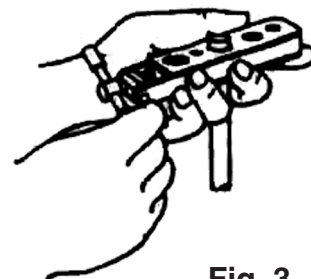


Fig. 3

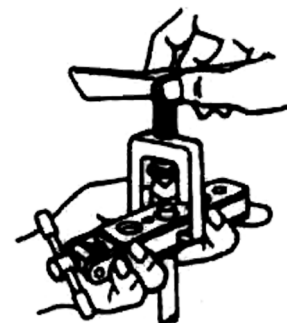


Fig. 4

IMPORTANT

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