



## Double Flare Tool

### INSTRUCTIONS

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- 1 - Flaring Bar
- 1 - Yoke with anvil
- 5 - Flaring dies: 3/16", 1/4", 5/16" 3/8", 1/2"

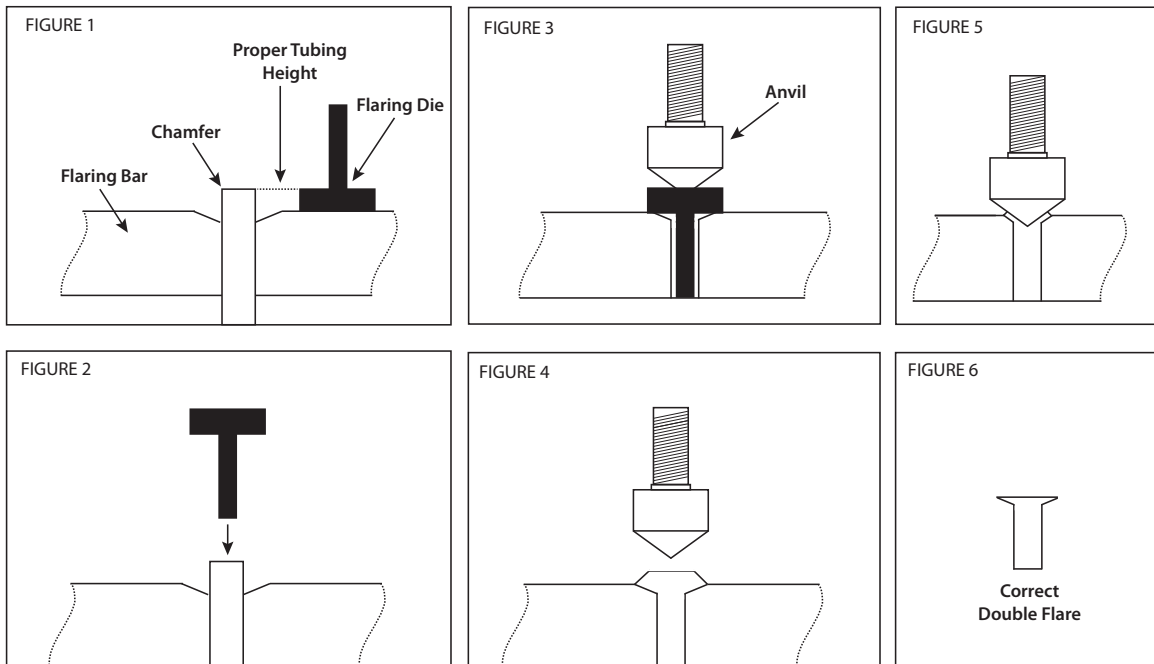
#### Instructions

This tool is designed to double flare thin wall steel, aluminum and .040 wall soft copper tubing.

1. End of tubing must be cut square (Use ALL11010 or ALL11011 Tubing Cutter)
2. Deburr inside of tubing, and chamfer outside.
3. Place tubing in correct hole with proper length exposed on beveled side of flaring bar as shown in (Figure 1).
4. Tighten flaring bar firmly starting with nut closest to tubing. Make certain tubing will not slip.
5. Fit Flaring Die into tubing (Figure 2). This may be difficult if tubing is not deburred.
6. Place anvil over Flaring Die and turn down until Die contacts flaring bar. (Figure 3).
7. Remove Flaring Die. End of tubing should be bell shaped (Figure 4).
8. Place anvil over bar and turn anvil down until tubing folds in on itself (Figure 5).
9. Remove tool and tubing should look like (Figure 6).



TIP: Lubricate yoke mandrel threads and flaring die with a light oil.



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