



37 Degree Flare Tool

INSTRUCTIONS

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- 1 - Flaring Bar
- 1 - Yoke with anvil

Instructions

This tool is designed to flare soft copper, aluminum and brass tubing. Not intended for flaring of steel or stainless steel tubing.

1. End of tubing must be cut square.(Use ALL11010 or ALL11011 Tubing Cutter)
2. Deburr inside of tubing (Use ALL11036).
3. Slip the flare nut onto tubing.
4. Oil threads and cone with a light lubricant such as WD-40 before each use especially when flaring aluminum.
5. Loosen die clamp screw to allow separation of the sliding flaring segments. See (Figure1).
6. Tool is self-gauging. The proper size flare is achieved when tubing is clamped flush with the top of the die block. See (Figure2). Insert tubing between the segments of the die block which correspond to the size of tubing being flared.
7. Firmly tighten the die clamp screw against the end segment. See (Figure3).
8. Position the yoke over the top of the die holder and twist clockwise to lock in position. The yoke should be positioned directly over the top of the tube. See (Figure4).
9. Turn the yoke screw clockwise until contact is made between the anvil and tube. Continue turning the yoke screw down just until slight resistance occurs. This indicates an accurate flare has been achieved. **IMPORTANT:** To maintain strength of the flare, do not force the anvil beyond this point.

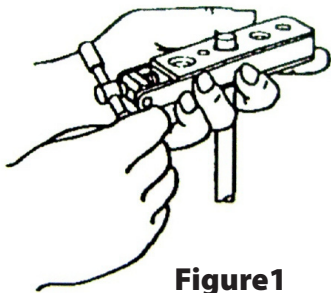


Figure1

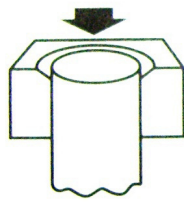


Figure2

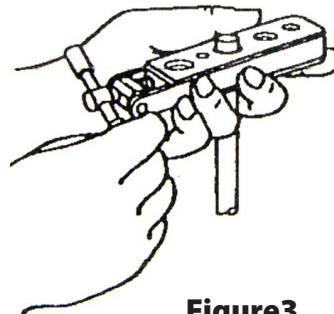


Figure3

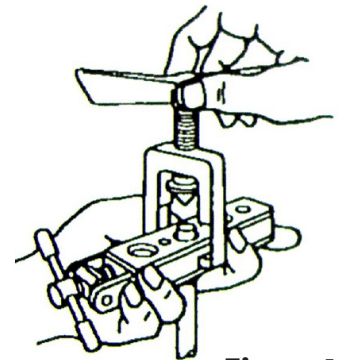


Figure4

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