



# Punch And Flare Tool

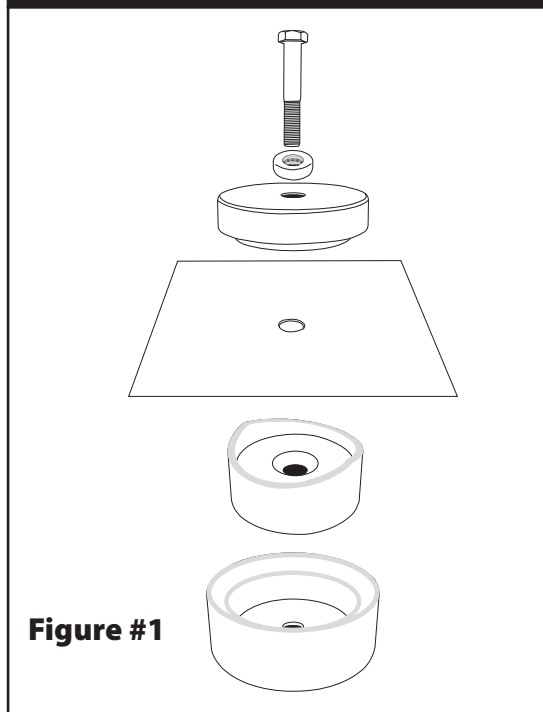
## INSTRUCTIONS

Note: This tool will cut a hole in up to 20 gauge (.0359") steel or 18 gauge (.0403") aluminum. Hole size is increased about 1/8" when hole is flared.

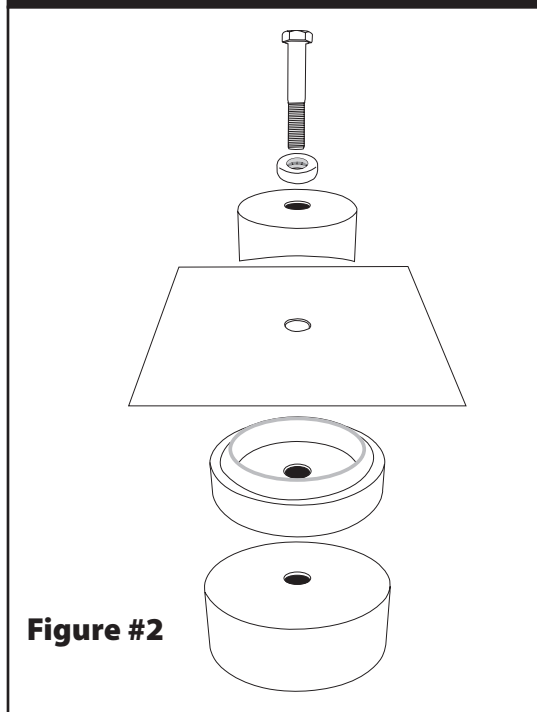
Begin by locating and marking the center point of desired hole location. Drill a 1/2" pilot hole in panel on the center point mark, the 1/2" hole is a guide for the punch tool. ALL11040 Step Drill Set is recommended as this will not distort the metal when drilling and will provide a clean chamfered hole. Apply lubricant, such as WD-40, to the bolt, bearing and surface of the panel to ease the cutting and flaring process. The scrap piece cut from the panel can be removed from the tool with a punch or similar item.

**Tech Tip:** If panel has a protective plastic covering, leave attached until punch and flare process is complete to help prevent damage to material finish.

**Diagram For Punching And Flaring A Hole (At The Same Time)**



**Diagram For Punching Hole Only**



Note: Only tighten the mandrel bolt until panel is cut. Further tightening of the mandrel bolt will damage the dies.

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