

INSTRUCTIONS FOR 37° HEAVY-DUTY FLARING TOOL

- Forms 37° flares in annealed stainless steel (MIL-T-6345 or AMS5566), cold drawn stainless steel and annealed copper or aluminum tubing.
- Ball thrust bearing mechanism reduces effort required.
- Hardened tool steel die features non-slip tubing grip, even after repetitive flaring.
- Extended bar for clamping in vise.

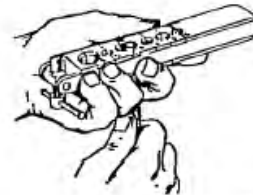


Fig. 1

1. Before flaring, be sure that tubing is cut off squarely, and deburred thoroughly.
2. Slip the flare nut onto the tubing.
3. **IMPORTANT:** Oil threads and cone before each use - especially when flaring aluminum. Use a 50/50, kerosene / oil mixture for aluminum.
4. Loosen clamping screw, which is used to lock the sliding segments in the die holder. This will permit their separation. (See Fig. 1)

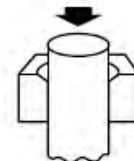


Fig. 2

5. Insert tubing between the segments of the die block that correspond to the size of the tubing to be flared. Allow tubing to protrude approximately 1/8" above die blocks before clamping. (See Fig. 2)
6. Advance the clamp screw against the end segment and tighten firmly. (See Fig. 3)
7. Slide the yoke over the end of the die holder and into position over the tubing to be flared. Note that the yoke slides directly over holder without twisting or turning. (See Fig. 4)
8. Turn the feed screw clockwise, until contact with tubing is made. Then turn the feed screw down until slight resistance is felt. This indicates an accurate flare has been completed.

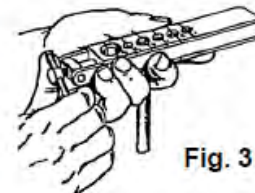


Fig. 3

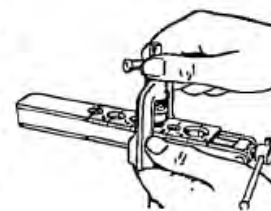


Fig. 4

IMPORTANT: To maintain maximum strength in the flare, do not force spreader cone beyond this point.

⚠ **Warning!** Always wear approved eye protection. Tip of flaring tool is sharp. Broken materials may fly.

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