

SAFETY INSTRUCTIONS:

- Do not attempt to flare out of round or unevenly cut tube ends.
- Tubing to be flared must have square cut ends and for best results the tubing ends should be cleanly deburred on the inside and outside diameters.
- Failure to observe tube preparation will result in unsatisfactory flares which could lead to brake failure.
- It is advisable to practice making several flares with the tool until a satisfactory quality can be achieved.

OPERATING INSTRUCTIONS:

Step 1. Turn the screw handle counter-clockwise to raise the flare cone.

Step 2. With the Grip Handles fully opened, rotate the two Clamping Blocks until the desired tube grip size appears centrally below the Flare Cone.

Step 3. Insert the prepared tube through the bottom of the tool, between the Clamp openings.

TO FORM A FEMALE FLARE (not normally used on brake lines)

Step 4. The tube should just protrude through the upper face of the Clamp Block by approximately 1 mm.

TO FORM A MALE FLARE

Step 5. Select the appropriate notch on the edge of the Former Bar which corresponds to the Tube size being flared. Lay the Former Bar on edge across the opening above the Clamp Blocks with the selected Notch above the tube. Push the tube through the clamp jaws to just touch the appropriate Notch on the Former Bar.

Step 6. Close the Grip Locking Handles fully to clamp the tube firmly in the tool. It is advisable to smear the tube end lightly with red Grease to prevent the Former or Flare Cone from sticking in the pipe.

Step 7. Push the appropriate Male Flare Former into the tube end. (If it does not fit easily, check the pipe end is properly deburred).

Step 8. Swing the Screw assembly round until it is fully engaged on to the Retaining post. The Flare Cone should now be in position directly above the hollow face of the Male Flare Former.

Step 9. Turn the Screw assembly clockwise to force the Flare Cone down until stiff resistance is felt. The correct amount of pressure to apply will soon be learnt though generally you should stop compressing as soon as resistance increases.

TO MAKE A DOUBLE FLARE

Step 10. Follow instructions for the Male Flare, without removing the pipe from the tool. Remove the Male Former and repeat Step 9 (above) thus pushing the Male Flare inside out.

NOTE: It is better to slightly under flare the tube permitting the tube fitting to complete the final forming and seating of the joint during assembly.

ADJUSTMENT INSTRUCTIONS:

This tool is factory set to grip .025/.035 wall copper tubing. As the compression of different metals and wall thicknesses vary the clamping pressure of the tool is adjustable. Should you encounter tubing that will not permit the Clamp Locking Handles to fully close you should make the following adjustment.

1. Use 1/2" AF spanner to loosen Adjusting Nut.
2. Use 5/8" AF spanner to turn the eccentric Adjusting Bolt (found beneath tool at opposite end of Adjusting Nut) until desired gripping pressure is obtained.
3. Re-tighten Adjusting Nut lightly to secure the adjustment.

