

## **Double Flare Tool**

## **INSTRUCTIONS**

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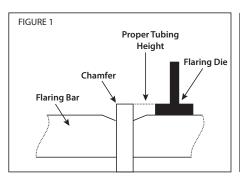
- 1 Flaring Bar
- 1 Yoke with anvil
- 5 Flaring dies: 3/16", 1/4", 5/16" 3/8", 1/2"

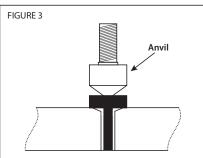
## **Instructions**

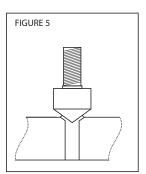
This tool is designed to double flare thin wall steel, aluminum and .040 wall soft copper tubing.

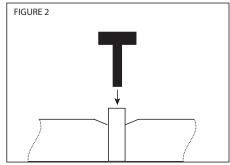
- 1. End of tubing must be cut square (Use ALL11010 or ALL11011 Tubing Cutter)
- 2. Deburr inside of tubing, and chamfer outside.
- 3. Place tubing in correct hole with proper length exposed on beveled side of flaring bar as shown in (Figure 1).
- 4. Tighten flaring bar firmly starting with nut closest 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).
- $8. \quad \text{Place anvil over bar and turn anvil down until tubing folds in on itself (Figure 5)}.$
- 9. Remove tool and tubing should look like (Figure 6).

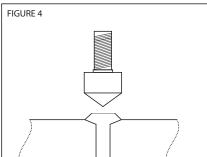
TIP: Lubricate yoke mandrel threads and flaring die with a light oil.

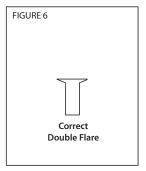












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