



3/16 Inch Brake Line Flaring Tool

038ERL



PARTS BREAKDOWN

Item	Description
1.	Flaring Tool
2.	Locking Screws (x2)
3.	Removable Handle
4.	Positioning Bolt
5.	OP1 Punch
6.	OP2 Punch
7.	Die Lubricant

TOOL SETUP & TUBING PREPARATION

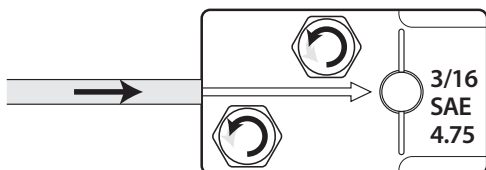
Always prepare tubing prior to flaring. Failure to do so will result in poorly formed flares.

- Tubing edge should have a clean straight cut and be free of corrosion. If necessary, use a tubing cutter to cut a straight edge.
- Deburr edges using a reamer, file, or a knife blade.
- Ensure proper fitting has been placed on tubing prior to flaring the end.
- For on car use, leave handle connected. If using in bench vise, remove handle and clamp bottom half of tool into vise.

OPERATING INSTRUCTIONS

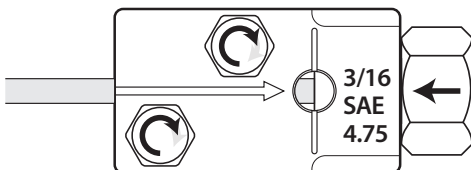
- Loosen the (2) locking screws.
- Insert tubing through the small opening of the flaring tool. Tighten locking screws slightly. Tubing should still move back and forth when pulled. **FIG A.**

FIG A.



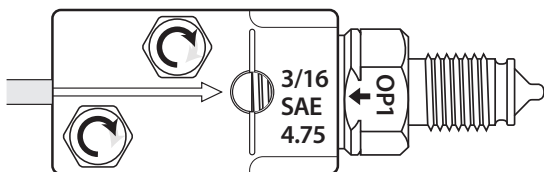
- Insert positioning bolt into the large threaded opening of the flaring tool.
- Slide tubing into flare tool until end is flat against the positioning screw. Tighten locking screws fully to clamp tubing in place. **FIG B.**

FIG B.



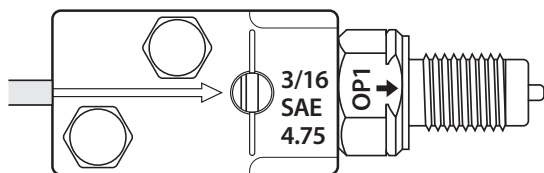
- Remove the positioning bolt. Lubricate the OP1 end of punch and insert into the large threaded end of the flare tool. Tighten down with wrench until hexagon of punch is flat against tool. **FIG C.**

FIG C.



- Remove the OP1 punch. Lubricate the OP2 end of punch and insert into the large threaded end of the flare tool. Tighten down with wrench until hexagon of punch is flat against tool. **FIG D.**

FIG D.



- Remove punch from flare tool. Loosen or remove the locking screws from tool. The tubing now has a completed double flare.