



# Hydraulic Flaring Tool Kit

## User's Manual

KTI-70082



### DO NOT DISCARD

You will need the manual for the safety warnings and precautions, operating instructions and maintenance procedures. Keep your invoice with this manual in a safe, dry location for future reference.



## WARNING!

**READ AND UNDERSTAND ALL INSTRUCTIONS BEFORE USE.**

Failure to follow all instructions listed below may result in electric shock, fire and/or serious injury.

## WARNINGS

- Read and understand all warning labels and operating instructions prior to use. If any portion of this material is unclear, contact a representative for clarification.
- It is your responsibility to keep all warning labels and instruction literature legible and intact. Replacement labels and literature are available from the factory.
- Never allow unskilled or improperly trained personnel to operate this equipment.
- Always wear appropriate protective eye wear.
- Always wear gloves during operation to avoid cuts from sharp metal edges.
- Keep work area clean and well lit.
- Inspect the tool thoroughly before use. Check for misaligned or binding of moving parts, breakage of parts and any other condition that may affect the tool's operation. **DO NOT** use if damaged. Check to ensure that all applicable parts are intact and firmly tightened.
- **DO NOT** operate when you are tired or under the influence of alcohol, drugs or any intoxicating medication.
- Use only accessories that are recommended by the manufacturer for this model.
- **DO NOT** make any modifications to this tool.
- **DO NOT** expose to inclement weather
- Only use the tool on properly secured materials and stable work surfaces.
- If the angle grinder requires repairs or replacement parts, have it repaired by an authorized technician and only use the replacement parts supplied by the manufacturer.
- Failure to heed these warnings may result in personal injury and/or property damage.

## TUBE PREPARATION

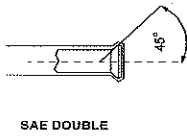
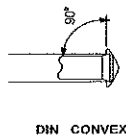
1. Use a tubing cutter to square cut the end of the tube
2. Chamfer the outside of the tube and ream the inside of the tube to remove all burrs. Clear any metal chips or other debris from inside tubing.
3. Thoroughly clean outside of tube before inserting flare forming die
4. If the tube is plastic-covered, remove approximately 1/8" (3mm) from the end of the tube to be flared. Do not use abrasive cloth. Remove any debris from tube.
5. Using an anti-seize compound, *lightly* lubricate then end of the cut tube.
6. Place appropriate fittings over ends of tubing, with flare end facing outward.

## TUBE & DIE SELECTION CHART

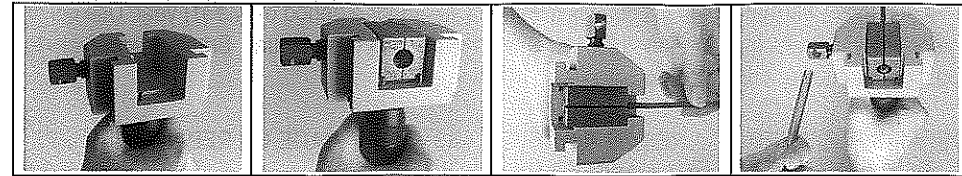
TUBE DIAMETER	OP.1 PUNCH	OP.2 PUNCH	DIE SET
4.75MM	4.75MM	3/16"-1/4"	4.75-3/16"
6MM	6MM	SAME ABOVE	SAME ABOVE
1/4"	1/4"	SAME ABOVE	6MM
		1/4"	1/4"

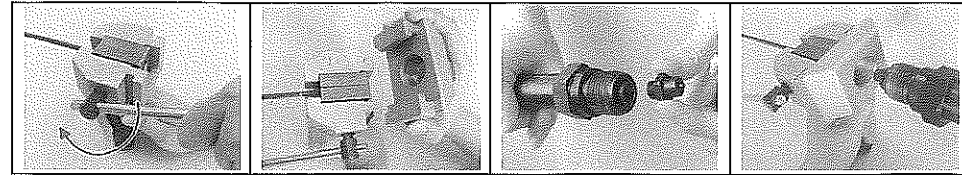
TUBE DIAMETER	OP.1 PUNCH	OP.2 PUNCH	DIE SET
3/16"	4.75-3/16"	3/16"-1/4"	4.75-3/16"
4.75MM	SAME ABOVE	SAME ABOVE	SAME ABOVE
6MM	6MM	SAME ABOVE	6MM
1/4"	1/4"	SAME ABOVE	1/4"



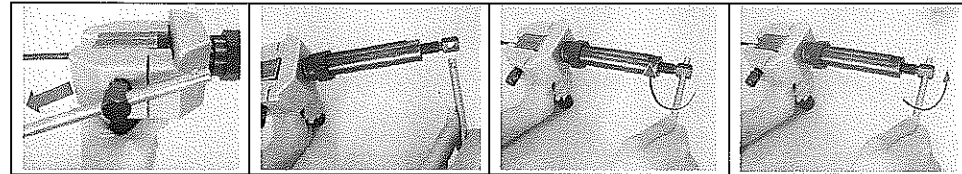
## OPERATING INSTRUCTIONS



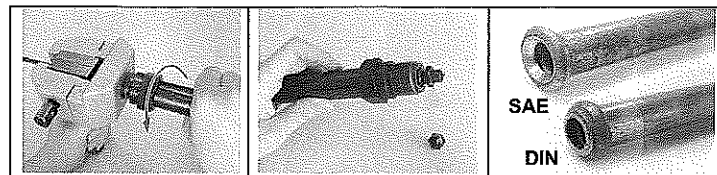
1. Take out body
2. Choose appropriate die size to put on square offset base. Please note: same instruction to make SAE & DIN
3. Put pipe into die from back side, align pipe with die. Please note: Deburr pipe edge before placing into die.
4. Put handle through hexagon screw. (Insert from steel ball end)



5. Tighten hexagon screw to force die by turning handle clockwise
6. Place square offset base side cover clip onto body after forcing die
7. Choose appropriate adapter & screw (OP.1) onto hydraulic handle. Please note: Adapter of DIN will have hexagon hook slot
8. Place hydraulic handle into connect hole on the square offset base



9. Take out handle on hexagon screw. (Insert from steel ball end)
10. Place handle through hydraulic handle
11. Twist clockwise until very tight
12. Release handle by turning counterclockwise



13. Turn hydraulic handle counterclockwise to release it from square offset base. Please note: DIN will be finished at this step
14. Change adapter OP.1 to OP.2 & repeat operating steps 8-13 to finish bubble flare
15. SAE & DIN DEMO