



# Instructions for Double Flaring

Thin wall steel tubing, aluminum or .040 wall soft copper.

1. Carefully prepare end of tubing by making sure tubing is cut off square.
2. Deburr inside with reamer blade of a tube cutter.
3. Chamfer outside with a file or grinding wheel.
4. This preparation is necessary to obtain correct forming.
5. Insert tubing through correct size hole.
6. Extend tubing beyond surface of bar assembly to proper distance as determined by placing corresponding size adapter flat surface down alongside tubing, so end of tubing contacts shoulder of adapter as shown in Figure 1.
7. Tighten nuts with a 1/2" wrench or socket, starting with the nut nearest the tubing. Be sure bar assembly holds tubing tight so that it will not slip.
8. Insert adapter stem into end of tubing. Place yoke assembly over bar assembly and adapter, so that cone enters depression in end of adapter.
9. With 1/2" wrench or socket, turn and force cone down until adapter rests flat against bar assembly as shown in Figure 2.
10. The end of the tubing is now formed into a bell shape. This completes the forming operation.
11. Back off cone and remove adapter from tubing. Now turn cone against bell shape of tubing so that metal folds in on itself as shown in Figure 3.
12. This operation is the same as a conventional single flare.

