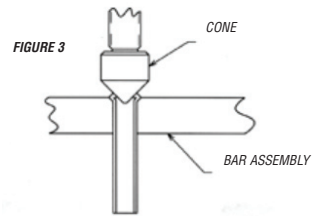
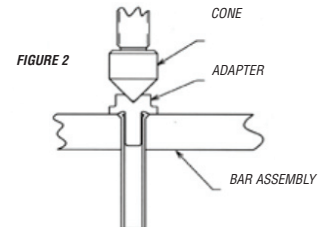
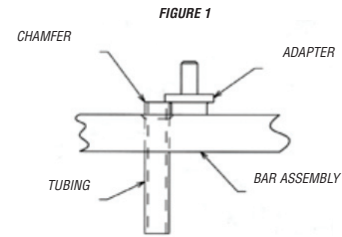


Instructions for Double Flaring

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 of tube.
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 bolts with a 1/2" wrench or socket, starting with the bolt 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.



Instructions for I.S.O. Flaring

1. Carefully prepare end of tubing by making sure tubing is cut off square.
2. Using countersink tool, chamfer inside of tubing until chamfer is approximately halfway thru tube wall thickness - Figure 1.
3. Insert tubing through correct size hole. The tube should protrude above the side that is stamped ISO only. Do not try to form an ISO flare on the side with chamfers! Extend tubing beyond surface of bar assembly to notch of wrench - Figure 2.
4. Tighten bolts with a 1/2" wrench or socket, starting with the bolt nearest the tubing. Be sure bar assembly holds tubing tight so it will not slip.
5. Install proper adapter into threaded hole of pusher screw. Place yoke assembly over bar assembly so that nose of adapter enters tubing.
6. With 1/2" wrench or socket, turn and force pusher screw down until adapter rests flat against bar assembly as shown in Figure 3.
7. Back off the pusher screw and remove the yoke assembly. Remove tubing from bar assembly. ISO flare should look like Figure 4.

Figure 1

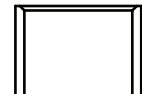


Figure 2

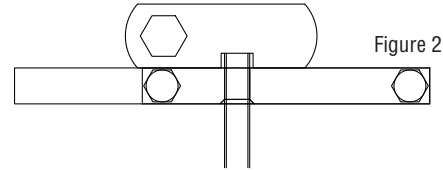


Figure 3

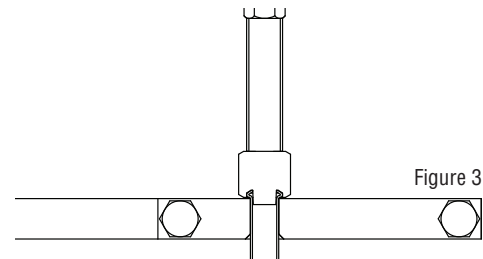


Figure 4

