

OPERATING INSTRUCTIONS

PUSH CONNECT, GM FUEL LINE FLARING, 45° DOUBLE FLARING, METRIC BUBBLE FLARING, GM TRANSMISSION COOLING LINE*



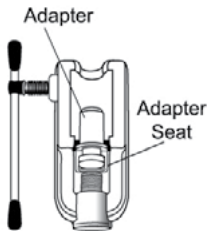
WARNING! Wear safety goggles when using this tool.

PRE-OPERATION SET-UP

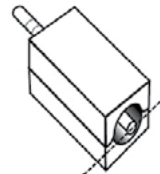
- Open the relief valve to fully recess the piston, then close tightly.
- Rotate the yoke fully counter-clockwise to bottom out the adapter seat.

PUSH CONNECT, GM FUEL LINE FLARING, GM TRANSMISSION COOLING LINE INSTRUCTIONS

- 1) Rotate the yoke fully counter-clockwise. Place the adapter onto the adapter seat on the end of the piston.

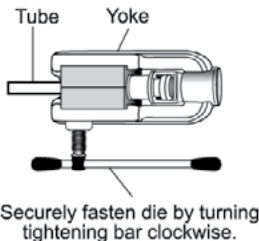


- 2) Insert the tube between the dies so it is even with the edge as shown.

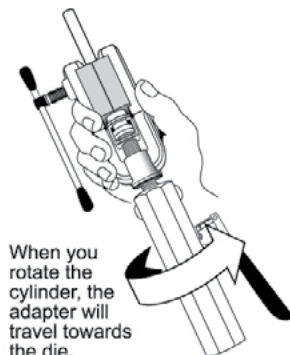


Tube should be even with die as shown.

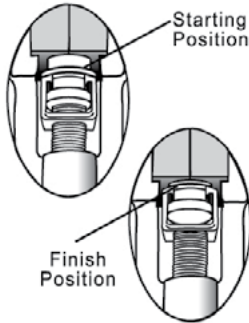
- 3) Insert dies and tubing into the yoke using the stabilizing lever. Make sure die and tube are level prior to tightening. **(important to securely fasten before moving on to step #4)**



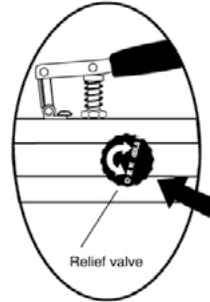
- 4) Grasp the yoke and rotate the hydraulic cylinder clockwise until it stops. (The adapter should engage the die.)



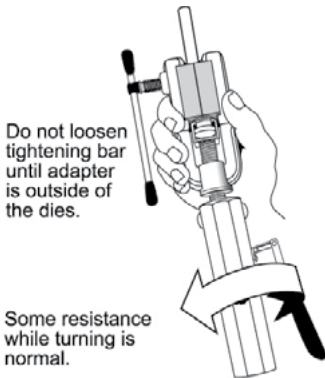
- 5) Begin squeezing the lever and continue until the edge of the adapter meets the die or pumping action shows substantial resistance.



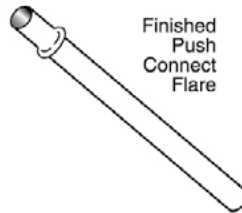
- 6) Release the pressure by opening the relief valve.



- 7) Grasp the yoke and rotate the tool counter-clockwise to remove the adapter from the die.

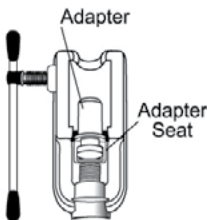


- 8) Loosen the tightening bar and remove the tube. It should look something like the sketch below.



45° DOUBLE FLARING AND METRIC BUBBLE FLARING INSTRUCTIONS

- 1) Rotate the yoke fully counter-clockwise. Place the MALE adapter onto the adapter seat on the end of the piston.

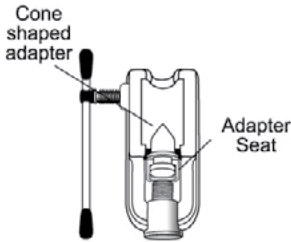


***Remember to use the correct die set.**

- 2) Follow steps 2-7 of push connect flaring instructions.

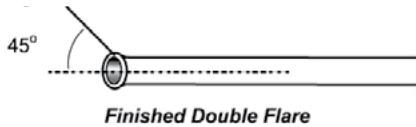
If forming 45° double flares continue to step 3. If forming metric bubble flare, loosen "T" handle and remove die blocks and tube.

3) Remove the male adapter and insert the cone shaped adapter onto the adapter seat.



4) Follow steps 4-7 of push connect flaring instructions.

5) Loosen the tightening bar and remove tube. It should look something like the sketch below.



TROUBLESHOOTING

The piston does not seem to advance when the level is pushed.

- Close the relief valve.
- The hydraulic fluid is too cold. Close the relief valve and pump the lever several times to warm the oil.

The push connect flare does not seem to be formed correctly.

- After the tubing is positioned in the tool the yoke must be rotated into the die before one begins to squeeze the lever.
- The tightening bar must be very tight.

The tubing is stuck inside the adapter.

- After flaring, you must rotate the yoke counter-clockwise to pull the adapter out of the tubing. This must be done prior to releasing the tightening bar and attempting to remove the tubing.

REPLACEMENT PARTS

Part #	Description	Part #	Description
71202	Hydra-Flare Assembly	71097-01	45° Flaring Cone
72485-PB	Plastic Box for 72475		
Push Connect Adapter Die Sets			
71205	5/16" Push Connect Adapter	71215	5/16" Push Connect Die Set
71206	3/8" Push Connect Adapter	71216	3/8" Push Connect Die Set
71204	1/4" Push Connect Adapter	71214	1/4" Push Connect Die Set
45° & Double Flaring Adapter Die Sets			
71097-01	45° Cone		
71097-03	3/16" Double Flare Adapter	71097-13	3/16" Double Flare Die Set
71097-04	1/4" Double Flare Adapter	71097-14	1/4" Double Flare Die Set
71097-05	5/16" Double Flare Adapter	71097-15	5/16" Double Flare Die Set
71097-06	3/8" Double Flare Adapter	71097-16	3/8" Double Flare Die Set
71097-08	1/2" Double Flare Adapter	71097-18	1/2" Double Flare Die Set
GM Fuel Line Adapter Die Sets			
71405	5/16" Adapter	71415	5/16" Die Set
71406	3/8" Adapter	71416	3/8" Die Set
Metric Bubble Flaring Adapter Die Sets			
71475-4M	4.75 mm Adapter	71475-14M	4.75 mm Die Set
71475-6M	6 mm Adapter	71475-16M	6 mm Die Set
71475-8M	8 mm Adapter	71475-18M	8 mm Die Set
71475-10M	10 mm Adapter	71475-110M	10 mm Die Set
GM Transmission Cooling Line Adapter Die Sets			
71099-06	3/8" Adapter	71099-16	3/8" Die Set
71099-08	1/2" Adapter	71099-18	1/2" Die Set

*Please note these instructions cover all dies and adapters available.
Your model may not include all of the dies and adapters listed.

WARNING: This product contains one or more chemicals known to the State of California to cause cancer, birth defects or other reproductive harm.

Learn more about other hand tools by Mastercool on our website.